

# **Revolver**



## *Highly Styled, Low Cost Serpentine Drive*

Installation Instructions

### *Chevy Big Block*

*#21285 - 21245 (Billet Alternator and Power Steering)*

*#21290 - 21240 (Chrome Alternator and Power Steering)*



## Parts List

### Main Front Bracket P/N 21266

- 1 - 21266-A or 21241-A. Main Front Bracket
- 2 - S146 ..... $\frac{5}{16}$ " x 1" SHCS
- 4 - S248 ..... $\frac{3}{8}$ " x 1" SHCS
- 4 - S339 ..... $\frac{3}{8}$ " x 3" Threaded Stud
- 4 - S786 ..... $\frac{3}{4}$ " od x 3" Lg Threaded Spacer
- 2 - MM100..... Bolt Bushing Alum

### Rear Power Steering Support Bracket P/N 21262

- 1 - 21262-A..... Rear Power Steering Support Bracket
- 1 - S277 ..... $\frac{3}{8}$ " x 4 $\frac{3}{4}$ " SHCS
- 2 - S676 ..... Water Pump Gasket
- 1 - TP3-1.680..... $\frac{3}{8}$ " Id x 1.680 Lg Tube Spacer
- 1 - TP3-1.890..... $\frac{3}{8}$ " Id x 1.890 Lg Tube Spacer
- 2 - S677 ..... $\frac{3}{8}$ " Washer

### Rear Alternator Support Bracket P/N 21263

- 1 - 21263-A..... Rear Alternator Support Bracket Body
- 1 - S279 ..... $\frac{3}{8}$ " x 5 $\frac{1}{4}$ " SHCS
- 1 - S450 ..... $\frac{5}{8}$ " Od x 1.125" Lg Set Screw
- 1 - S622 ..... $\frac{3}{8}$ " RH Lock Nut
- 2 - S676 ..... Water Pump Gasket
- 1 - TP3-1.400..... $\frac{3}{8}$ " Od x 1.400" Lg Tube Spacer

### Power Steering Ring Adaptor P/N 21074

- 1 - 21074-A..... Power Steering Ring Adaptor
- 2 - S244 ..... $\frac{3}{8}$ " x  $\frac{3}{4}$ " Lg SHCS
- 1 - S309 ..... $\frac{3}{8}$ " x 1" Lg Button Head Bolt

### Adjustment Tool P/N 21206

- 1 - MM101..... RH Rod End
- 1 - MM102..... LH Rod End
- 1 - MM105..... 13" Threaded Rod

### Pulley Kit P/N 7625-206

- 1 - 7661-A..... Crank Shaft Pulley
- 1 - 6307-A or 6302-A..... Water Pump Pulley
- 1 - 206-A..... Alternator Pulley
- 1 - 221-A..... Alternator Fan
- 1 - 306-A..... Alternator Cap
- 1 - 360-A..... Power Steering Pulley Cap
- 1 - 629-A..... Power Steering Pulley
- 3 - S028 ..... 8-32 x 1" Lg SHCS
- 4 - S183 ..... $\frac{5}{16}$ " x  $\frac{5}{8}$ " Lg Fine Thd SHCS
- 3 - S248 ..... $\frac{3}{8}$ " x 1" Lg SHCS
- 1 - S685 ..... $\frac{11}{16}$ " Id Lock Washer
- 1 - S716 ..... $\frac{3}{4}$ " od x  $\frac{5}{8}$ " id Alum Water Pump Ring
- 3 - S106 ..... $\frac{1}{4}$ "- 20 x 1 $\frac{1}{4}$ " SHCS

### Accessories

- 1 - P-125..... Water Pump Aluminum
- 1 - P-304..... Power Steering Pump Saginaw Chrome **FOR KIT #21290 / #21240 ONLY**
- 1 - P-555..... 100 Amp Alternator Chrome **FOR KIT # 21290 / #21240 ONLY**
- 1 - P9600..... Power Steering Pump Saginaw Style Billet **FOR KIT #21285 / #21245 ONLY**
- 1 - P9655..... 140 Amp Alternator Billet Aluminum **FOR KIT #21285 / #21245 ONLY**

## 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

- 64" Serpentine Belt

## Preparing to Install

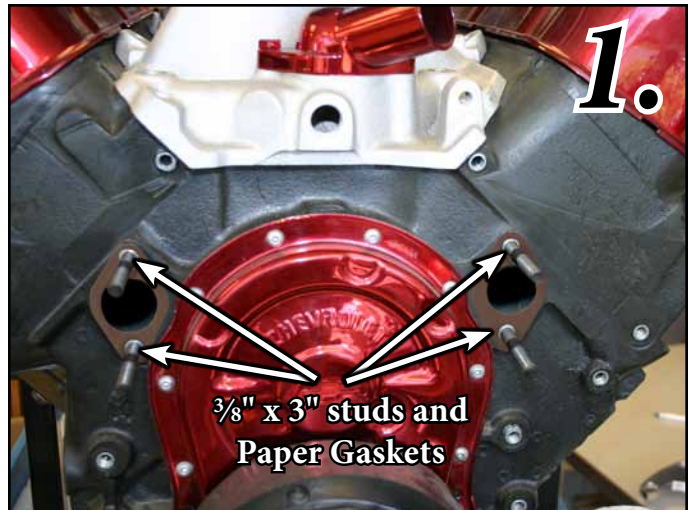
- Disconnect the battery to prevent accidental engagement of starter motor.
- Drain coolant from system
- If your A/C is intact and charged it must be evacuated. This is best done by a professional garage with proper recycling equipment
- Remove the existing alternator, air conditioning compressor and 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.

**NOTE: : If using old style cylinder heads that have freeze plugs contact tech support before install. Support brackets will have to be modified or modifications to freeze plugs will need to be made.**

## Installing the Kit

**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 (2) Paper Gasket (S676) over the studs and the on the passenger side install the Alternator Rear Support Bracket (21263-A). On the drivers side install the Power Steering Rear Support Bracket Drivers Side (21262-A)

**Fig 3.** Install the second set of Paper Gaskets over the studs and slide the Water pump (P-125) over the four studs.



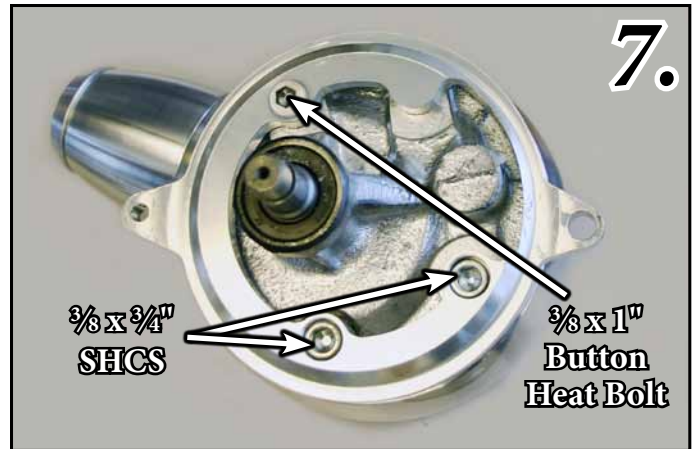
**Fig. 4.** Install (4) Stainless Spacer (S786) onto the studs .

**Fig. 5.** Install the Main Faceplate (21266-A or 21241-A) onto the studs using (4)  $\frac{3}{8}$  x 1" SHCS (S248).



**Fig. 6.** Install the Adjustment Bushing (S450) into the rear Alt Support.

**Fig. 7.** Install the Power Steering Adapter Bracket (21074-A) to the power steering Pump using (2)  $\frac{3}{8}$  x  $\frac{3}{4}$ " SHCS (S244) and (1)  $\frac{3}{8}$  x 1" Button Head Bolt (S309).



**Fig. 8.** Install the power steering pump (P304 or P9600) to the main bracket (21266-A or 21241-A) by stacking the two Spacers  $\frac{3}{8}$  x 1.680 (TP3-1.680) and  $\frac{3}{8}$  x 1.890 (TP3-1.890) together between the pump adapter (21074-A) and the rear support bracket (21262-A) using a  $\frac{3}{8}$  x  $\frac{3}{4}$ " SHCS (S277) to install the pump. If additional length is needed use supplied washers.



**Fig. 9.** Install the Alternator (P555) or (P9655) using a  $\frac{3}{8}$  x  $5\frac{1}{4}$ " SHCS (S279) and a  $\frac{3}{8}$ " lock nut (S622). Place a Billet Spacer Bushing (TP3-1.400) between the Alternator and the Adjust Set Screw (S450). Adjust S450 to take up any space between the lower alternator support and the spacer. (snug only at this time). Tighten lightly at this time.



**Fig. 10.** In the upper Alternator and Power Steering slots use the two (MM100) Alum. Bolt bushings and the (2)  $\frac{5}{16}$  x 1" (S146)

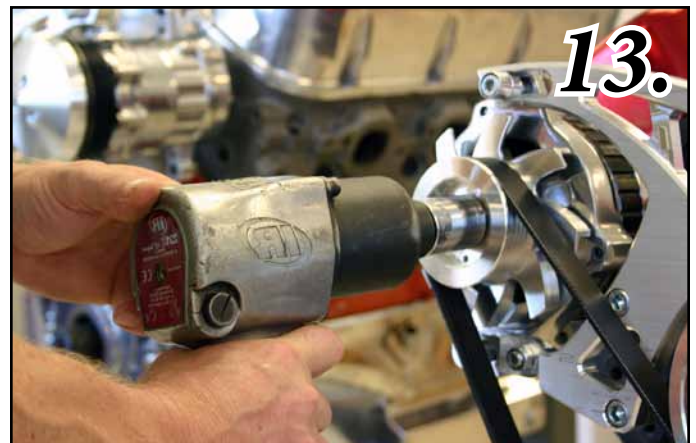


**Fig. 11.** Apply Loc-Tite to the threads of the (4)  $\frac{5}{16}$ -24 x  $\frac{5}{8}$ " SHCS (S183). Install adaptor ring (S716). Place water pump pulley (6302-A or 6307-A) to the water pump and thread the cap screws through pulley and into water pump pulley flange, tighten firmly (28 ft/lbs.)



**Fig 12.** Apply Loc-Tite to the threads of the (3)  $\frac{3}{8}$ -16 x 1" SHCS (S248). Place the crank pulley (7661-A) on damper and align holes. Thread the (3) screws through pulley and into damper, tighten firmly (50 ft/lbs.)

**Fig. 13.** Install alternator fan (221-A) and pulley (206-A) over the alternator shaft. Use the lockwasher (S685) and then tighten pulley nut (impact to 90 ft, pounds). Install Alt Cap (306-A) with (3) 8-32 x 1" SHCS (S028).



**Fig. 14.** Push the Alternator and A/C inward to their fullest position and Install a 64" belt belt.

**Fig. 15.** Slip the supplied March Adjustment tool (21206) 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.



## Final Assembly

Check and tighten all bracket bolts and alternator and Power Steering 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.

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- 1. Use and install the Product only for its intended purpose.
2. To avail yourself of this Limited Warranty, return the Product with a copy of the paid receipt, postage paid to: MARCH PERFORMANCE 16160 PERFORMANCE WAY NAPLES, FL 34110
3. When returning the Product, you must follow the directions set forth on the Warranty/Return Form on the reverse side of this Limited Warranty. If you no longer have the Warranty/Return Form, one may be obtained by contacting March Performance during normal business hours at: (888) 729-9070.
4. Shipping and/or transportation costs returning the Product to March Performance and any damage caused during shipping are your responsibility. March Performance will pay for shipping and/or transportation costs incurred in returning the Product to you.

LIMITED WARRANTY WARRANTY/RETURNS FORM

No product mounted is considered for credit unless it is a manufacturer defect.

All products returned for any reason must reference an authorization number (RGA). The RGA number is obtained by calling place of purchase during normal business hours. Any product returned without the RGA# written on the return package next to the return shipping label will be refused.

All returns must ship via UPS and be properly packaged in the original carton. Return freight charges are the responsibility of the customer unless the product was shipped in error.

March product returned after (1) year from date of purchase will not be accepted unless it is found to be a manufacturer defect. The customer must include a written statement describing the alleged product defect. The complete Limited Warranty is set forth on the reverse side.

- 100% credit issued on manufacturer defects
20% return fee on all reshelvable product
30% return fee on all repairable product

NO CREDIT WILL BE ISSUED ON RETURNED PRODUCT BEYOND REPAIR

March Performance thoroughly inspects all returns. It is the sole discretion of March Performance in determining the condition of all returned merchandise.

To receive replacements at no charge the original product must first be received and inspected by March Performance for determination. Immediate replacements may be purchased and later credited upon inspection determination.

Please Complete the Information below, detach and include with returned product.

Form fields for RGA#, CT#, Issued by, Date, Purchaser's Name, Phone, Address, Purchased Directly Through, Invoice#, Product ID, Invoice Date, Reason.

\*\* MOUNTED PRODUCTS ARE NONREFUNDABLE \*\*