



SPORT TRACK ULTRA SERPENTINE KIT
23610 ALT/AC ONLY
23615 ALT/AC/REMOTE P/S
23620 ALT/AC/SAGINAW P/S

PARTS LIST

MAIN FRONT BRACKET P/N 23611

- 1 - 23611-A.....Main Front Bracket
- 6 - S248.....3/8 x 1" SHCS
- 4 - S339.....3/8-16 x 3" Threaded Stud
- 1 - S550.....M8-1.25 x 20mm SHCS
- 2 - S553.....M8-1.25 x 35mm SHCS
- 2 - S622.....3/8" Lock Nut
- 4 - S785.....3" Threaded Spacer
- 2 - MM100-A.....Aluminum Bolt Cap

ALT REAR SUPPORT BRACKET P/N 21202

- 1 - 21202-A.....Alternator Rear Support
- 1 - S277.....3/8 x 4-3/4" SHCS
- 1 - S452.....5/8" Threaded Bushing
- 2 - S676.....Water Pump Gaskets
- 1 - AC3-1.2501.250 Alum Spacer

A/C REAR SUPPORT BRACKET P/N 21203

- 1 - 21203-A.....A/C Rear Support
- 1 - S150.....5/16 x 1-1/2" SHCS
- 2 - S676.....Water Pump Gaskets
- 1 - TP3-.300Tube Spacer .300 Long

POWER STEERING BRACKET P/N 40724

(For kit 23615 w/Remote Power Steering)

- 1 - 40724-A.....Power Steering Bracket
- 2 - S551.....M8-1.25 x 25mm SHCS

POWER STEERING BRACKET P/N 21205-09

(For kit 23620 w/Saginaw Power Steering)

- 1 - 21205A-09.....P/S Front Bracket
- 1 - 21205B-09.....P/S Rear Bracket
- 1 - 20115C-09.....P/S Spacer Block
- 2 - S3113/8 x 3/4" Hex Head Bolts
- 1 - S325.....3/8 x 1" Flat Head Bolt
- 2 - S369.....7/16 x 4" SHCS
- 1 - TP3-.150Tube Spacer .150 Long

BELT TENSIONER TOOL BLT-13

- 1 - MM101-A.....Right Hand Rod End
- 1 - MM102-A.....Left Hand Rod End
- 1 - MM105-A.....13" Threaded Rod

CHEVY BIG BLOCK PULLEY KIT P/N 23610-206

- 1 - 7666-A.....Crank Pulley
- 1 - 6308-A.....W/P Pulley
- 1 - 398-A.....A/C Clutch Cover
- 1 - 306-A.....Alternator Pulley Cap
- 1 - 225-A.....Alternator Fan
- 1 - 206-A.....Alternator Pulley Body
- 1 - S716W/P Pulley Bushing
- 1 - S685.....Alternator Lock Washer
- 3 - S520M6-1.0 x 20mm Button Head
- 3 - S2483/8 x 1" SHCS
- 4 - S1865/16 x 7/8" SHCS
- 3 - S1241/4 x 3/4" Button Head
- 3 - S0288-32 x 1" SHCS

(For kit #23615)

- 1 - 652-A.....Power Steering Pulley
- 3 - S1445/16 x 7/8" SHCS

(For kit #23620)

- 1 - 541-A.....Keyway Power Steering Pulley
- 1 - 302-A.....Power Steering Nose Cover
- 3 - S0228-32 x 3/8" SHCS

ACCESSORIES

- 1 - P125Alum Water Pump
- 1 - P412A/C Compressor
- 1 - P572Alternator
- 1 - 417.....A/C Line Adapters

- 1 - P314Remote Power Steering Pump

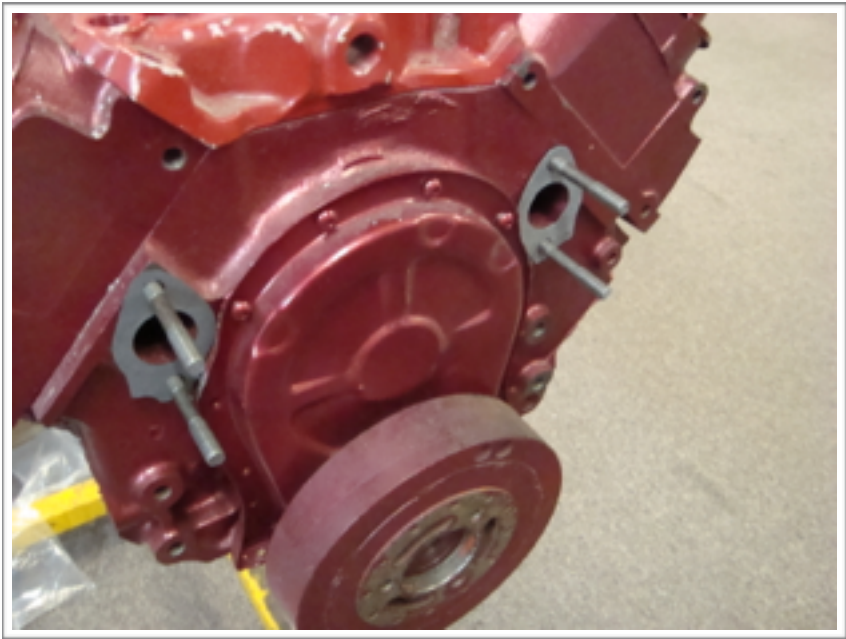
(For Kit # 23615)

- 1 - P304Saginaw Power Steering Pump

(For Kit # 23620)

Photo 1

Ensure the sealing face of coolant ports are clean, flat and clear of old gasket material. Apply a small amount of RTV silicone to one end of each mounting stud to prevent leakage. Install four 3/8 x 3" mounting studs (S339) into the four water pump mounting holes 1/2" deep into block. Install two (S676) gaskets of each pair of mounting studs.

**Photo 2**

Install the alternator rear support bracket (21202-A) on the drivers side, and the a/c rear support (21203-A) on the passenger side of engine. Use the second pair of gaskets and apply one each to the face of each of the rear support brackets.

**Photo 3**

Install the water pump (P125) over the mounting studs and secure with three 3" threaded spacers (S785) as shown and tighten down water pump.



Photo 4

Install front main bracket (23611-A) to the four threaded studs using four 3/8 x 1" SHCS (S248).

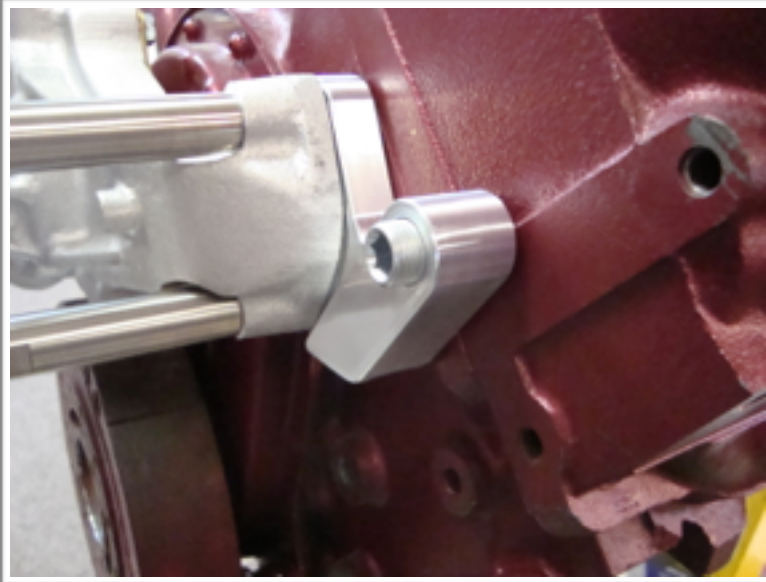


Photo 5

Install 5/8-18 threaded adjustment bushing (S452) into rear alternator support bracket as shown.



Photo 6

Install the alternator (P572) using a 3/8 x 4-3/4" SHCS (S277) and install the aluminum spacer (AC3-1.250) and adjust any space with the adjustment bushing (S452).

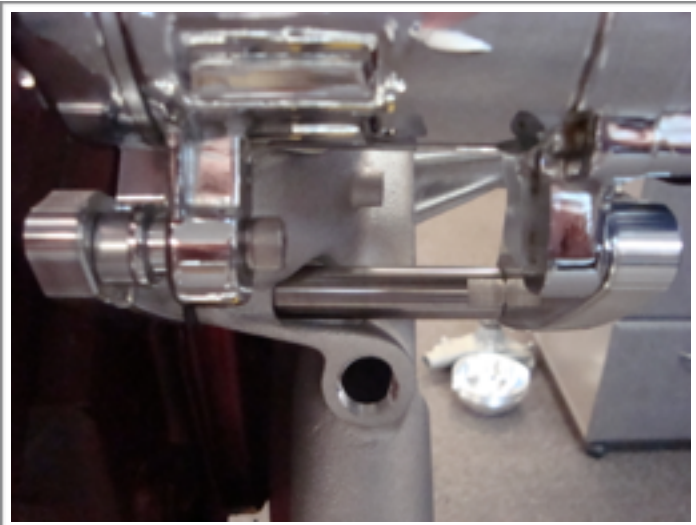


Photo 7

Install a/c unit (P412) using a M8 x 20mm SHCS (S550) in the lower front hole and a 5/16 x 1-1/2" (S150) in the rear lower hole. Use a .300 Spacer (TP3-.300) between the rear a/c bracket and rear ear of a/c unit as shown.

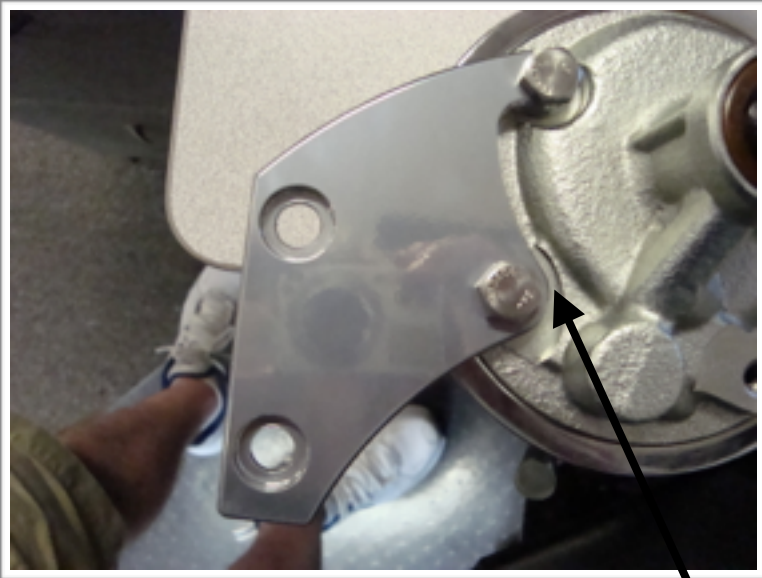
FOR KIT 21615 WITH REMOTE POWER STEERING. IF NOT RUNNING POWER STEERING OPTIONS SKIP TO PHOTO 11.

Photo 8
Install power steering pump (P314) to power steering bracket (40724-A) using two M8 x 25mm SHCS (S551). Then install power steering pump and bracket to front main bracket to the two lower holes with two 3/8 x 1" (S248) SHCS and tighten down. If **NOT** running any power steering use the same bolts to fill in lower holes and install two 3/8" lock nuts (S622)



FOR KIT 21620 WITH SAGINAW POWER STEERING.

Photo 9
Mount the front bracket (21205A-09) to front of power steering pump (P304) with two 3/8 x 3/4" hex head bolts. On the rear of pump install the rear support bracket (21205A-09) to rear of pump with one 3/8 x 1" flat head bolt (S325) with a .150 spacer (TP3-.150) between pump and bracket.



Front of power steering pump.



Rear of power steering pump.

Photo 10
Use the spacer block (20115C-09) between the two pump brackets. Install to lower mounting holes on the driver's side of engine using two 7/16 x 4" SHCS (S369).

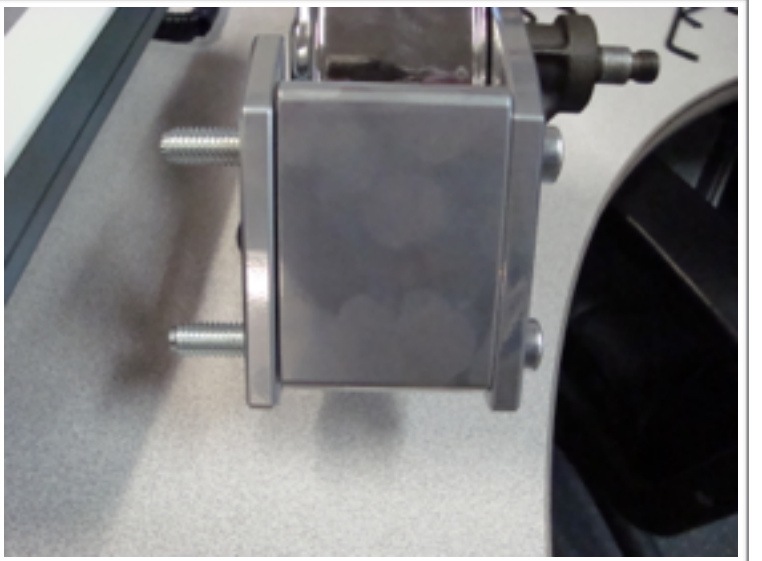


Photo 11

Install water pump adapter bushing (S716) over water pump pilot shaft as shown.



Photo 12

Install water pump pulley (6308-A) to water pump flange and tighten down with four 5/16 x 7/8" SHCS (S186) bolts.



Photo 13

Apply Loc-Tite to the threads of the three 3/8 x 1" SHCS (S248). Place the crank pulley (7666-A) onto the harmonic balancer and tighten firmly down with supplied bolts.



FOR KITS WITH REMOTE POWER STEERING, KIT 23615.

Photo 14

Install power steering (652-A) to power steering flange with three 5/16 x 7/8" SHCS (S144) and tighten firmly.

FOR KITS WITH SAGINAW POWER STEERING, KIT 23620.

Photo 15

Install power steering (541-A) to power steering shaft aligning pulley with keyway. Tighten down pulley with supplied lock nut. Next install (302-A) nose cover and tighten down with three 8-32 x 3/8" SHCS (S022).

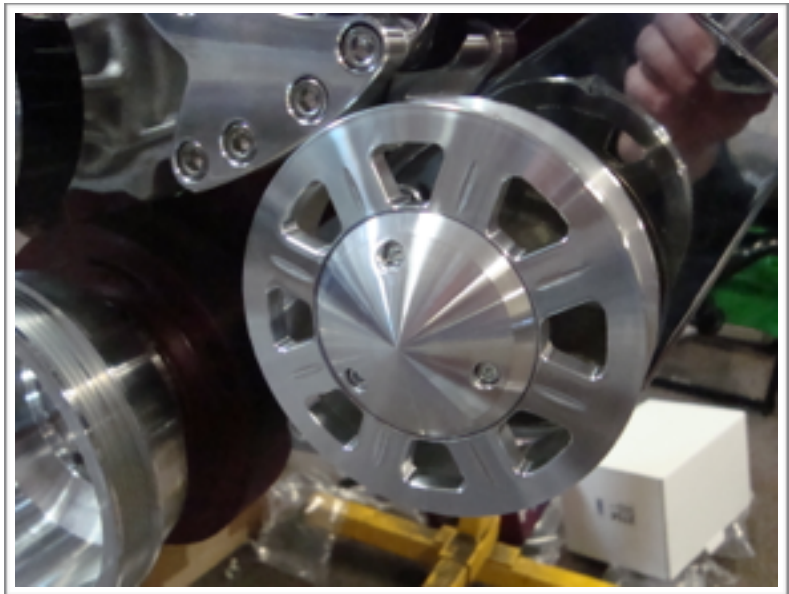


Photo 16

Next swing the alternator and a/c compressor inward and install each one with a MM100 bushing and running a M8 x 35mm SHCS (S553) through the bushing and into the mounting ears of each component. Leave loose at this time.

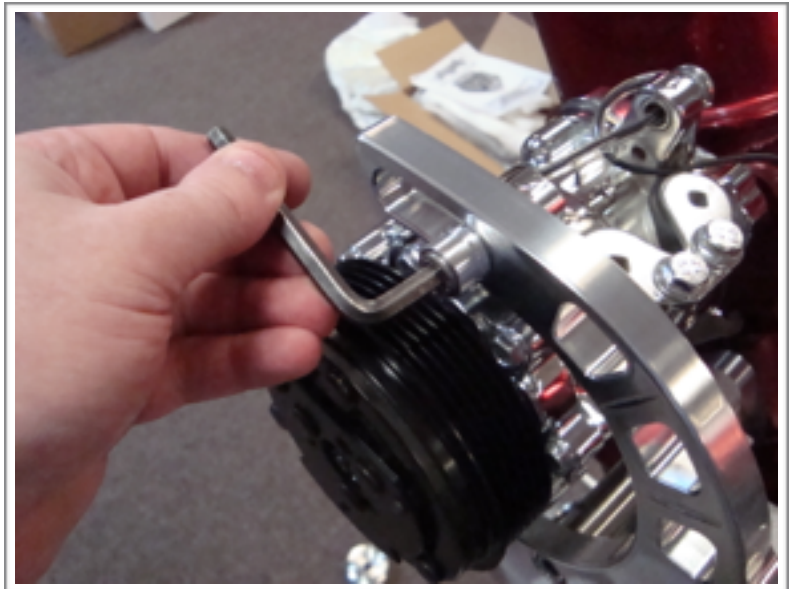


Photo 17

Install alternator fan (225-A), then alternator pulley (206-A). Install (S685) lock washer and supplied lock nut and impact pulley onto alternator shaft. Next install alternator pulley cap (306-A) with three 8-32 x 1" SHCS (S028) bolts.



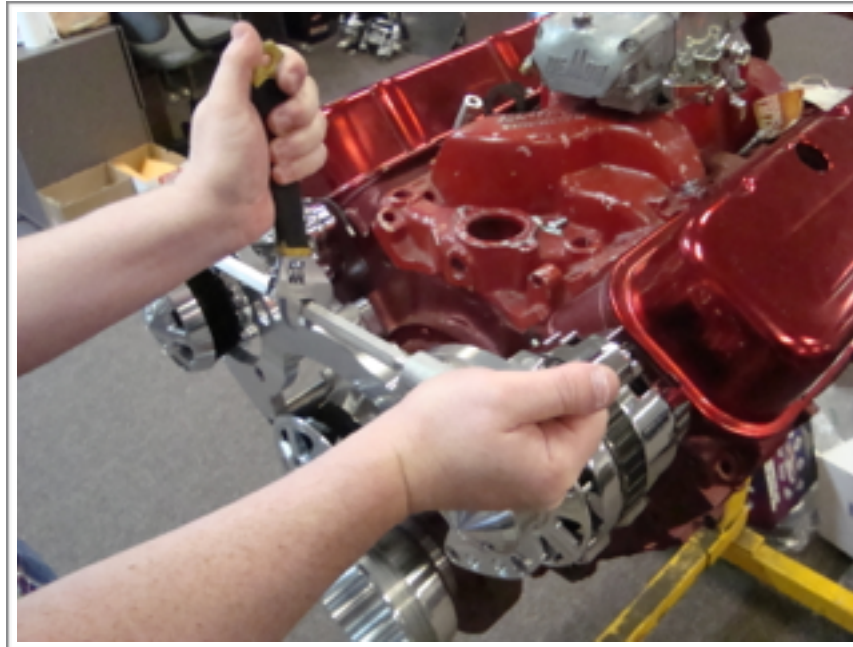


Photo 18

Install a/c clutch cover (398-A) to compressor using either the M6 x 20mm SHCS (S520) or 1/4 x 3/4" (S124) button head bolts depending on your clutch and tighten. **Caution: DO NOT over-tighten or clutch may lock up.**

Photo 19

Push the alternator and a/c compressor to their most inward position and install a 65" belt Dayco (5060650) for non-power steering. For kits with power steering use a 68-1/2" belt Dayco (5060685). **(NOTICE: Due to some variations in belt sizes it may be necessary to remove one of the (S553) and aluminum bushing and moving the loose component all the way in to install belt.)** Slip the supplied adjustment tool over the aluminum bushings and tighten outward to tighten serpentine belt. Once tight, lock down the (S553) bolts and remove tool and keep for future use. Check and tighten all bolts, if hooking up a/c next, install supplied a/c line adapter to compressor and continue on with installation. If **NOT** hooking up a/c at this time do not wire up compressor or remove cover plate off compressor.



Tech Support:

1-888-729-9070

info@marchperformance.com

www.marchperformance.com