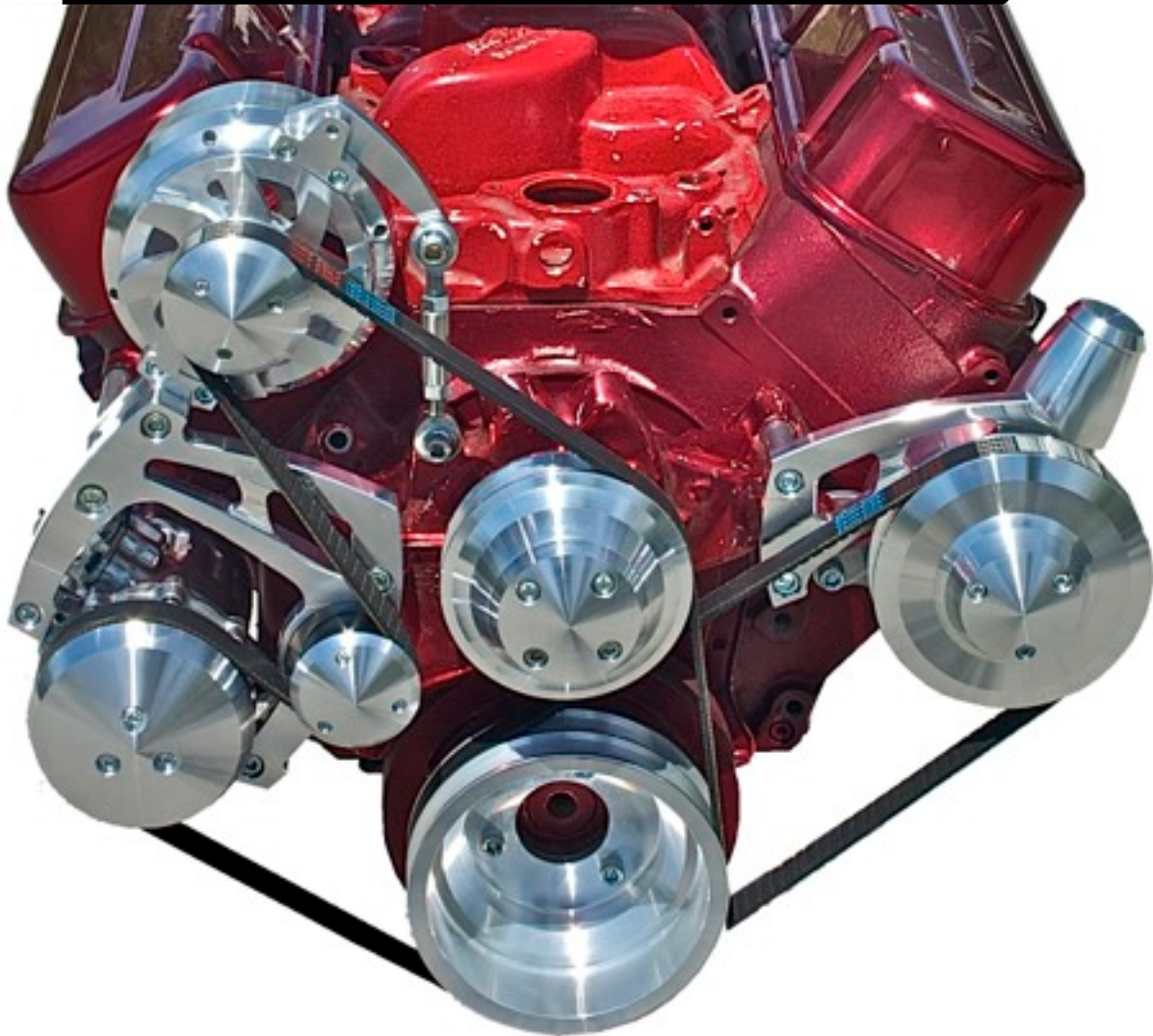




Rev: 9/25/12

**CHEVY BIG BLOCK LONG WATER PUMP
PERFORMANCE BILLET BRACKETS**



23073 KEYWAY P/S Bracket & Pulley Kit
23083 PRESS P/S Bracket & Pulley Kit
65 230+ Billet Alternator & Power Steering & A/C
75 230+ Chrome Alternator & Power Steering & A/C

Parts List:

20173 Alt & A/C Bracket

- 1 – 23681-A.....Alternator & AC Brkt
- 1 – 23681-B.....Alternator Rear Bracket
- 1 – 20129-B.....A/C Rear Support Brkt
- 1 – 20140-A.....Alt. Relocation Bracket
- 1 – S144.....5/16-18 x 7/8” SHCS
- 3 – S248.....3/8-16 x 1” SHCS
- 1 – RA-1.625.....Adjustment Rod 1-5/8”
- 2 – TP7-1.625.....Spacer Tube 1-5/8”
- 1 – TP7-2.000.....Spacer Tube 2”
- 1 – TP7-2.750.....Spacer Tube 2-3/4”
- 1 – S266.....3/8-16 x 3” SHCS
- 1 – S150.....5/16-18 x 1-1/2” SHCS
- 1 – S282.....3/8-16 x 6” SHCS
- 1 – S324.....3/8-16 x 2-1/4” Hex Bolt
- 2 – S358.....7/16-14 x 2-1/2” SHCS
- 1 – S376.....7/16-14 x 6” SHCS
- 2 – S550.....M8-1.25 x 20mm SHCS
- 1 – S616.....5/16 Lock Nut
- 1 – 740-A.....Idler Pulley
- 1 – 302-A.....Idler Pulley Cover
- 1 – S666.....3/8 Washer
- 2 – S260.....3/8-16 x 2-1/4” SHCS
- 3 – S022.....8-32 x 3/8” SHCS

20151 Power Steering Bracket

- 1 – 20151-A.....Bracket Body
- 2 – TP3-1.980.....Spacer Tube 1.980”
- 2 – S275.....3/8-16 x 4-1/4” SHCS
- 2 – S312.....3/8-16 x 1” Hex Bolt
- 1 – 20176-A.....Frt Lower Support Brkt
- 1 – 20176-B.....Rear Lower Support Brkt
- 1 – S268.....3/8-16 x 3-1/4” SHCS
- 2 – S311.....3/8-16 x 3/4” Hex Bolt
- 6 – S664.....3/8 x 1” Washer
- 3 – S666.....3/8 x 3/4” Washer

Pulley Kit

- 1 – 6322-A.....Water Pump Pulley
- 1 – 7336-A.....Crank Pulley
- 1 – 208-A.....Alternator Pulley
- 1 – 307-A.....Alternator Pulley Cover
- 1 – 221-A.....Alternator Fan
- 1 – 314-A.....WP Nose Cover
- 1 – 394-A.....A/C Cover
- 3 – S028.....8-32 x 1” SHCS
- 1 – S685.....Lock Nut
- 4 – S183.....5/16-18 x 5/8 SHCS
- 3 – S248.....3/8-16 x 1” SHCS
- 3 – S124.....1/4 x 3/4 Button Hd (or)
- 3 – S520.....M6 x 20mm Button Hd
- 1 – 623-A.....Keyway PS Pulley (or)
- 1 – 624-A.....Press Fit PS Pulley
- 1 – 360-A.....W/P Pulley Nose Cover
- 3 – S106.....1/4-20 x 1-1/4” SHCS

The following is included in Kits:

- 23073- Brkt & Pulley Kit for Keyed P/S
- 23083- Brkt & Pulley Kit for Press fit P/S
- BA23073- Brkt & Pulleys, Billet Alt & P/S & A/C Unit, Aluminum Water Pump
- CA23073- Brkt & Pulleys, Chrome Alt & P/S & A/C Unit, Aluminum Water Pump

I.D. Numbers for aftermarket parts in BA/CA Kits

Accessories

- P304 Chrome Power Steering Unit
- 9600 Billet Power Steering Unit
- P412 Chrome A/C Unit
- P411 Polished A/C Unit
- P555 Chrome Alternator Unit
- 9650 Billet Alternator Unit
- P126 Long Water Pump
- P417 A/C Line Adapter



Photo-1

Mount the Water Pump and gaskets, on the left side of the Water Pump use two 3/8 x 2-1/4" SHCS (S260) to hold the W/P in place.

Install the Alternator Bracket (23681-A) to the two tapped holes in the Water Pump. In the upper hole use a 3/8 x 1" SHCS (S248). In the lower hole use the (740-A) Idler Pulley a 3/8 Washer (S666) securing with a 3/8 x 2-1/4" Hex Bolt (S324). Then add the Idler Pulley Cap (302-A) using three 8-32 x 3/8 SHCS (S022).

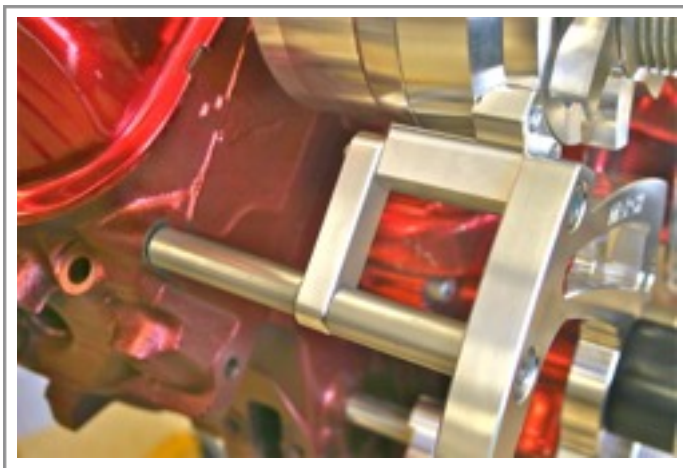
Photo-2

Install the Rear A/C Support (20129-B). Use two 7/16 x 2-1/2" SHCS (S358) and shim the bracket from the block using two (TP7-1.625) Spacer Tubes. 1-5/8" Long.



Photo-3

Mount the Alternator. First run the 3/8 x 6" SHCS (S282) or the 7/16 x 6" (S376) thru the bracket. Depending on the tapped hole in the head. Then on the back side of the bracket add a (TP7-2.000) Spacer Tube (2") the use the Alt Rear Support (23681B-09) then stack a 2-3/4" Spacer Tube (TP7-2.750) securing to the block as shown.



Now in the upper hole of the Main Bracket use a 3/8 x 3" SHCS (S266) to secure the alternator threading it into the Rear Alt Support as shown.

Photo-4

Mount the Alternator RE-locator (20140-A) to the top (backside) of the alternator ear with a 5/16 x 7/8 SHCS (S144). Then attach the (RA-1.625) Adjustment Rod to the RE-locator and the Water Pump with two 3/8 x 1" SHCS (S248). Now add the Alt. Fan (221-A) and the Alt. Pulley (208-A) using the (S685) Lock Nut then add the (307-A) Pulley Cap Using three 8-32 x 1" SHCS (S028).

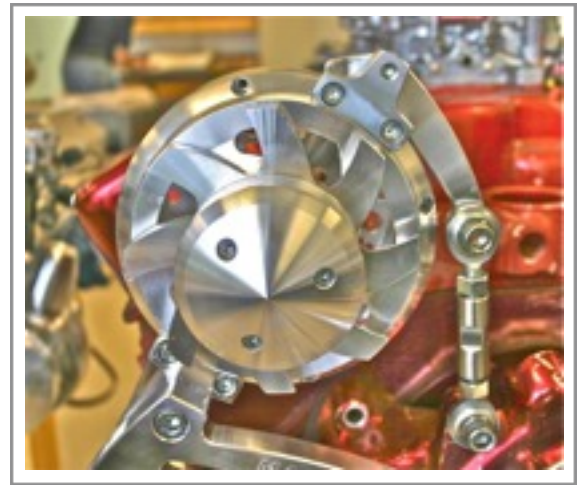


Photo-5

Mount the A/C unit to the two lower tangs using two M8 x 20mm SHCS (S550) Also add the (394-A) A/C Cover using three 1/4 x 3/4" Button Heads (S124) or three M6 x 20mm Button Heads (S520) depending on the clutch tapped holes.

Photo-6

Line up the rear A/C Support Bracket with the Rear A/C Ear and secure the two with a 5/16 x 1-1/2" SHSC (S150) and a 5/16 Lock Nut (S616).

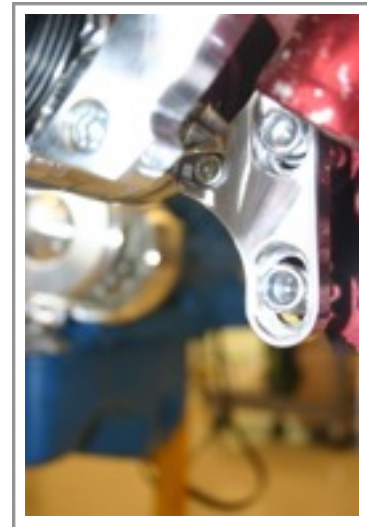


Photo-7

Mount the two Power Steering lower brackets (20176-A) on the front of the pump using two 3/8 x 3/4" Hex Bolts (S311). On the rear of the pump mount the (20176-B) using one 3/8 x 1" Hex Bolt (S312) and a 3/8 Washer (S666). Note: May require more than one (S666) depending on Water Pump mounting ear thickness.

Photo-8

Mount the front Power Steering Bracket (20151-A). Use two (TP3-1.980) Spacer Tubes and two 3/8 x 4-1/4" SHCS (S275).

Mount the Power Steering Pump to the thru hole on the Water Pump using a 3/8 x 3" SHCS (S266). NOTE: Extra Washers are provided due to different heights and locations of the P/S Mounting Boss. Use them as shims as needed to line up your P/S Unit with the Crank. Now thru the slot use a 3/8 Washer (S666) and a 3/8 x 1" Hex Bolt (S312).



Photo-9

Install the Crank Pulley (7336-A) using three 3/8 x 1" SHCS (S248). Now install the Water Pump Pulley (6322-A) and the Water Pump Pulley Cap (314-A) use four 5/16 x 5/8 SHCS (S183).

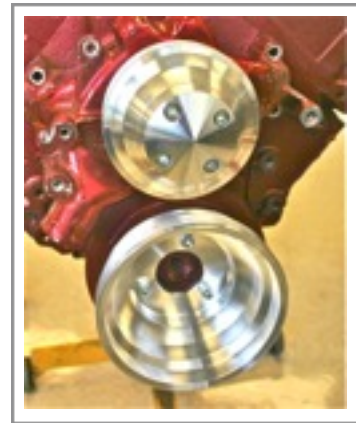


Photo-10

Install the Power Steering Pulley (623-A) Keyed or (624-A) Pressed. Photo shows optional P/S Nose Cover (360-A) with three 1/4-20 x 1-1/4" SHCS (S106).



Photo-11

Install the Power Steering Belt 42-1/2" and tighten the belt using the slot. Now install the Alt & A/C belt 62-1/2" and adjust with the 1-5/8 Adjuster Rod. Note: It may be necessary to disconnect the Adjustment Rod and tilt in Alt to install belt, then re-attach Adjustment Rod. Re-Check all bolts and pulleys and belt alignment before starting.

LIMITED WARRANTY

March Performance warrants to the original retail purchaser that for a period of ninety (90) days from the date of purchase, March Performance will repair or replace, at their option, any Product, which is found to be defective in material or workmanship.

Exclusions from Warranty Coverage

March Performance does not warrant any Product that is damaged from abuse, misuse or misapplication or not used for its intended purposes.

This Limited Warranty does not cover or apply to any damage or loss sustained to the engine or any other parts which may have been caused by the defective Product and does not cover or apply to any personal injury, labor charges or any other incidental costs for damages caused by the defective Product. THIS IS THE ONLY EXPRESS WARRANTY GIVEN WITH RESPECT TO YOUR PRODUCT. ALL OTHER EXPRESS WARRANTIES, GUARANTEES, OR STATEMENTS REGARDING THE PRODUCT, WHETHER WRITTEN OR VERBAL, ARE HEREBY DEEMED NULL AND VOID AND OF NO EFFECT.

Normal wear and tear and damage to the Product not caused by March Performance are also excluded from this Warranty.

DISCLAIMER OF OTHER WARRANTIES

EXCEPT TO THE EXTENT PROHIBITED BY APPLICABLE LAW, ANY IMPLIED WARRANTY WHETHER OF MERCHANTABILITY, FITNESS FOR A PARTICULAR PURPOSE, OR WARRANTY, SOME STATES DO NOT ALLOW LIMITATIONS ON HOW LONG AN IMPLIED WARRANTY WILL LAST SO THAT THE PRECEDING LIMITATION MAY NOT APPLY TO YOU.

Limitation on Remedies

REPAIR OR REPLACEMENT AS PROVIDED IN THIS WARRANTY IS YOUR EXCLUSIVE REMEDY. MARCH PERFORMANCE SHALL NOT BE LIABLE FOR ANY INCIDENTAL OR CONSEQUENTIAL DAMAGE FOR BREACH OF ANY EXPRESS OR IMPLIED WARRANTY ON THE PRODUCT. SOME STATES DO NOT ALLOW THE EXCLUSION OR LIMITATION OF INCIDENTAL OF CONSEQUENTIAL DAMAGES SO THE PROCEEDING LIMITATIO OR EXCLUSIONS MAY NOT APPLY TO YOU. YOU HAVE NO RECOURSE OR REMEDY FOR DAMAGE OR DEFECT CAUSED BY MISUSE, ABUSE OR NEGLIGENCE.

THIS WARRANTY GIVES YOU SPECIFIC RIGHTS AND YOU MAY ALSO HAVE OTHER RIGHTS, WHICH MAY VARY FROM STATE TO STATE.

Your Responsibilities:

- 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 **