



Highly Styled, Low Cost Serpentine Drive

Installation Instructions

Chevy Big Block (Style Track)

#21200 (without Power Steering)

#21250 (with Remote Power Steering)

#21255 (with Saginaw Power Steering)



Parts List

Main Front Bracket Kit P/N 21201

- 1 - 21201-A.....Main Front bracket body (Style Track)
- 1 - 21261-A.....Main Front bracket body (Revolver)
- 4 - S248 $\frac{3}{8}$ - 16 x 1" SHCS
- 4 - S339 $\frac{3}{8}$ - 16 x 3" Threaded Stud
- 1 - S550M8 - 1.25 x 20mm SHCS
- 2 - S553M8 - 1.25 x 35mm SHCS
- 4 - S7853.000" Threaded Spacer Stainless
- 2 - MM100.....Alum Bolt Cap

Alt Rear Support Bracket P/N 21202

- 1 - 21202-A.....Alt Support Bracket Body
- 1 - S277 $\frac{3}{8}$ - 16 x $4\frac{3}{4}$ " SHCS
- 1 - S452 $\frac{5}{8}$ " Threaded Bushing
- 2 - S676Paper Water Pump Gaskets
- 1 - A3-1.250.....Alum Spacer $1\frac{1}{4}$ " Lg

A/C Rear Support Bracket P/N 21203

- 1 - 21203-A.....A/C Support Bracket Body
- 1 - S150 $\frac{5}{16}$ - 18 x $1\frac{1}{2}$ " SHCS
- 2 - S676Paper Water Pump Gaskets
- 1 - TP3-.300..... $\frac{3}{8}$ " ID x .300 Lg Spacer

Power Steering Bracket P/N 21204

(For Kit # 21250 with Saginaw Pump)

- 1 - 21204-A.....Power Steering Bracket Body
- 2 - S260 $\frac{3}{8}$ - 18 x $2\frac{1}{4}$ " SHCS
- 2 - S356 $\frac{7}{16}$ - 14 x $2\frac{1}{4}$ " SHCS
- 2 - S556M8 - 1.25 x 40mm SHCS

Power Steering Bracket P/N 21205

(For Kit # 21255 with Saginaw Pump)

- 1 - 21205-A.....P/S Front Plate
- 1 - 21205-BP/S Rear Plate
- 1 - 20115-C.....Spacer Block
- 2 - S311 $\frac{3}{8}$ - 16 x $\frac{3}{4}$ " Hex Head Bolts
- 1 - S312 $\frac{3}{8}$ - 16 x 1" Hex Head Bolts
- 1 - TP3-.150..... $\frac{3}{8}$ " ID x .150 Spacer
- 2 - S364 $\frac{7}{16}$ - 14 x $3\frac{1}{2}$ " SHCS

Belt Tensioner Tool P/N 21206

- 1 - MM101.....Right Hand Rod End
- 1 - MM102.....Left Hand Rod End
- 1 - MM105.....13" Threaded Rod

Chevy BB Pulley Kit P/N 7660-206

- 1 - 7666-A.....Crank Pulley body
- 1 - 6302-A.....Water pump Pulley Body
- 1 - 206-A.....Alternator Pulley Body
- 1 - 306-A.....Alternator Pulley Cap Body
- 1 - 221-A.....Alternator Fan
- 1 - 394-A.....A/C Cover Body
- 3 - S028 $\frac{8}{32}$ x 1" SHCS
- 3 - S520 M6 - 1.0 x 16mm Button Head Bolts
- 4 - S186 $\frac{5}{16}$ - 24 x $\frac{7}{8}$ " SHCS
- 3 - S248 $\frac{3}{8}$ - 16 x 1" SHCS
- 1 - S685 $\frac{11}{16}$ " Lock Washer
- 1 - S716Water Pump Bushing
 $\frac{3}{4}$ " OD x $\frac{5}{8}$ " ID x $\frac{3}{16}$ " Long
- 1 - 618-A.....P/S Pulley (Press Fit)
(For Kit # 21250)
- 1 - 535-A.....P/S Pulley (Keyed)
(For Kit # 21255)
- 1 - 302-A.....P/S Pulley Nose Cover
- 3 - S022 $\frac{8}{32}$ x $\frac{3}{8}$ " SHCS

Accessories

- 1 - P125.....BB Chevy Alum Water Pump
Rev. Rotation
- 1 - P412.....Sanden A/C Compressor (chrome)
- 1 - P417.....A/C Line Kit
- 1 - P572.....Alum Alternator (chrome)
- 1 - P315.....Remote P/S Pump
(For Kit # 21250)
- 1 - P304.....Remote P/S Pump
(For Kit # 21255)

Required Tools and Materials

- RTV Silicone
- Loc-Tite® Thread Locker
- Anti-seize Compound
- Gasket Scraper, Steel Wool or Sandpaper to clean gasket surfaces
- $\frac{3}{16}$ " Allen Head Driver
- $\frac{5}{16}$ " Allen Head Driver
- $\frac{1}{4}$ " Allen Head Driver
- 6mm Allen Head Driver
- $\frac{5}{8}$ " Combo Wrench

- $\frac{9}{16}$ " Combo Wrench
- $\frac{11}{16}$ " Combo Wrench
- $\frac{3}{4}$ " Combo Wrench
- Socket Wrench & Extension
- 10mm 12pt. socket
- 12mm 12pt. socket

Serpentine Belt

- 65" for Kits Without Power Steering
- 67 $\frac{1}{2}$ " for Kits With Remote Power Steering
- 69" for Kits With Saginaw Power Steering

Preparing to Install

- Disconnect the battery to prevent accidental engagement of starter motor.
- Drain coolant from system
- If your A/C is intact and charged it must be evacuated. This is best done by a professional garage with proper recycling equipment
- Remove the existing alternator, air conditioning compressor and associated brackets.
- Remove all pulleys and water pump.
- Remove all traces of old gasket and sealer with gasket scraper and steel wool pad.
- Clean threads in block by chasing with appropriate thread chasers.

Installing the Kit

Note: Photos in these instruction show the Style Track bracket, Assembly of the Revolver Style kit is the same.

Fig 1. Ensure the sealing face of the coolant outlets are clean, flat and free of old gasket material. Apply a small amount of RTV silicone to one end of each mounting stud to prevent coolant seepage. Install the (4) $\frac{3}{8}$ x 3" mounting studs (S339) into the four water pump mounting holes $\frac{1}{2}$ " inch deep into block.

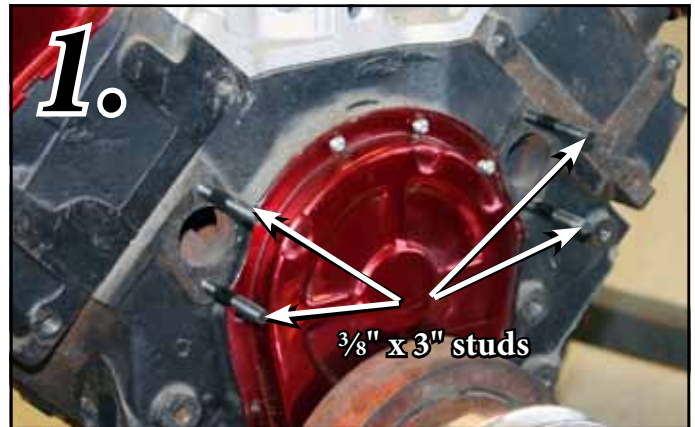


Fig 2. Install the Alternator Rear Support Brackets (21202-A) on the drivers side and A/C Rear Support (21203-A) on drivers side. Use the (4) provided Paper Gaskets (S676) and a small amount of silicon sealant installed on the front and rear of both brackets to ensure a water tight seal.

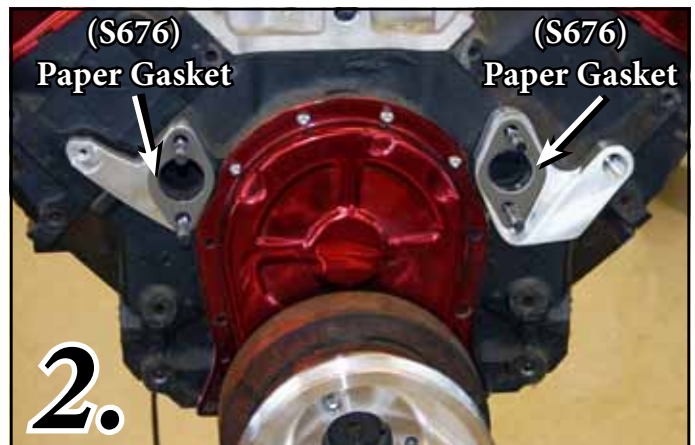


Fig 3. install the Water Pump (P125) over the studs and secure with (4) 3" threaded spacers (S785) as shown and tighten.



Fig 4. Install Main Front Bracket (21201-A Style Track) or (21261-A Revolver) to the threaded studs using (4) $\frac{3}{8}$ -16 x 1" socket caps. (S248)

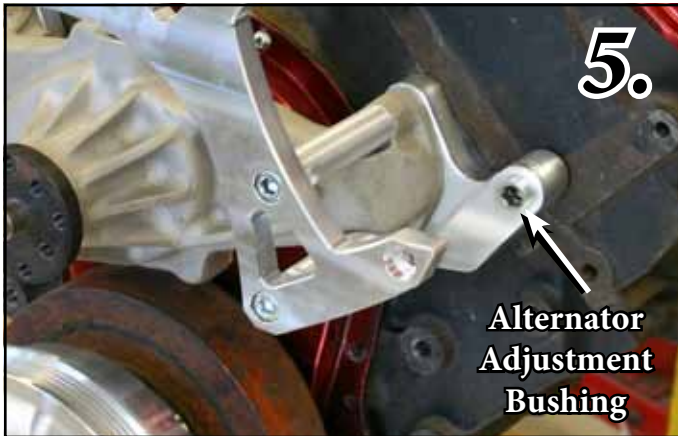


Fig 5. Install $\frac{5}{8}$ "-18 Threaded Alternator Adjustment Bushing (S452) into Rear Alternator Support Bracket as shown.

Fig 6. Install the Alternator (P572) using a $\frac{3}{8}$ x $4\frac{3}{4}$ " SHCS (S277) and the billet spacer bushing (A3-1.250). Adjust Bushing (S452) to take up any space between the lower alternator support and the spacer. (snug only at this time). Tighten lightly at this time.

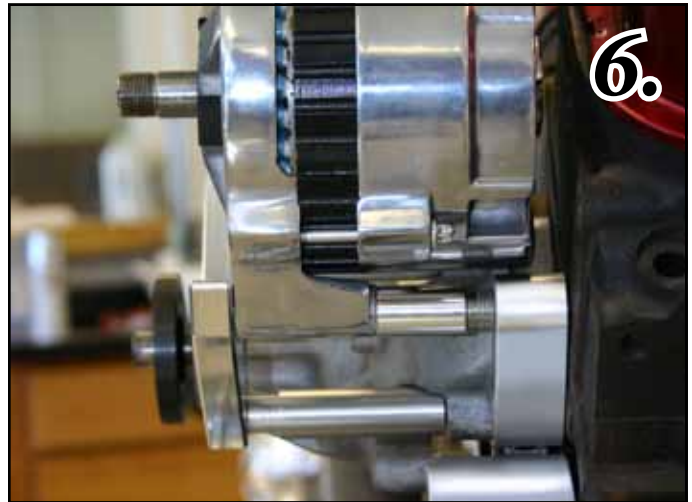


Fig 7. Install A/C unit (P412) Using a M8 x 20mm SHCS (S550) in the lower front hole and a $\frac{5}{16}$ x $1\frac{1}{2}$ " (S150) SHCS in the rear lower Hole. Use a $\frac{3}{8}$ " I.D. x .300 long spacer (TP3-.300) between the rear A/C bracket and the rear ear of the A/C unit As Shown.

For kit #21250 #21260with remote Power Steering

Fig 8. Install the power Steering Pump (P315).To the Power Steering Bracket (21204-A) With (2) M8 x 40 mm SHCS (S556) Bolts are installed from the Rear of the bracket and into the pump. Install Power Steering Bracket (21204-A) to the lower two holes of the block with (2) $\frac{7}{16}$ x $2\frac{1}{4}$ " (S356) or $\frac{3}{8}$ X $2\frac{1}{4}$ " (S260) SHCS Depending on Tapped holes of the block.



For kit #21255 with Saginaw Power Steering

Fig 9. Mount the front bracket (21205-A) to the front of the Power Steering pump with (2) $\frac{3}{8}$ x $\frac{3}{4}$ " Hex Head (S311). Mount the rear plate (21205-B) to the rear of the Power Steering pump with (1) $\frac{3}{8}$ x $\frac{3}{4}$ " Hex Head (S312). Use spacer (TP3-.150) between the rear plate and the Power Steering pump.



Fig 10. Use the (20115-C) Spacer Block between the two brackets. Install the unit to the lower right (drivers side) engine block tapped holes with (2) $\frac{7}{16}$ x $3\frac{1}{2}$ " SHCS (S364). Then install the Power Steering pulley.

Fig 11. Swing up A/C and Alt. units and let them swing inward at this time do not install the upper bolts into the Alt. and A/C units at this time.



Fig 12. Install water pump adapter bushing (S716) over the shaft as shown onto the locating boss.

Fig 13. Apply Loc-Tite to the threads of the four (S186) $\frac{5}{16}$ "-24 x $\frac{7}{8}$ " SHCS. Place the water pump pulley (6302-A or 6307-A) to the water pump and thread the cap screws through pulley and into water pump pulley flange, tighten firmly (28 ft/lbs.)



Fig 14. Install power steering pulley. (618-A or 535-A) Mount pulley in-line with crank pulley. Press on with a $\frac{9}{16}$ " wrench and install tool. When properly installed, pulley should be flush with top of shaft as shown. **Fig 14a.**

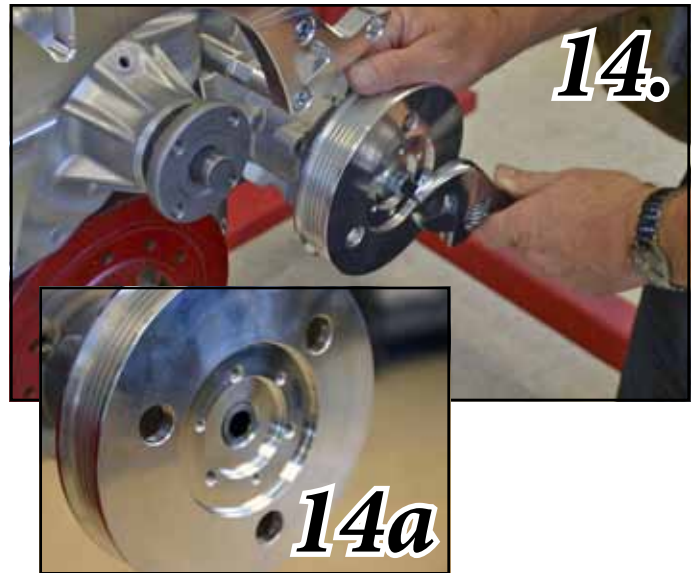


Fig 15. Install (S553) M8 x 1.25 x 35 mm bolt into (MM100) bushings as shown. Install one each into Alternator, and A/C units in adjustment slots, leave loose at this time.

Fig 16. Apply Loc-Tite to the threads of the three

(S248) $\frac{3}{8}$ "-16 x 1" SHCS. Place the crank pulley (7666-A) on damper and align holes. Thread the (3) screws through pulley and into damper, tighten firmly (50 ft/lbs.)



Fig 17. Install alternator fan (221-A) and pulley (206-A) Along with Lock Washer (S685) and tighten pulley nut (impact to 90 ft, pounds). Install Alt Cap (306-A) with (3) 8-32 x 1" SHCS (S028). Place the compressor clutch cover (394-A) onto the compressor clutch and align. Thread the three (3) (S520) M6 - 1.0 x 16mm Button Head Bolts. through the cover and into the clutch and tighten. **Caution - Do not over-tighten!**

Install the Power Steering Pulley Cover (302-A) with (3) 8/32 x $\frac{3}{8}$ " SHCS (S022).

Fig 18. Push the Alternator and A/C inward to their fullest position and Install a (Dayco 5060650) 65" belt for non-power steering kits, (Dayco 5060675) 67½" belt for Remote Power steering kits or (Dayco 5060690) 69" belt for Saginaw Power steering kits.

Slip the supplied March Adjustment tool over the two (MM100) bushings. Use a wrench to turn the adjustment tool outward to tighten the serpentine belt to 100 ft. lbs. Use the holes in the adjustment tool to tighten both M8 socket head cap screws when correct belt tension has been achieved. Remove the adjustment tool and keep for future use.



Fig 18a. TIP: Serpentine belt is tight when it can't be moved by more than ½ inch at it's longest span between pulleys. The belt should not be able to be twisted by more than half a turn.

Check and tighten all bracket bolts and alternator and A/C lower mounting bolts, turn engine over once by hand to check for any belt rubbing and proper belt alignment. Run engine three minutes and check belt tension again.

Final Assembly

If you are going to be installing your air conditioning hoses and charging the system at this time, remove the cover plate on top of the compressor body. Install the (P417) A/C adapter lines, hoses and connect clutch wire and charge system.

Important: If you are NOT installing hoses and charging the system at this time, leave cover plate on compressor. Do not connect the clutch wire or apply power to clutch wire without the hoses connected and the system charged – ***Serious damage will occur to compressor.***