

# **Revolver**



**Powder Coated**  
NO Polishing Required

*Highly Styled, Low Cost Serpentine Drive*

Installation Instructions

*Chrysler 383, 440 and 426 HEMI*

*Kit #40720 (without Power Steering) Use 71.5" Serpentine Belt*

*Kit #40725 (with Power Steering) Use 81.5" Serpentine Belt*



## Included Parts List

### Main Front Bracket P/N # 40721

- 1 40721-A ..... Front Bracket body
- 4 740-A ..... Idler Pulley Body
- 4 302-A ..... Idler Cap
- 2 MM100 ..... Bolt Adjustment Sleeve
- 12 S022 ..... 8-32 x 3/8" SHCS
- 4 S244 ..... 3/8-16 x 3/4" SHCS
- 2 S248 ..... 3/8-16 x 1" SHCS
- 4 S321 ..... 3/8-16 x 1 3/4" Hex Head Bolt
- 4 S340 ..... 3/8 x 4" Threaded Stud
- 1 S551 ..... 8mm-1.25 x 25mm SHCS
- 2 S553 ..... 8mm-1.25 x 35mm SHCS
- 2 S622 ..... 3/16-16 Nylon Locknut
- 4 S771 ..... 3/8 x 2" Threaded Spacer

### A/C Rear Support Bracket P/N # 40722

- 1 40722-A ..... A/C Rear Support Brk Body
- 1 AC3-.200 ..... Spacer Alum 3/8" id x .200 Lg
- 1 S155 ..... 5/16-18 x 2" SHCS

### Alternator Rear Support Bracket P/N # 40723

- 1 40723-A ..... Alt Rear Support Brk Body
- 1 S270 ..... 3/8-16 x 3 1/2" SHCS
- 1 S453 ..... 5/8-18 x .850" Set Screw
- 1 S622 ..... 3/8" Nylon Lock Nut

### Power Steering Bracket P/N # 40724

#### For Kit # 40725 (Power Steering)

- 1 40724-A ..... P/S Bracket Body
- 3 S551 ..... 8mm-1.25 x 25mm SHCS

### Pulley Kit P/N # 10350-208

- 1 10321-A ..... Crank Shaft Pulley Body
- 1 10322-A ..... Water Pump Pulley Body
- 1 208-A ..... Alt Pulley Body
- 1 307-A ..... Alt Cap
- 1 221-A ..... Alt Fan
- 1 394-A ..... A/C Cover
- 3 S028 ..... 8/32 x 1" SHCS
- 4 S143 ..... 5/16-18 x 5/8" SHCS
- 6 S144 ..... 5/16-18 x 7/8" SHCS
- 3 S520 ..... 6mm-1.0 x 16mm Button Hd Bolt
- 1 S685 ..... 1 1/16" Lock Washer
- 1 650-A ..... Power Steering Pulley For Kit # 40725 (Power Steering)
- 1 600-A ..... Hub Power Steering For Kit # 40725 (Power Steering)
- 3 S144 ..... 5/16-18 x 7/8" SHCS For Kit # 40725 (Power Steering)

### Adjustment Tool P/N # 30436

- 1 MM101 ..... Right Hand Rod End
- 2 MM102 ..... Left Hand Rod End
- 1 MM106 ..... 14 3/4" Threaded Rod

### Accessories

- 1 P178 ..... Mopar Polished Water Pump
- 1 P412 ..... A/C Compressor Chrome
- 1 P417 ..... A/C Line Kit
- 1 P572 ..... Alternator 105 Amp Chrome
- 1 P315 ..... Remote Power Steering Pump For Kit # 40725 (Power Steering)

## Required Tools and Materials

- RTV Silicone
- Loc-Tite® Thread Locker
- Gasket Scraper, Steel Wool or Sandpaper to clean gasket surfaces
- 3/16" Allen Head Driver
- 5/16" Allen Head Driver
- 1/4" Allen Head Driver
- 6mm Allen Head Driver
- 5/8" Combo Wrench

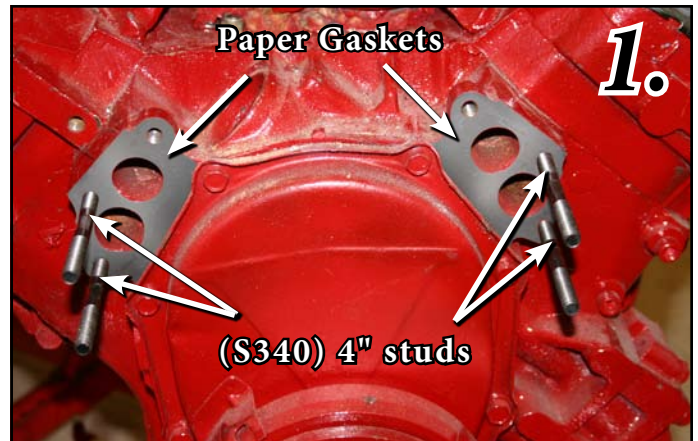
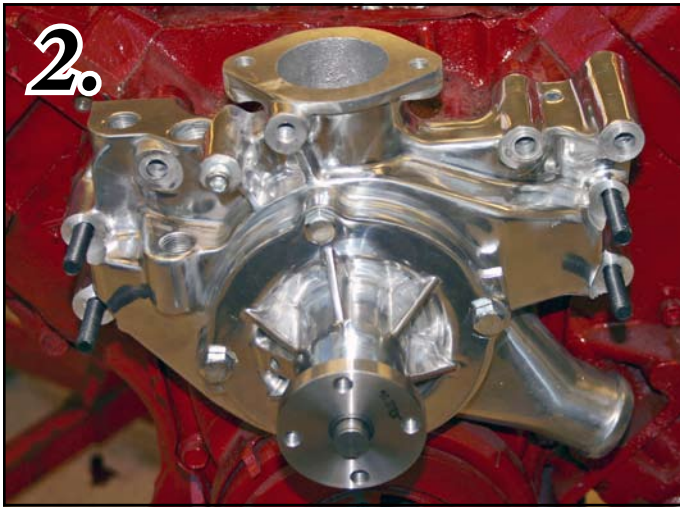
- 9/16" Combo Wrench
- 1 1/16" Combo Wrench
- 3/4" Combo Wrench
- Socket Wrench & Extension
- 10mm 12pt. socket
- 12mm 12pt. socket
- 81.5" Serpentine Belt (with P/S)
- 71.5" Serpentine Belt (without P/S)

## 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

**Photo-1** Make sure the water pump mounting surfaces are clean and free of old gasket material. Install the (4) four inch long studs (S340) in the mounting locations shown.



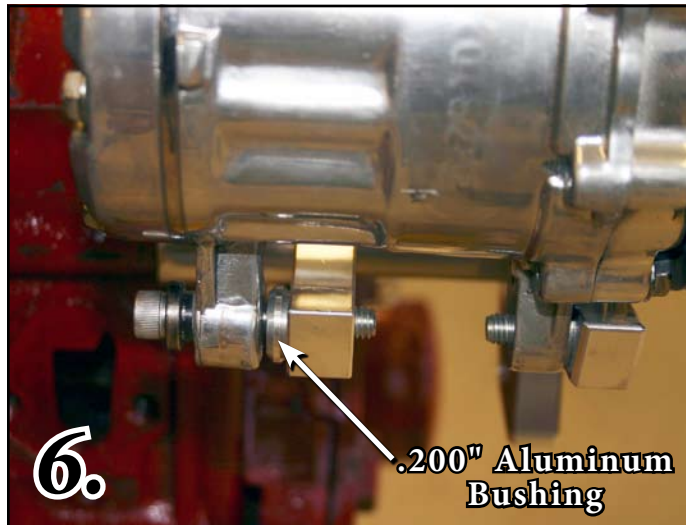
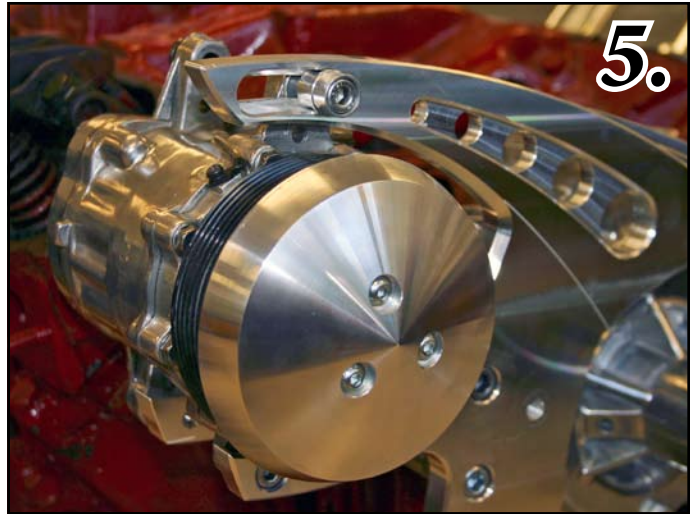
**Photo-2** Using silicon sealer and new gaskets, install the Provided Water pump (P178) over the four studs as shown.

**Photo-3** Slide the A/C Rear Supports (40722-A) over the studs on the passenger and side and Alternator Rear Support (40723-A) over the stud on the drivers side. Secure using the (4)  $\frac{3}{8}$  x 2" (S771) Threaded Stainless Spacers mounting over the studs as shown.



**Photo-4** Install The Main Face Plate (40721-A) using (4) (S244)  $\frac{3}{8}$  x  $\frac{3}{4}$  " SHCS thru the four counter sunk bolt holes in the front of the plate and into the four Stainless Threaded Spacers.

**Photo-5** Install the A/C Unit (P412) to the Main Bracket Face Plate with the A/C outlet lines pointing to the top. Use (1) M8 x 25mm SHCS (S551) in the bottom Front ear and (1) M8 x 35mm (S553) in the top counter sunk Slot along with the Countersunk Aluminum Bushing (MM100) as shown (do not tighten at this time).



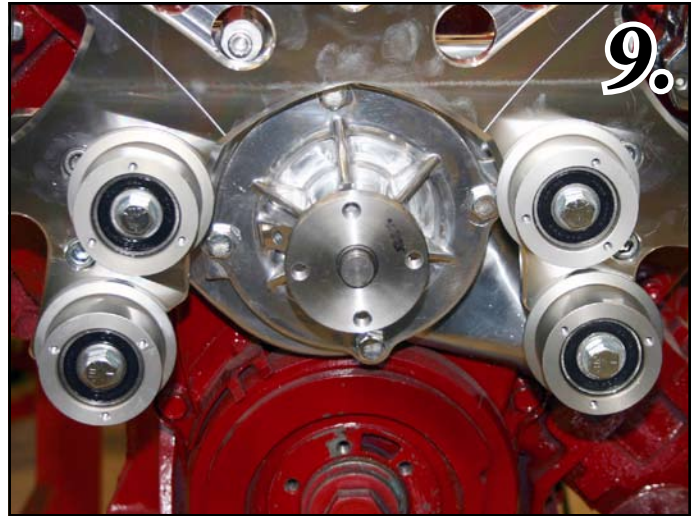
**Photo-6** Install the rear  $\frac{5}{16}$  x 2" SHCS (S155) A/C support bolt thru the rear lower ear of the A/C unit. Between the rear A/C ear and the Rear A/C support install a .200 Aluminum Bushing (AC3-.200) as shown and tighten at this time.

**Photo-7** Install the  $\frac{5}{8}$ " Dia. Threaded bushing (S453) into the Alternator Rear Support as shown.

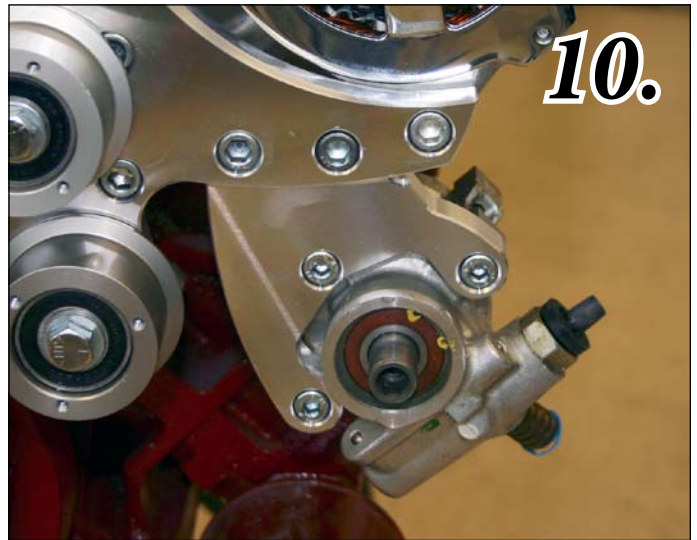


**Photo-8** Installing the Alternator (P572) using a  $\frac{3}{8}$  x  $3\frac{1}{2}$ " SHCS (S270) thru the bottom bolt hole. Adjust the  $\frac{5}{8}$ " Dia. Threaded bushing (S453) to take up any slack between the Alternator's lower mount and the Rear Alternator Support Bracket. Secure with a  $\frac{3}{8}$ " Lock nut (S622). In the upper Alternator location use a M8 x 35mm SHCS (S553) and Countersunk Aluminum Bushing (MM100). (do not tighten at this time).

**Photo-9** Install the (4) (740) Idler units to the main face plate using four  $\frac{3}{8}$  x  $1\frac{1}{4}$ " Hex Bolts (S321) and four  $\frac{3}{8}$ " washers (S666) as Shown.



**Photo-10** On kit with Power Steering install the Power Steering Pump Unit (P315) to the Power Steering Bracket (40724-A) using (3) M8 x 25mm SHCS (S551).



**Photo-12** Install the Power Steering Bracket to the Main front bracket Using two  $\frac{3}{8}$  x 1" SHCS (S248).

*(NOTE: if not using power Steering Disregard and install Two  $\frac{3}{8}$  x 1" SHCS and Two  $\frac{3}{8}$ " Locknuts (S622) to fill the counter bored Holes.)*



**Photo 11.** Slide the Alternator Fan (221-A) over the alternator shaft followed by the Alternator Pulley (208-A). Use the lockwasher (S685) and lock nut then tighten (*We recommend a impact for installation of alt pulley, impact to 90 ft, pounds*).

**Photo 12.** Install the Alternator Pulley Cover (307-A) with three  $\frac{8}{32} \times 1$ " SHCS (S028).

Install the A/C cover (394) with three 6mm-1.0 x 16mm Button Hd Bolt (S520).

Install the WaterPump Pulley (10322-A) with four  $\frac{5}{16} \times \frac{5}{8}$ " SHCS (S143).

Install the Crank Pulley (10321-A) with (6)  $\frac{5}{16} \times \frac{7}{8}$ " SHCS (S144)

Install the Power Steering Pulley (650-A) using (3)  $\frac{5}{16} \times \frac{7}{8}$ " SHCS (S144).

Install the Idler Covers (302-A) with (3)  $\frac{8}{32} \times \frac{3}{8}$ " SHCS (S022).



**Photo 13** Push both the Alternator and A/C units inwards at the top mounts and install the serpentine belt routing as shown, 87 $\frac{1}{2}$ " belt for kits with Power Steering. Non-Power steering kits will bypass the P/S Pulley with a shorter 72 $\frac{1}{2}$ " belt.



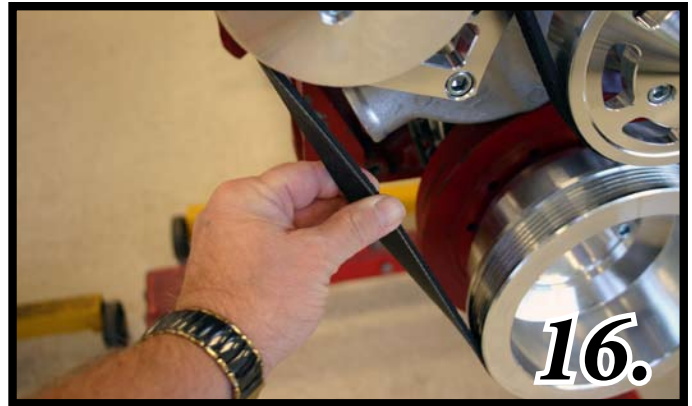
**Photo 14.** Slip the supplied March Adjustment Tool (30436) over the two (MM100) bushings at the Alternator and A/C sides. Use a wrench to turn the adjustment tool outward to tighten the serpentine belt to 100 ft. lbs.



**Photo 15.** 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.

**Photo 16 TIP: Your Serpentine belt is tight when it can't be moved by more than 1/2" 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, 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 A/C adapter lines (P417), 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.***