



Highly Styled, Low Cost Serpentine Drive

Installation Instructions

Chevy Big Block Electric

Water Pump Bracket Kit

#23115 (Alternator A/C & Power Steering Pump)

#23110 (Alternator & A/C)



23110 / 23115 PARTS LIST

23111 Main Bracket

1	21201-A	Main Front Bracket
4	S338	3/8-16 x 2-1/2" Threaded Studs
4	S676	Water Pump Gaskets
4	S776	3/8 x 2.720 Spacers
4	S252	3/8-16 x 1-1/2" SHCS
1	S277	3/8-16 x 4-3/4" SHCS
2	S553	M8-1.25 x 35mm SHCS
1	S551	M8-1.25 x 25mm SHCS
1	TP3-.700	Tube Spacer .700"
2	MM100	Alum. Bushings

23112 Alt Rear Support Bracket

1	21202-A	Alt Rear Support Bracket
1	S450	Threaded Bushing

23113 A/C Bracket

1	21203-A	A/C Rear Support Bracket
1	S150	5/16-18 x 1-1/2 SHCS
1	TP3-.300	Tube Spacer .300"

23114 P/S Bracket

1	21204-A	P/S Bracket
2	S556	M8-1.25 x 40mm SHCS
2	S356	7/16-14 x 2-1/4"

23116 Left Idler Bracket Assembly

1	23101-A	Left Idler Bracket
1	740	Idler Pulley
1	S264	3/8-16 x 2-3/4" SHCS
1	S666	3/8 Washer
1	TP3-.650	Tube Spacer .650"

23117 Right Idler Bracket Assembly

1	23102-A	Right Idler Bracket
1	740	Idler Pulley
1	S264	3/8-16 x 2-3/4" SHCS
1	S666	3/8 Washer
1	TP3-.650	Tube Spacer .650"

Pulley Kit

1	7766-A	Crank Pulley
3	S248	3/8-16 x 1 SHCS
1	394-A	A/C Cover
3	S124	1/4-20 x 3/4" Button Head or
3	S520	M6-1.0 x 20mm Button Head
1	650-A	P/S Pulley
3	S144	5/16-18 x 7/8 SHCS
1	360-A	P/S Pulley Cap
3	S106	1/4-20 x 1-1/4 SHCS
1	345-A	W/P Pulley Cap
4	S048	10-24 x 4" SHCS
1	221-A	Alternator Fan
1	208-A	Alternator Pulley
1	307-A	Alternator Pulley Cap
3	S028	8-32 x 1 SHCS
1	S685	11/16 Lock Washer

Accessories

1	P820	Electric Water Pump
1	P315	P/S Pump
1	P572	Alternator
1	P412	A/C Unit
1	417	A/C manifold
1	P828	Radiator Adaptor

BLT-13 March Adjustment Tool

Belt Size

68" Belt	Kit #23110 (non – P/S)
70-1/2" Belt	Kit #23115

MARCH PERFORMANCE
1-888-729-9070

Required Tools And Materials

RVT Silicone	5/16 Allen Driver	11/16 Combo Wrench
Loc-Tite	1/4 Allen Driver	3/4 Combo Wrench
Anti-seize	6mm Allen Driver	Socket Wrench & Extensions
Gasket Scraper	5/8 Combo Wrench	M10 12 Pt. Socket
3/16 Allen Driver	9/16 Combo Wrench	

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 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 2 $\frac{1}{2}$ " mounting studs (S338) into the four water pump mounting holes $\frac{1}{2}$ " inch deep into block as shown. Using a sealer install (2) Paper Gasket (S676) over the studs.

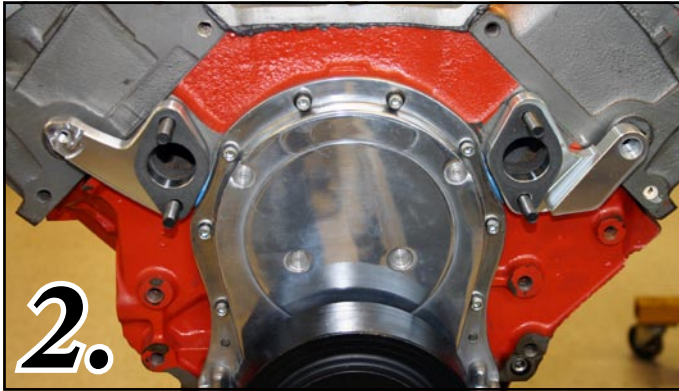


Photo-3 Slide the Electric Water Pump (P820) over the four studs, and secure with Four $\frac{3}{8}$ x 2.720 Long Threaded Spacers (S776). You can also add the Electric Water Pump Cover (345-A) at this time using the Four $1\frac{1}{32}$ x 4" SHCS (S048).

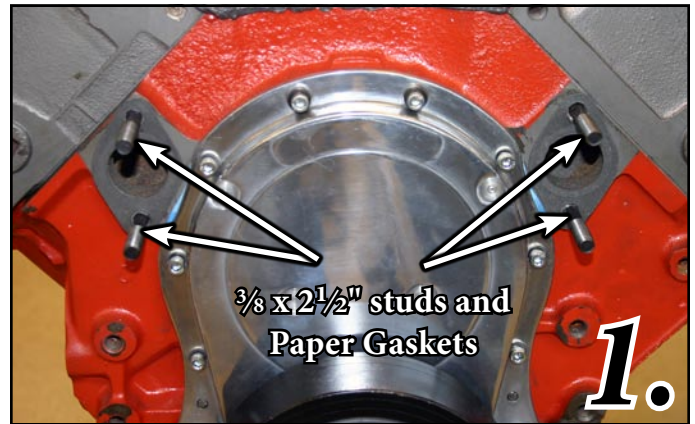
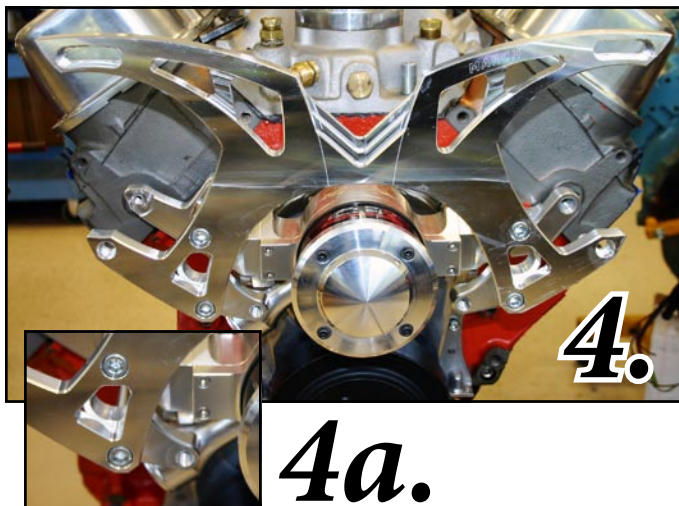


Photo-2 Slide the rear A/C Support (21203-A) and the rear Alt Support (21202-A) over the studs and using a sealer add the Second Pair of Gaskets (S676).

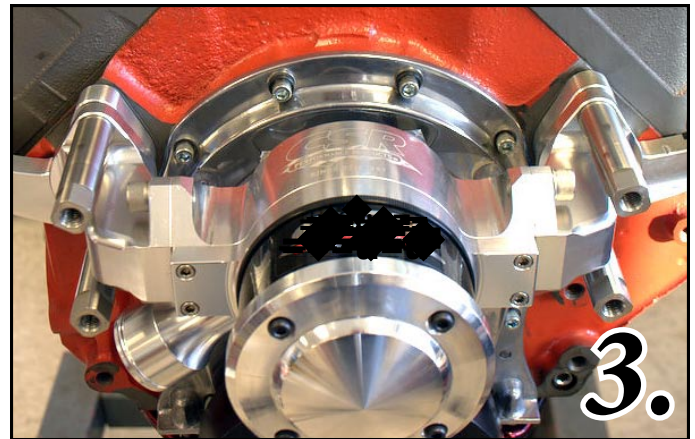


Photo-4 Using four $\frac{3}{8}$ x 1 $\frac{1}{2}$ " SHCS (S252) install the Main Front Plate (21201-A) along with the two Rear Idler Brackets (23101-A) Left Side and (23102-A) Right Side.

Photo-4a Note the Idler Brackets will mount behind the Main bracket with the tapped holes pointing inward to the centerline of the motor. Install the idler brackets and the main plate at the same time.

Photo-5 Install the rear Adjustment Spacer (S450) into the rear Alternator Support as Shown.

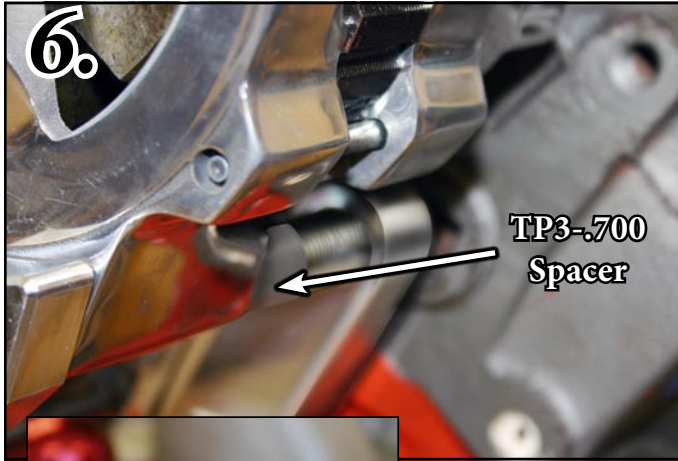


Photo-6 Using one $\frac{3}{8} \times 4\frac{3}{4}$ " SHCS (S277) through the Main Bracket, install the Alternator (P572), Put a .700 spacer (TP3-.700) behind the alternator mounting ear and adjust the Adjustment Spacer (S450) so its tight to the back of the alternator. In the upper slot use a MM100 Bushing and a M8 x 1.25 x 35mm SHCS (S553).

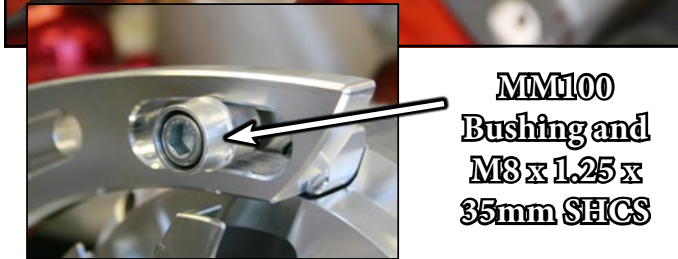


Photo-7 Installing the A/C Unit (P412), Thru the front top slot In the main Bracket install a M8x1.1.25 x 35 MM SHCS (S553) and a MM100 Bushing (as per Alternator side). Through the bottom Front of the main bracket use a M8 x 1.25 x 25mm SHCS. (S551) and Thru the Rear lower A/C Ear use a $\frac{5}{16} \times 1\frac{1}{2}$ " (S150) SHCS and use a $\frac{3}{8} \times .300$ (TP3.300) Spacer between the rear Support ear and the rear A/C ear as shown. Install the A/C Cover (394-A) with the provided button head Screws.

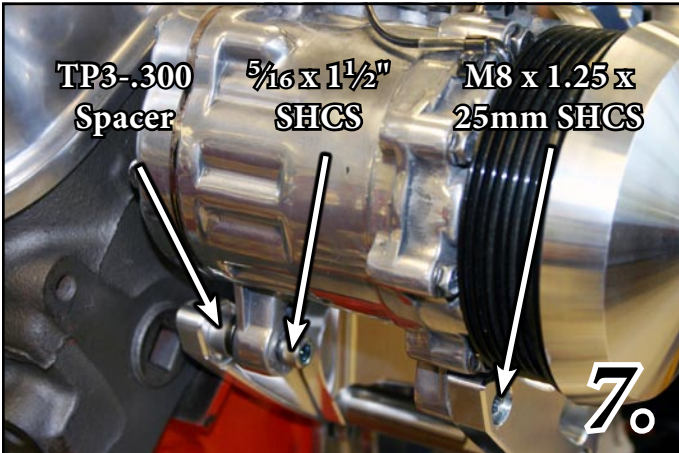
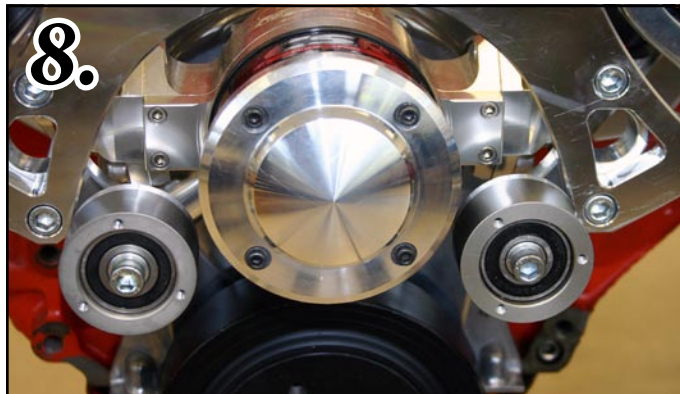


Photo-8 Using two $\frac{3}{8} \times 2\frac{3}{4}$ " SHCS (S264) and two $\frac{3}{8}$ " Washers (666) mount the Idlers (740) To the Idler Brackets.



Between the Idlers and the Idler Brackets use the two (TP3-.650) Aluminum Spacers. Install the Idler Caps (302-A) using (3) $\frac{8}{32} \times \frac{3}{8}$ " SHCS (S022).

Photo-9 Install Alternator Fan (221-A) and Pulley (208-A) over the alternator shaft. Use the lockwasher (S685) and then tighten pulley nut (impact to 90 ft, pounds). Install Alt Cap (307-A) with (3) $\frac{8}{32} \times 1$ " SHCS (S028).

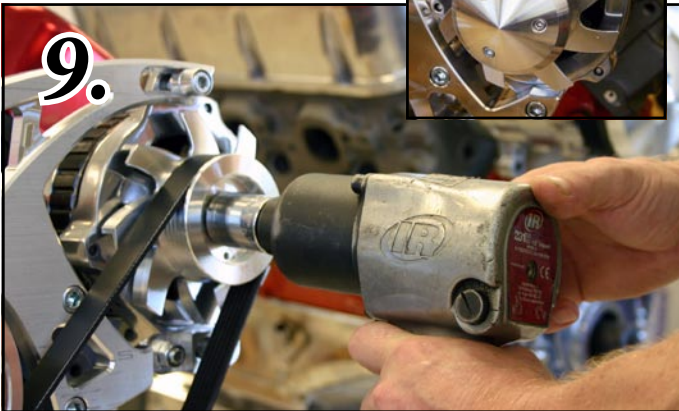
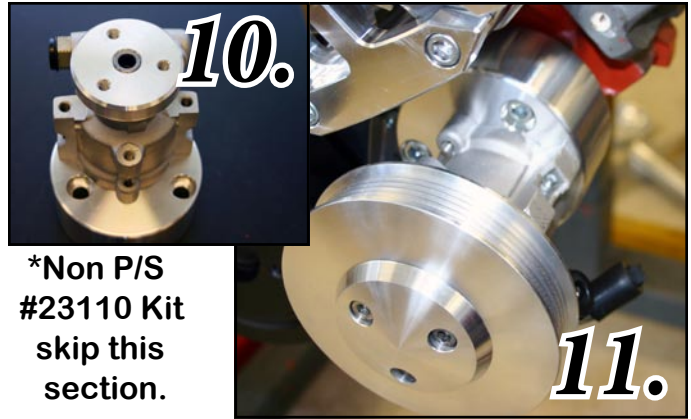


Photo-10 From the back of the Power Steering Bracket (21204-A) and using two M8 x 1.25 x 40mm SHCS (S556) mount the Power Steering unit (P315) noting the Position of the pump (*NOTE the back of the bracket has the 1-1/8 inch Hole.*)

Photo-11 Mount the Pump and Power Steering Bracket Unit to the block using two $\frac{7}{16}$ x $2\frac{1}{4}$ " SHCS (S356). Install the Power Steering Pump Pulley (650-A) with the three $\frac{5}{16}$ x $\frac{7}{8}$ " SHCS



***Non P/S
#23110 Kit
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section.**



Photo-12 Apply Loc-Tite to the threads of the (3) $\frac{3}{8}$ -16 x 1" SHCS (S248). Place the Crank Pulley (7666-A) on damper and align holes. Thread the (3) screws through pulley and into damper, tighten firmly (50 ft/lbs.)

Photo-13 Push the Alternator and A/C inward you may have to remove one of the MM100 bushings and the bolt. Install the 70 $\frac{1}{2}$ " Long Belt routing as shown.
*68" Belt for Non-P/S Kit #23110

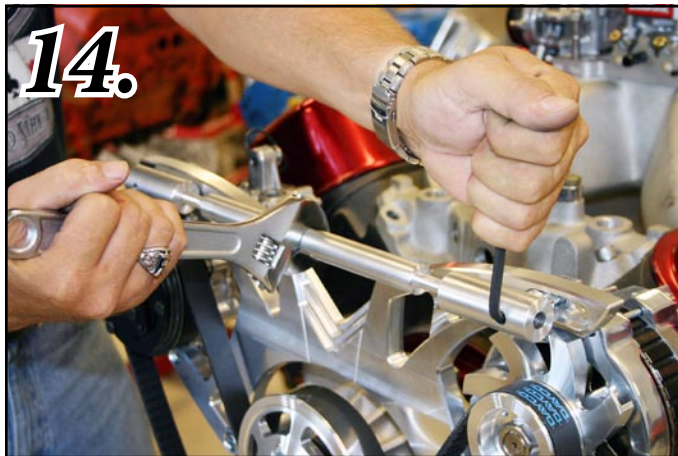
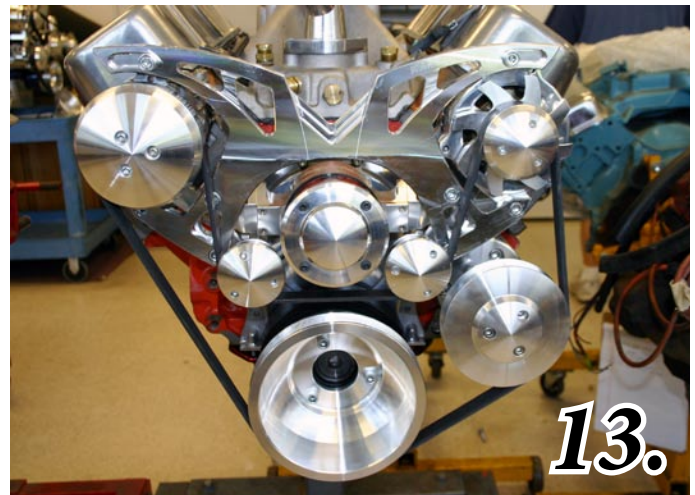


Photo 14 Slip the supplied March Adjustment Tool over the two (MM100) bushings. Use a wrench to turn the adjustment tool outward to tighten the serpentine belt to 100 ft. lbs. Use the holes in the adjustment tool to tighten both 8M socket head cap screws when correct belt tension has been achieved. Remove 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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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.

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

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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.

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