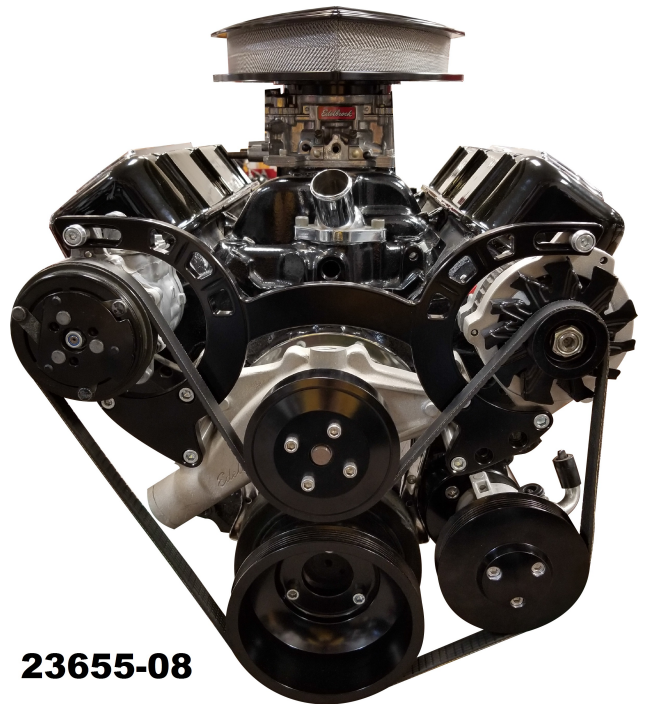
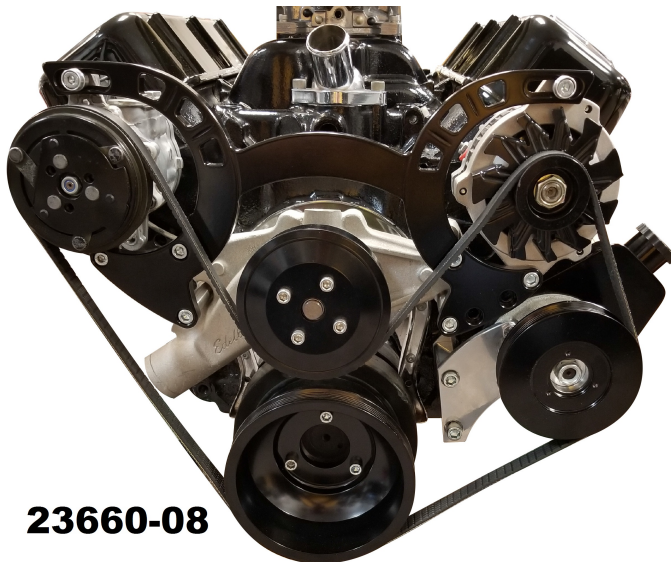


**23650-08**



**23655-08**



**23660-08**

# Instructions for kits 23650-08, 23655-08 & 23660-08

# PARTS LIST

## MAIN FRONT BRACKET P/N **23611-08**

- 1 - 23611A-08.....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 **21202-08**

- 1 - 21202A-08.....Alternator Rear Support
- 1 - S277.....3/8 x 4-3/4" SHCS
- 1 - S452.....5/8" Threaded Bushing
- 2 - S676.....Water Pump Gaskets
- 1 - AC3-1.250 .....1.250 Alum Spacer

## A/C REAR SUPPORT BRACKET P/N **21203-08**

- 1 - 21203A-08.....A/C Rear Support
- 1 - S150.....5/16 x 1-1/2" SHCS
- 2 - S676.....Water Pump Gaskets
- 1 - TP3-.300 .....Tube Spacer .300 Long

## POWER STEERING BRACKET P/N **40724-08**

**(For kit 23655-08 w/Remote Power Steering)**

- 1 - 40724A-08.....Power Steering Bracket
- 2 - S551.....M8-1.25 x 25mm SHCS

## POWER STEERING BRACKET P/N **21205-09**

**(For kit 23660-08 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 - S311 .....3/8 x 3/4" Hex Head Bolts
- 1 - S325.....3/8 x 1" Flat Head Bolt
- 2 - S368.....7/16 x 3 3/4" SHCS
- 1 - TP3-.150 .....Tube 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 **23605-08**

- 1 - 7666A-08 .....Crank Pulley
- 3 - S248 .....3/8 x 1" SHCS
- 1 - 6303A-08 .....W/P Pulley
- 1 - S716 .....W/P Pulley Bushing
- 4 - S183 .....5/16 x 5/8" SHCS

**(For kit 23655-08)**

- 1 - 650A-08 .....Power Steering Pulley
- 3 - S144 .....5/16 x 7/8" SHCS

**(For kit 23660-08)**

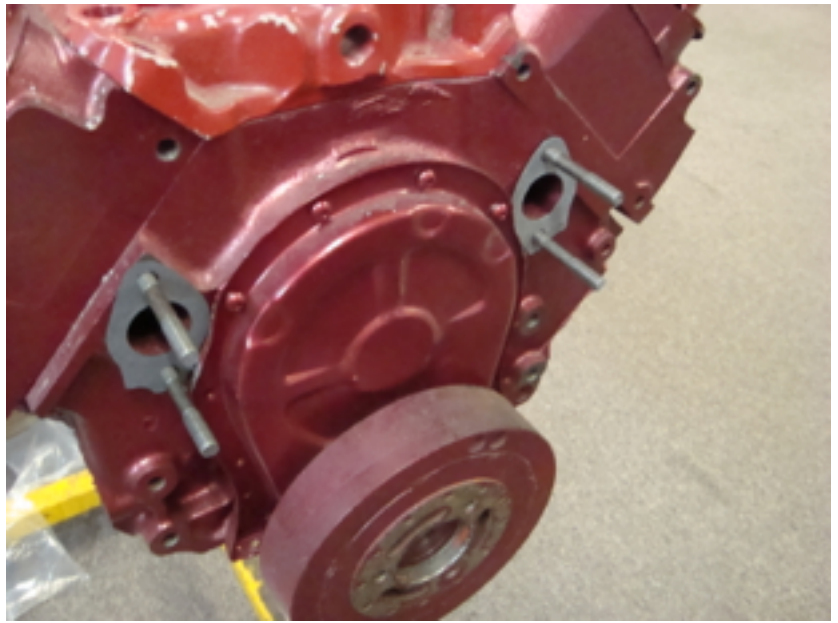
- 1 - 535A-08 .....Keyway Power Steering Pulley

## ACCESSORIES

- 1 - P125 .....Alum Water Pump
  - 1 - P425 .....A/C Compressor
  - 1 - P566 .....Alternator with fan and pulley
  - 1 - 419.....A/C Line Adapters
  
  - 1 - P314 .....Remote Power Steering Pump
- (For Kit # 23655-08)**
- 1 - P300 .....Saginaw Power Steering Pump
- (For Kit # 23660-08)**

**Photo 1**

Make sure the sealing surface of the 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 (21202A-08) on the drivers side, and the a/c rear support (21203A-08) on the passenger side of engine. Use two more gaskets (S676) and apply one each to the face of each of the rear support brackets.

**Photo 3**

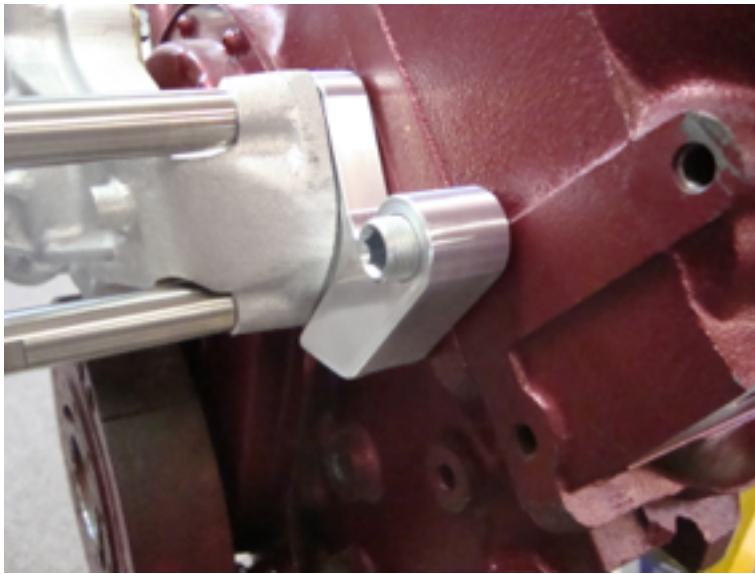
Install the water pump (P125) over the mounting studs and secure with four 3" threaded spacers (S785) as shown and tighten down water pump.





**Photo 4**

Install front main bracket (23611A-08) to the four threaded spacers using four 3/8 x 1" SHCS (S248).



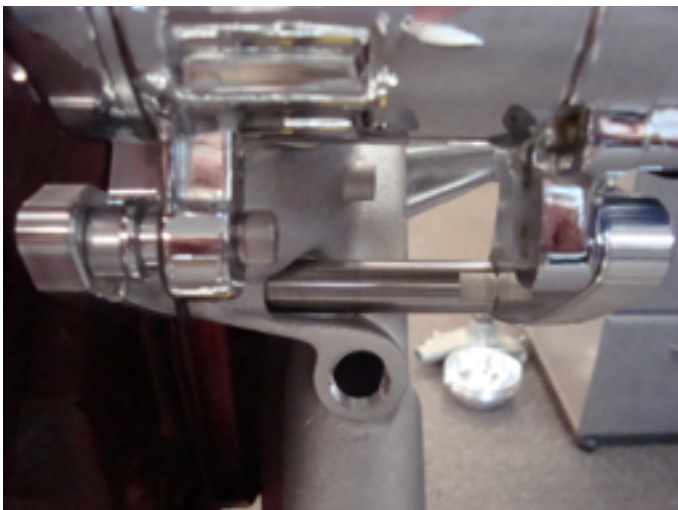
**Photo 5**

Install 5/8-18 threaded adjustment bushing (S452) into rear alternator rear support bracket 21202A-08 as shown.



**Photo 6**

Install the alternator (P566) using a 3/8 x 4-3/4" SHCS (S277) with the aluminum spacer (AC3-1.250) in between brackets and adjust any space with the adjustment bushing (S452).



**Photo 7**

Install a/c unit (P425) 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.



If not using a power steering pump. Install two 3/8-16 x 1" SCHS (S248) with two 3/8 lock nuts (S622) on lower driver side of main front bracket to fill p/s bracket mounting holes. **Now go to photo 11**



**For kit 23655-08 with remote power steering.**

**Photo 8**

Install power steering pump (P314) to power steering bracket (40724A-08) using two M8 x 25mm SHCS (S551). Then install power steering pump and bracket to the front main bracket driver side two lower holes with two 3/8 x 1" (S248) SHCS and tighten down.

**For kit 23660-08 with Saginaw power steering.**

**Photo 9**

Mount the front bracket (21205A-09) to front of power steering pump (P300) with two 3/8 x 3/4" (S311) hex head bolts. On the rear of pump first remove stud from pump. Then install the rear support bracket (21205B-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. **NOTE: These brackets are silver powder coated and only available in this finish.**



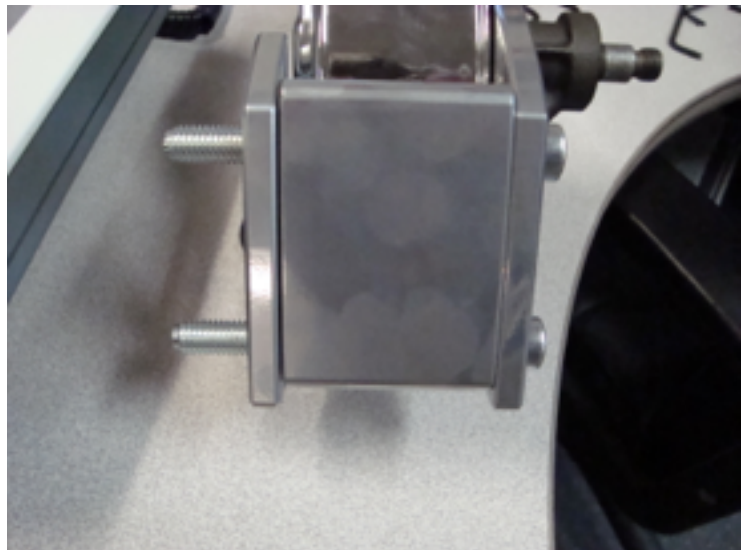
Front of power steering pump.



Rear of power steering pump.

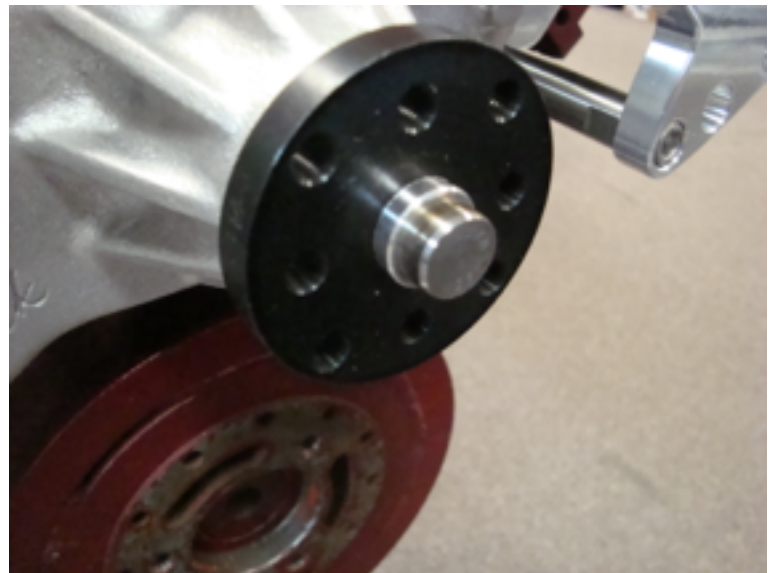
**Photo 10**

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 3 3/4" SHCS (S368).



**Photo 11**

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



**Photo 12**

Install water pump pulley (6303A-08) to water pump flange and tighten down with four 5/16 x 5/8" SHCS (S183) bolts.



**Photo 13**

Apply Loc-Tite to the threads of the three 3/8 x 1" SHCS (S248). Place the crank pulley (7666A-08) onto the harmonic balancer and tighten firmly down with supplied bolts.



**For kit with remote power steering  
# 23655-08**

**Photo 14**

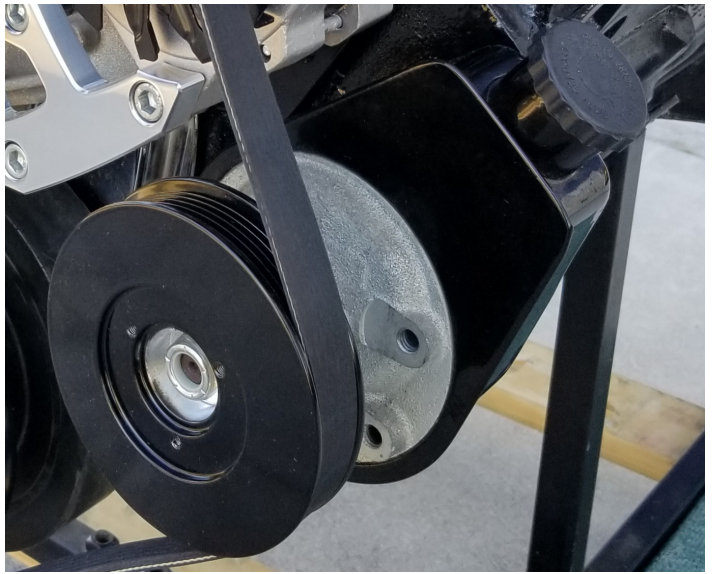
Install power steering (650A-08) to power steering flange with three 5/16 x 7/8" SHCS (S144) and tighten firmly.



**For kits with Saginaw power steering # 23660-08.**

**Photo 15**

Install power steering (535A-08) to power steering shaft aligning pulley with keyway. Tighten down pulley with supplied lock nut.



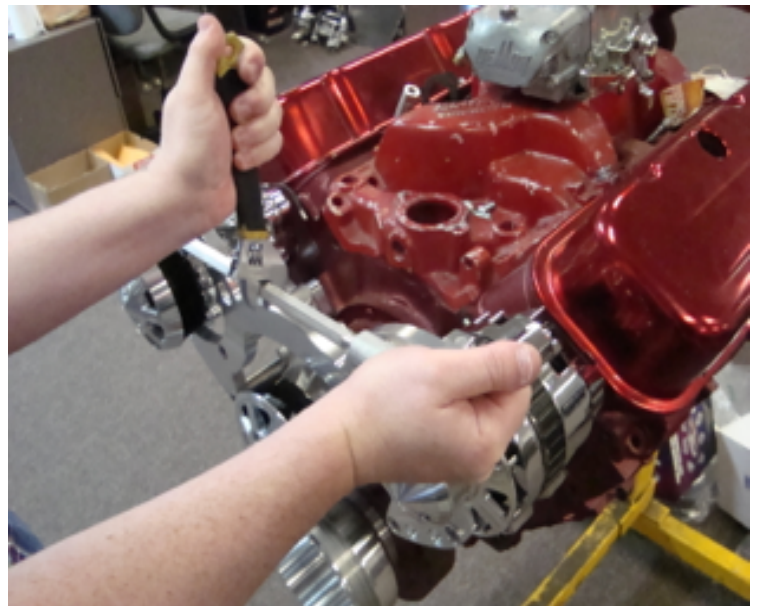
**Photo 16**

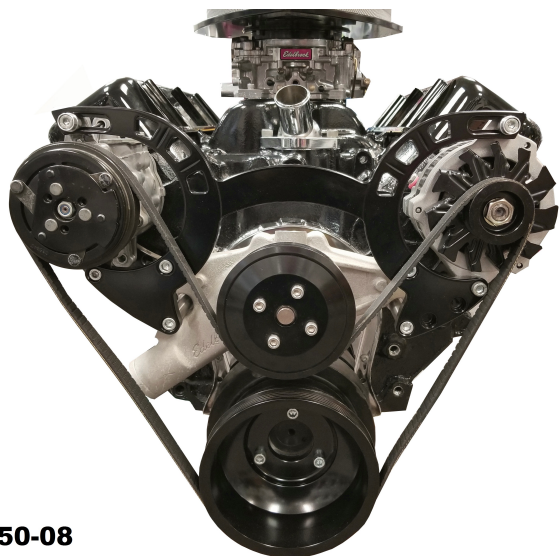
Next swing the alternator and a/c compressor inward and install each one with a MM100 bushing and running a M8 x 35mm SHCS (S553) through the bushing and into the mounting ears of each component. Leave loose at this time.



**Photo 17**

Push the alternator and a/c compressor to their most inward position and install Dayco brand 6 rib belt. See next page for belt routing and belt lengths. **(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 installing a/c lines, next install supplied a/c line adapter (419) to compressor and continue with a/c charging procedures. If NOT charging a/c at this time do not wire up compressor or remove cover plate off compressor.





**23650-08**

**Kit 23650-08** will require a 65" 6 rib belt.  
We recommend **Dayco part # 5060650**



**23655-08**

**Kit 23655-08** will require a 67.5" 6 rib belt. We recommend **Dayco part # 5060690**



**23660-08**

**Kit 23660-08** will require a 69" 6 rib belt. We recommend a **Dayco part # 5060690**