



Highly Styled , Low Cost Serpentine Drive Systems



CHEVY BIG BLOCK ALT/P/S/A/C KIT

&' \$()

&' \$+&

&' \$, &

23092

Included Parts List



20150 Power Steering Bracket

1-20150-AP/S Bracket Body
2-TP3-1.980.....Spacer Tube
2-S275.....3/8-16 x 4-1/4" SHCS
1-S312.....3/8-16 x 1" Hex Bolt
1-20175-A.....Lower Front Support Bracket
1-20175-B.....Lower Rear Support Bracket
1-S266.....3/8-16 x 3" SHCS
3-S311.....3/8-16 x 3/4" Hex Bolt
4-S664.....3/8 x 1" Washer
5-S666.....3/8 x 3/4" Washer
2-S667.....3/8 x 5/8" Washer

20129 Alt. & A/C combo Bracket

1-20129-A.....Front Bracket
1-20129-B.....Rear Support Bracket
1-20142-A.....Alt Relocation Bracket
with/ 1-S144 & 1-S248
1-RA-1.625.....Adjustment rod
1-TP7-3.250.....Spacer Tube
2-TP7-1.625.....Spacer Tube
1-S150.....5/16 x 1-1/2" SHCS
2-S244.....3/8 x 3/4" SHCS
2-S248.....3/8 x 1" SHCS
1-S284.....3/8 x 6-1/2" SHCS
1-S324.....3/8 x 2-1/4" Hex Head Bolt
2-S358.....7/16 x 2-1/2" SHCS
1-S378.....7/16 x 6-1/2" SHCS
2-S550.....M8 x 20mm SHCS
1-S616.....5/16 Lock Nut
1-740-A.....Idler Pulley
with 1-S324,1-S622,1-S666
1-740-B Cap.....3-S022

6322-623 Pulley Kit

1-7336-A.....Crank Pulley
1-6322-A.....Water Pump Pulley
1-623-A.....Power Steering Pulley (key)
1-208-A.....Alt. Pulley
1-221-A.....Alt Pulley Fan
1-314-A.....W/P Pulley Cover
1-394-A.....A/C Cover
1-307-A.....Alt Cover
3-S028.....8/32 x 1" SHCS
1-S685..... Lock Y æ @!
4-S183.....5/16-24 x 5/8 SHCS
3-S248.....3/8-16 x 1" SHCS
3-S124.....1/4" Button head screws
3-S520.....M6 x 20mm  P^æå
(For Metric A/C Clutch)

Required tools and Materials

RTV silicone	6mm Allen Head
Lock-Tite	5/8 Combo Wrench
Gasket Scraper	9/16 Combo Wrench
3/16 Allen head	11/16 Combo Wrench
5/16 Allen head	3/4 Combo Wrench

Photo-1

Install the crank pulley 7336-A To the balancer using three 3/8-16 x 1" SHCS (S248) as shown.

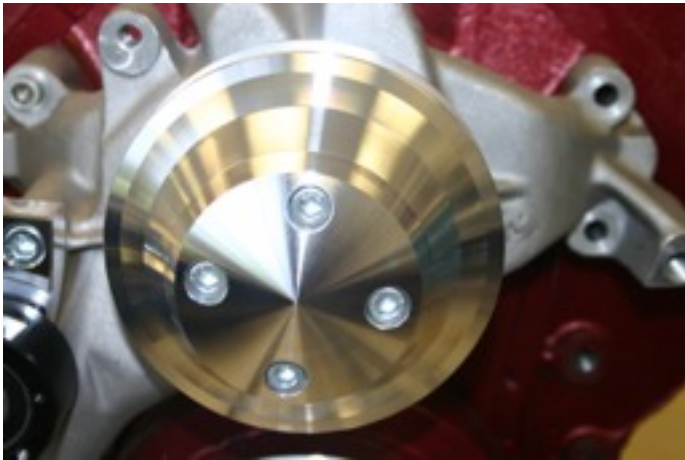


Photo-2

Install the Water Pump Pulley (6322-A) and the pulley cover (314-A) using four 5/16 x 5/8 SHCS (S183).

Photo-3

Mount the Alt & A/C front bracket (20129-A) to the two tapped holes on the water pump. In the upper hole use a 3/8 x 1" SHCS (S248) In the lower hole install the Idler pulley (740-A) use a 3/8 x 3/4 washer (S666) and a 3/8 x 2-1/4" hex bolt (S324). And install the (740-O) Idler Pulley O-ring as well. Using three 8/32 x 3/8 SHCS (S622)



Photo-4

Mount your GM Alternator to the bracket using the (TP7-3.250) Spacer Tube between the head and the rear of the Alt Mounting ear, using a 3/8 x 6-1/2" SHCS (S284) as shown. We also provide a 7/16 x 6-1/2" SHCS (S378) if your heads have 7/16 holes. Now install the Alt. Fan, (221-A) and Alt Pulley (208-A) with the provided 11/16 lock washer (S685). Make sure to use an impact to secure the pulley and fan. Next install the Alt Cap (307-A) using three 8/32 x 1" SHCS (S028).

Photo-5

Mount the Rear A/C support Bracket (20129-B) To the Pass. Side two lower holes using two (TP7-1.625) Spacers between the block and the rear support securing with two 7/16 x 2-1/2" SHCS (S358).

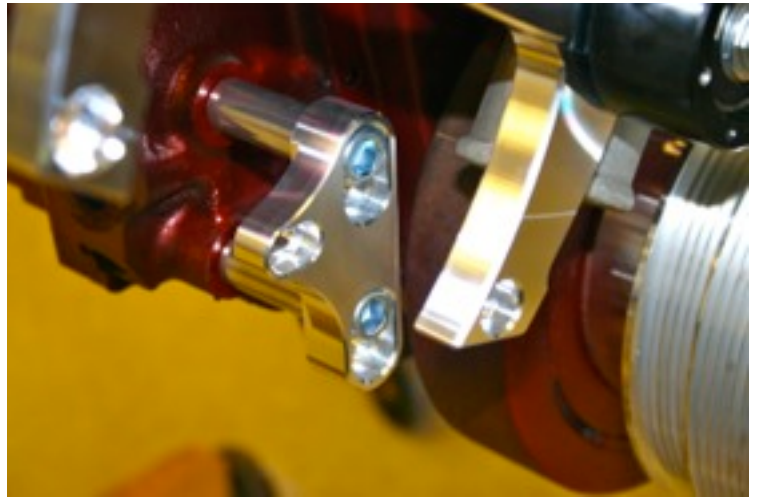


Photo-6

Mount the A/C compressor to the A/C & Alt Main bracket. Use two M8 x 20mm SHCS (S550). (Note) the metric bolts have a larger head then the standard socket caps. Now lineup the rear support to the rear A/C ear and secure with a 5/16 x 1-1/2" SHCS (S150) and a 5/16 lock nut (S616). Now add the provided (394-A) A/C clutch cover to the front do the A/C unit using three 1/4-20 x 3/4" button head screws.(S124).(NOTE) Some clutch units require metric screws for this application, use the three M6 x 20 mm Metric Button Heads (S520).

.Photo-7

Mount the Alt. Re-locator (20142-A) to the tapped hole of the Alternator (Back Side) using the provided 5/16 x 7/8 SHCS (S144) then attach the (RA-1.625) Adjustment rod to the Re-locator with a 3/8 x 1" SHCS (S248).You can now attach the rod to the water pump Using the second provided 3/8 x 1" SHCS As shown.

If your Not using the power steering option install and tighten the 62" belt, if your using power steering move to the next step.

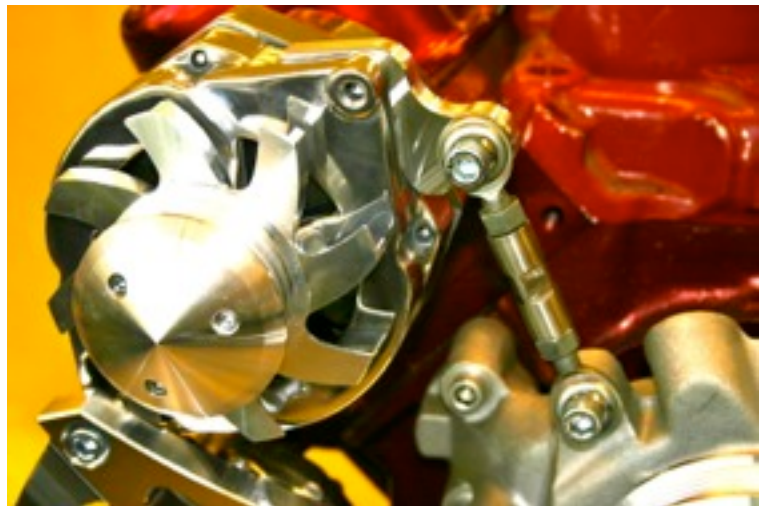


Photo-8 Mounting the P/S. If your P/S pump came with a mounting stud at the rear lower 6 o'clock position in the the pump use a 11/16 wrench and remove it .

Photo-9

Mount the Power steering brackets that came with your kit to the water pump boss (20175-A) front & (20175-B) rear. Use a 3/8 x 3" SHCS (S266) Place one 3/8 x 1" (S664) washer between the water pump and rear support bracket and start threads. Due to production Differences in the water pumps different shimming may be required and extra washers are provided.

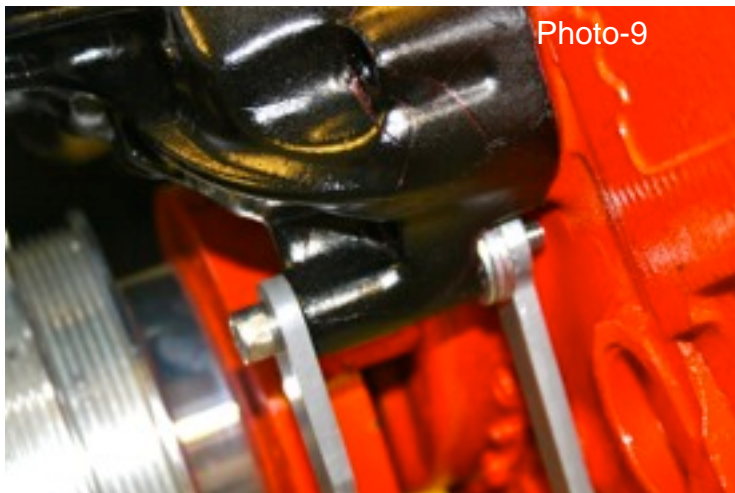
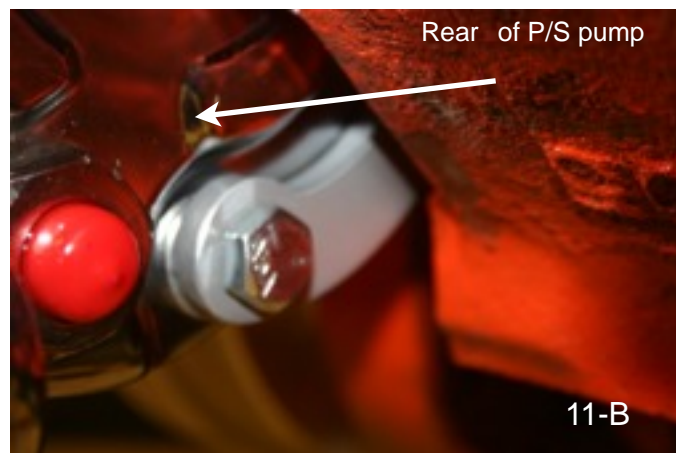


Photo-9



11-A



Rear of P/S pump

11-B

Photo-11

Secure the P/S pump to the lower brackets (20175-A) & (20175-B) use two 3/8 x 3/4 Hex bolts (S311) in the front bracket use two 3/8 x 3/4" washers (S664) behind each of the two locations of the front mounting bracket. And snug the bolts. See photo 11-A . Photo-11-B shows mounting of the rear support bracket using one 3/8 x 1" washer.(S664) and a 3/8 x 3/4" hex bolt (S311) .

Photo-12

Install the front Power steering bracket (20150-A) to the water pump using two 3/8 x 4-1/4" SHCS (S275) and two (TP3-1.980) spacer tubes.

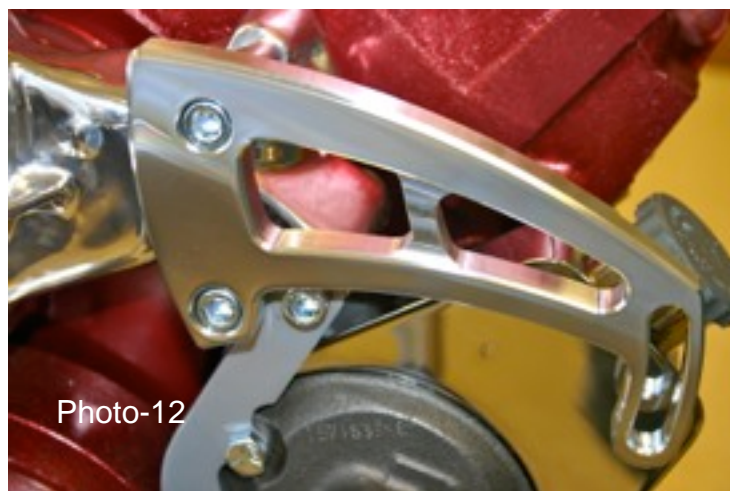


Photo-12

Photo-13

Check the distance between the front bracket and the power steering pump there should be a gap big enough to fill with one 3/8 washer. If the distance is greater it may be necessary to remove one washer from the rear of the lower rear support to move the pump forward this will achieve a movement of 3/32 on one inch.

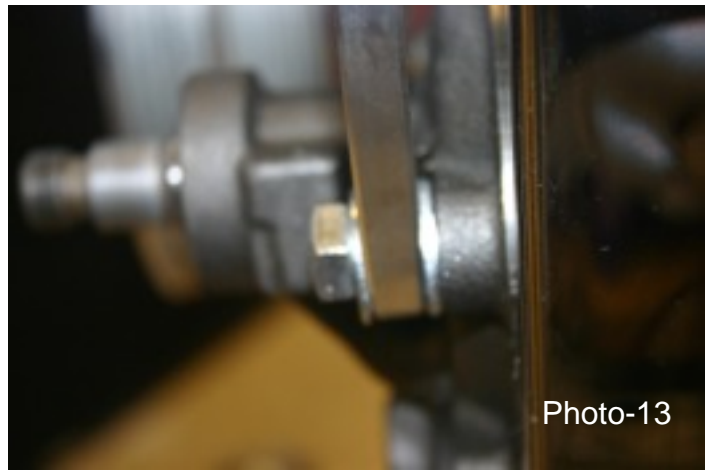


Photo-13

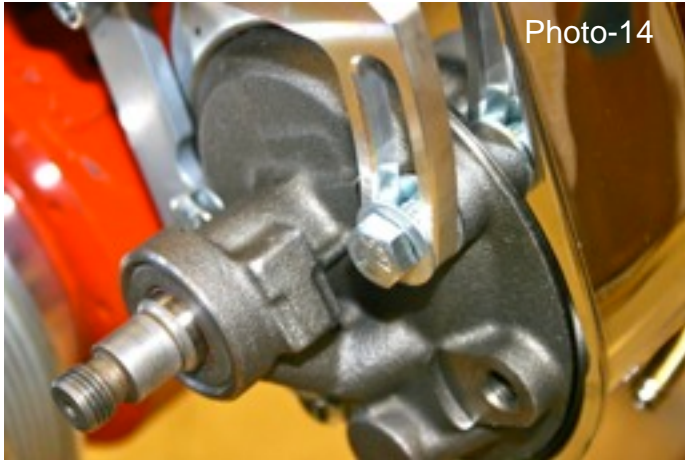


Photo-14

Photo-14

Once proper spacing is achieved secure the front bracket to the pump thru the slot use a 3/8 x 3/4" washer (S666) and a 3/8 x 1" hex bolt (S312) . And one 3/8 x 1" washer between the main front bracket (20150-A) and the power steering pump.

Photo-15

Mount the power steering pulley to the pump (623-A) keyed or (624-A) press fit. And check alignment in relation to the crank pulley . Install the power steering belt 5060390 (39") From the crank to the P/S pulley and tighten. Use the adjustment bolt in the P/S slot to secure the belt position with no more the 1/4" of twist in the belt when tight.



Photo-15



Photo-16

Now add the Alt & A/C Drive Belt (5060620) 62" belt and use the Adjustment rod to tighten. Re-check all bolts. And drive belts after a five min. Run time.