



MARCH PERFORMANCE LS STREET ROD KIT

19940

Alternator & Power Steering

19950

Alternator, Air Conditioning & Power Steering

PARTS LIST

19941 Alternator Bracket

1-19941-A.....Front Alt Bracket
1-19941-B.....Rear Support Bracket
1-747-A.....Idler Pulley
1-302-A.....Idler Pulley Cap
1-713Idler Adjustment Assembly
3-S022.....8-32 x 3/8" SHCS
2-S102.....1/4 x 3/4" SHCS
1-S264.....3/8 x 2-3/4" SHCS
1-S321.....3/8 x 1-3/4" Hex Head Bolt
1-S550.....M8-1.25 x 20mm SHCS
3-S554.....M8-1.25 x 80mm SHCS
3-S562.....M10-1.5 x 80mm SHCS
1-S666.....3/8" Flat Washer
1-TP7-1.6757/16" x 1.675 Tube Spacer
2-TP7-2.3007/16" x 2.300 Tube Spacer

19942 A/C Bracket

1-19942-A.....Front A/C Bracket
1-19942-B.....Rear Support Bracket
1-S213.....5/16 x 1-1/2" Hex Head Bolt
2-S550.....M8-1.25 x 20mm SHCS
3-S554.....M8-1.25 x 80mm SHCS
2-S564.....M10-1.5 x 110mm SHCS
1-S590.....M10-1.5 x 45mm SHCS
1-S616.....5/16" Lock Nut
1-S660.....5/16" Flat Washer
1-TP7-.9007/16" x .900 Tube Spacer
1-TP7-2.6257/16" x 2.625 Tube Spacer
1-TP7-3.2507/16" x 3.250 Tube Spacer

19943 Power Steering Bracket

1-19943-A.....Power Steering Bracket
2-S550.....M8-1.25 x 20mm SHCS

19944 Non-A/C Idler Assy

2-S561M10 x 1.5 x 30mm SHCS
1-P753.....Adjustable Idler Assy

Accessories

1-P121Water Pump
1-P313.....P/S Pump with Hub
1-P412.....A/C Compressor
1-P572.....Alternator
1-418-06A/C Line Adapter

Pulleys

1-653-A.....P/S Pulley
1-394-A.....A/C Compressor Cap
1-306-A.....Alternator Pulley Cap
1-221-A.....Alternator Fan
1-206-A.....Alternator Pulley
3-S028.....8-32 x 1" SHCS
3-S144.....5/16 x 7/8" SHCS
3-S124.....1/4 x 3/4" Button Head
3-S520.....M6-1.0 x 20mm Button Head
1-S685.....11/16" Lock Washer

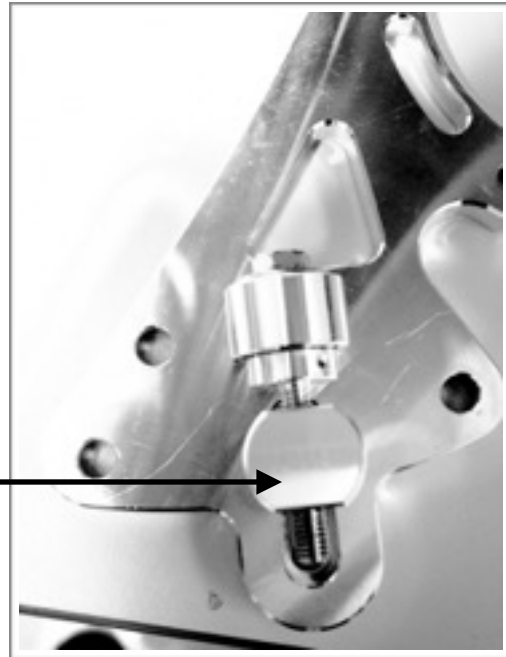


Fig.-1

Mount the water pump (P121) with the six provided M8 x 80 MM SHCS (S554). **(Note):** If you have the power steering option leave bolts out, you will use them later when mounting power steering bracket.

Fig.-2

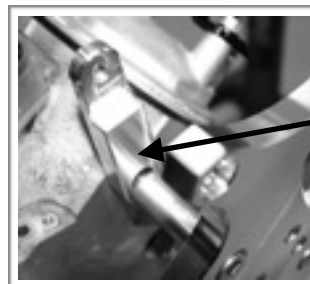
Mount the (713) idler adjustment assembly to the back side of the (19941-A) main alternator bracket, securing it with two 1/4 x 3/4" SHCS (S102) from the front side of the main bracket.



713 idler adjustment assembly, mount to rear of main alternator bracket, with the block adjusted to the up position.

Fig.-3

Mount the main alternator bracket (19941-A) to the drivers side head. Use two M10 x 80 mm SHCS (S562) in the outer two bolt holes with two (TP7-2.300) Spacers between the head and the rear of the main bracket. The inner mounting bolt will use a M10 x 80mm (S562) and a (TP7-1.675) spacer tube then the (19941-B) rear support with the rear support resting on the face of the head with the spacer in between. Make sure the notch of the bracket faces up.



Rear Alternator Support (19941-B) & TP7-1.675 spacer

2-M10 x 80MM With 2-2.300 Spacers

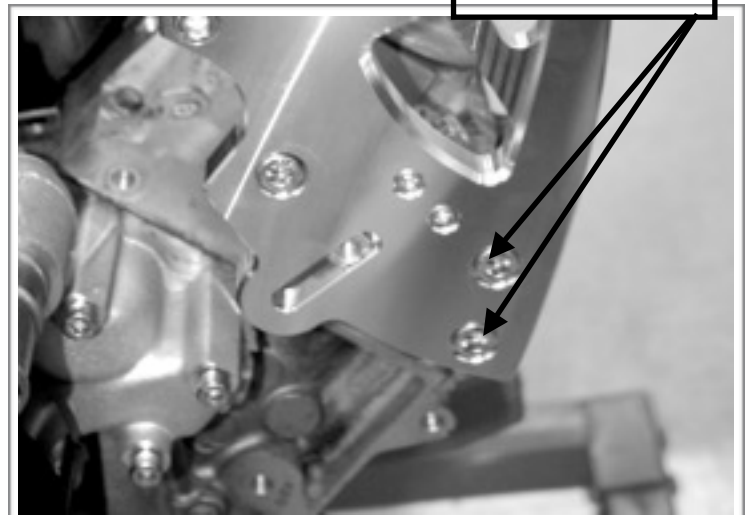




Fig.-4

Mount the Alternator (P572) to the main bracket using in the upper mounting hole a (S550) M8 x 20mm SHCS. The lower mounting hole will use a (S264) 3/8 x 2-3/4" SHCS. Run this bolt thru the alternator, threading it into the rear support bracket. Add the (221-A) alternator fan and the (206-A) alternator pulley. Secure the alternator pulley with the (S685) lock washer. Impact the pulley on and then add the cover (306-A) using three 8-32 x 3/8 x 1" SHCS (S028).

Fig.-5

Mount the (747-A) idler with a (S666) washer along with a (S321) 3/8 x 1-3/4" hex bolt and thread into the open threaded hole in the bracket. Leave finger tight until after installing the belt. **DO NOT** install idler nose cover at this point.



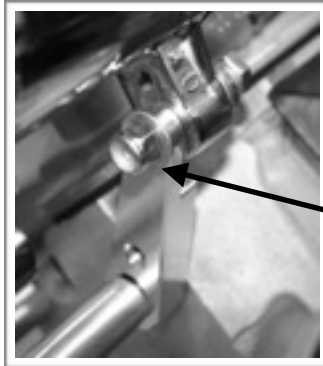
Fig.-6

If not running a/c skip to figure 8. Mount the A/C bracket (19942-A) running in lower left mounting hole use a (S564) M10 x 110mm SHCS along with a (TP7-3.250) spacer between the bracket and the head. In upper right mounting hole will use a (S564) M10 x 110mm SHCS, placing a (TP7-2.625) spacer behind the bracket the slide the (19942-B) rear support between the spacer and the head with the step facing the motor. The lower center bolt will use a (TP7-.900) Spacer between the water pump boss and the bracket. Secure with a (S590) M10 x 45mm SHCS.



Fig.-7

Mount the A/C unit (P412) to the back of the main bracket, using two (S550) M8 x 20mm SHCS in the top and bottom A/C ears. Tie the rear support bracket to the rear lower A/C ear. Use a (S660) 5/16 washer and a (S213) 5/16 x 1-1/2" hex head bolt running it thru the rear A/C ear into the rear support secure with a 5/16 lock nut (S616). Now add the (394-A) A/C cover. Use three (S124) 1/4" Button heads or three (S520) Metric button heads depending on your clutch.



Rear Support (19942-B) ties into rear lower A/C ear with a 5/16 x 1-1/2" hex bolt and a 5/16 lock nut.

Fig.-8

Mount the power steering bracket (19943-A) to the water pump using three M8 x 80 MM SHCS (S554) Next mount the remote pump (P313) to the bracket using two (S550) M8 x 20 MM SHCS.

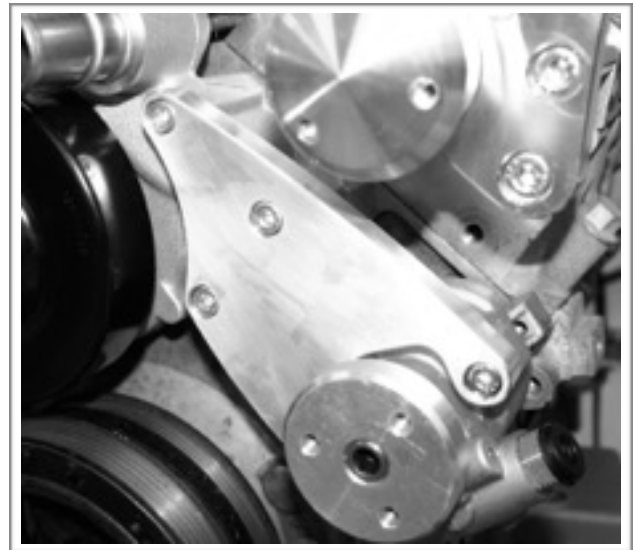


Fig.-9

Install the (653-A) power steering pulley using three (S144) 5/16 x 7/8" SHCS attaching pulley to the pressed on flange.

Fig.-10

For non-a/c kits install belt tensioner (P753) to the two water pump ears with two M10 x 30mm bolts (S561).

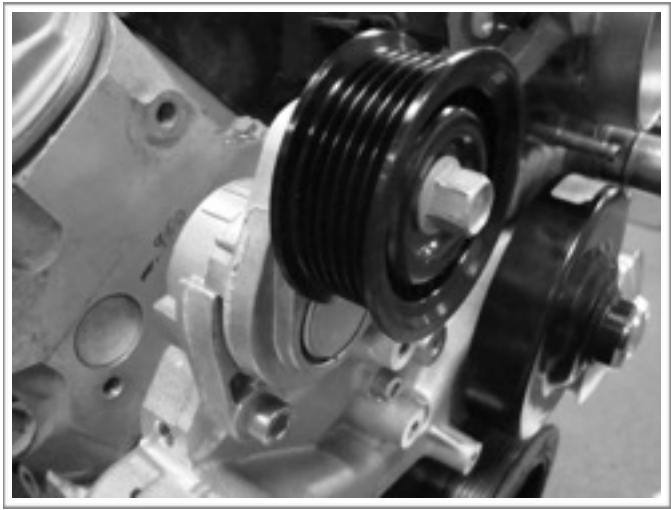


Fig.-11

Install the belt with the idler adjustment assembly (713) in the up position. Install a Dayco 93-1/2" (5060935) belt for alt/ac & p/s kits and a Dayco 78" (5060780) for non-a/c kits. Make sure the adjustable idler is finger tight only while using a socket to tighten the belt with the adjustable idler assembly. Adjust idler assembly with a 9/16" socket on the back side of the bracket. For non-a/c kits, to install belt pull idler towards the throttle body, making sure to install the belt by going under water pump last and then let it release. After belt installation, tighten the idler bolt and add the (302-A) Idler pulley cover use three 8/32 x 3/8 SHCS (S022).

Non- A/C Belt Routing



Alt/AC/PS Belt Routing

