

Install Instructions
Kits 25100 & 25110

Parts List

25116 Alternator & a/c bracket

- 1-25116-A.....alternator & a/c main bracket
- 1-25116-B.....a/c rear support bracket
- 1-759-A.....tensioner cover
- 1-P758.....automatic tensioner
- 1-TP3-1.040....tube spacer 1.040" long
- 1-TP3-1.630....tube spacer 1.630" long
- 2-S022.....8-32 x 3/8" shcs
- 1-S146.....5/16-18 x 1" shcs
- 1-S160.....5/16-18 x 2 3/4" shcs
- 1-S216.....5/19-18 x 2" hex bolt
- 2-S248.....3/8-16 x 1" shcs
- 1-S282.....3/8-16 x 6" shcs
- 4-S338.....3/8-16 x 2 1/2" stud
- 2-S551.....8mm x 1.25 x 25mm shcs
- 2-S616.....5/16-18 lock nut
- 4-S660.....5/16" washer
- 2-S775.....threaded spacer 2.720" long
- 2-S777.....threaded spacer 2.820" long

25114 Power steering bracket

- 1-25114-A.....power steering main bracket
- 1-25114-B.....power steering rear bracket
- 2-TP3-.150....tube spacer .150" long
- 1-TP3-.300....tube spacer .300" long
- 2-TP3-.400....tube spacer .400" long
- 1-TP3-.700....tube spacer .700" long
- 4-S248.....3/8-16 x 1" shcs
- 2-S316.....3/8-16 x 3/4" button bolts
- 1-S322.....3/8-16 x 1 1/2" hex bolt
- 1-S323.....3/8-16 x 2" hex bolt
- 2-S666.....3/8 x 3/4" o.d. washer

25100-206 Pulley kit

- 1-6371-A.....crank pulley
- 3-S292.....3/8-24 x 1" shcs
- 1-2012-A.....water pump pulley
- 1-319-A.....water pump pulley cover
- 4-S550.....8mm x 1.25 x 20mm shcs
- 1-221-A.....alternator fan
- 1-206-A.....alternator pulley
- 1-S685.....11/16 lock washer
- 1-306-A.....alternator pulley cover
- 3-S028.....8-32 x 1" shcs
- 1-360-A.....power steering pulley cover
- 3-S106.....1/4-20 x 1 1/4" shcs
- 1-394-A.....a/c clutch cover
- 3-S124.....1/4-20 x 3/4" button hd bolt
- 3-S520.....6mm x 1.0 x 20mm button hd bolt

Power steering pulleys

- 1-623-A.....keyway (kit 25100)
- or
- 1-624-A.....press fit (kit 25110)

shcs= socket head cap screw

For technical questions please call 888-729-9070

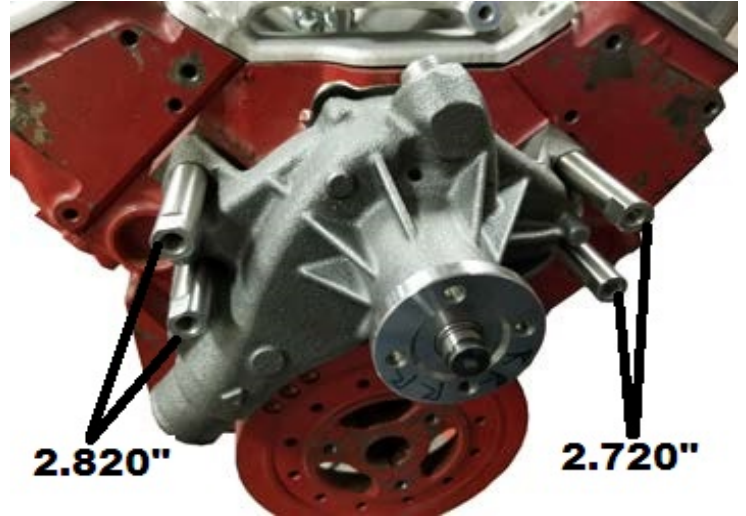


Step 1

Install four of (S338) 3/8-16 x 2 1/2" studs into the engine block water pump mounting holes. Now install water pump gaskets.

Step 2

Slide the water pump (1988 to 1995 reverse rotation long water pump) over the four studs. On the passenger side install two of (S777) 3/4" o.d. x 2.820" long stainless spacers. On the driver side install two (S775) 3/4" o.d. x 2.720" stainless spacers.



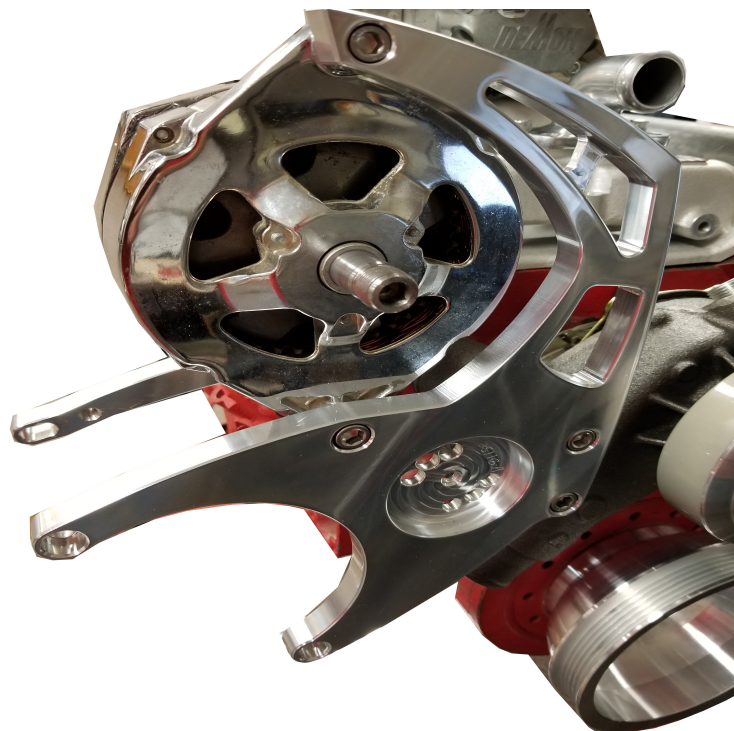
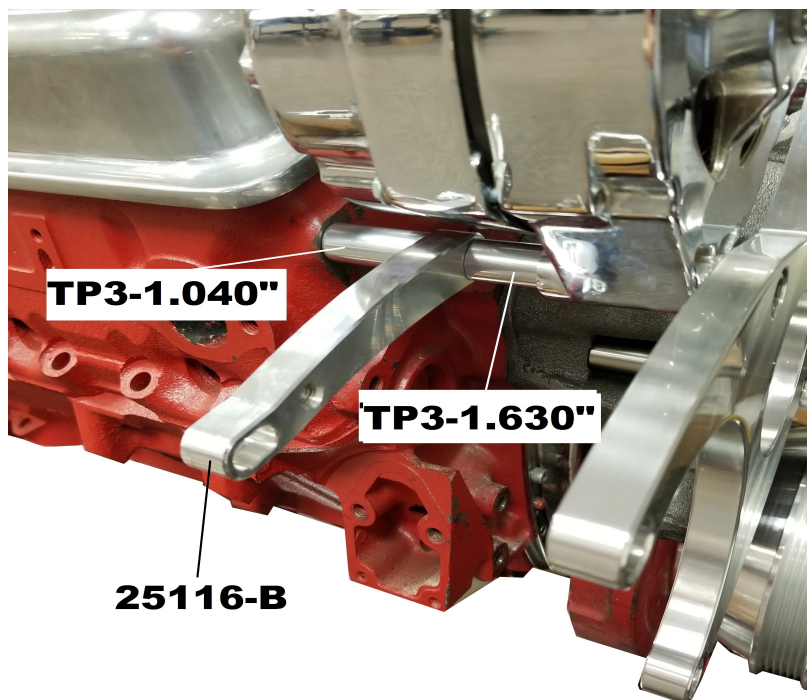
Step 3

Install (2012-A) water pump pulley with (319-A) water pump pulley nose cover using four (S550) M8-1.25 x 20mm shcs. Now install (6371-A) crank pulley using three (S292) 3/8-24 x 1" shcs.

Step 4

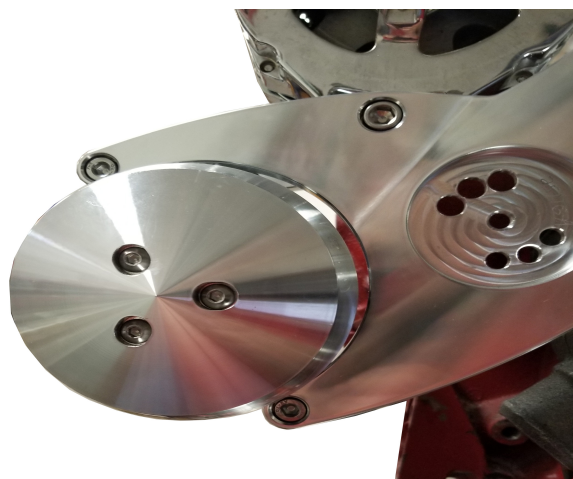
Install (25116-A) alternator & a/c bracket with two (S248) 3/8-16 x 1" shcs. Leave slightly loose until alternator has been installed.





Step 5

Install GM 10si style alternator to the backside of (25116-A) alternator & a/c bracket with a (S146) 5/16-18 x 1" shcs through the upper mounting hole. In the bottom mounting hole use a (S282) 3/8-16 x 6" shcs through the bracket and alternator ear and then a (TP3-1.630) tube spacer, (25116-B) rear support bracket and (TP3-1.040) tube spacer threaded in to the cylinder head. Make sure slotted portion of rear bracket (25116-B) is on the outside for a/c compressor to mount to as shown in photos above. Leave loose until compressor is fully installed.

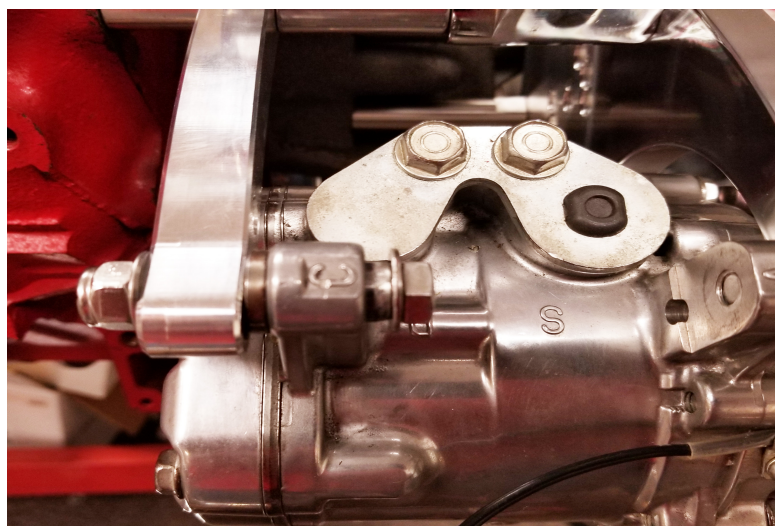


Step 6

Install Sanden 7176 a/c compressor to backside of (25116-A) main bracket with two (S551) 8mm x 1.25 x 25mm shcs. Now install (394-A) clutch cover with either three (S124) 1/4-20 x 3/4" button head bolts or three (S520) 6mm x 1.0 x 20mm button head bolts. Threads will vary on that is why we supply both sets of bolts.

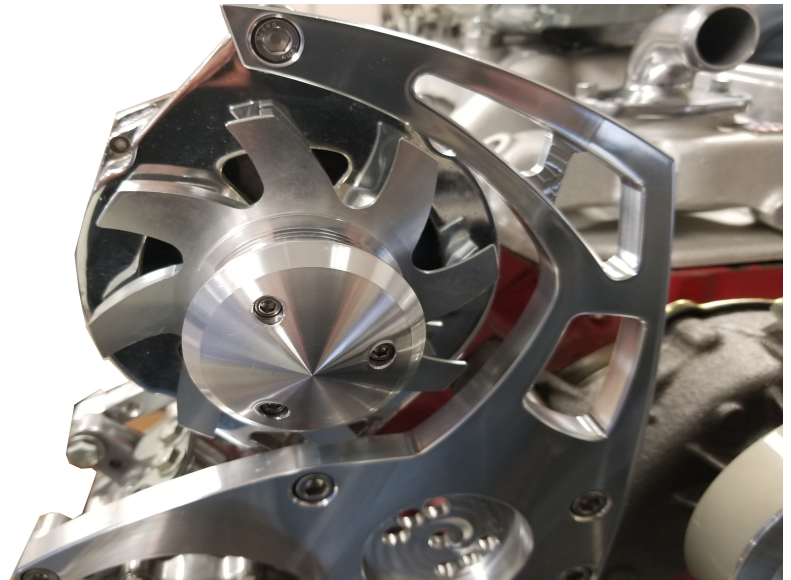
Step 7

Secure (25116-B) rear support bracket to the rear compressor ear with a (S216) 5/16-18 x 2" hex bolt with two (S660) 5/16" washers and a (S616) 5/16-18 lock nut. Now tighten all of the alternator & a/c bracket bolts.



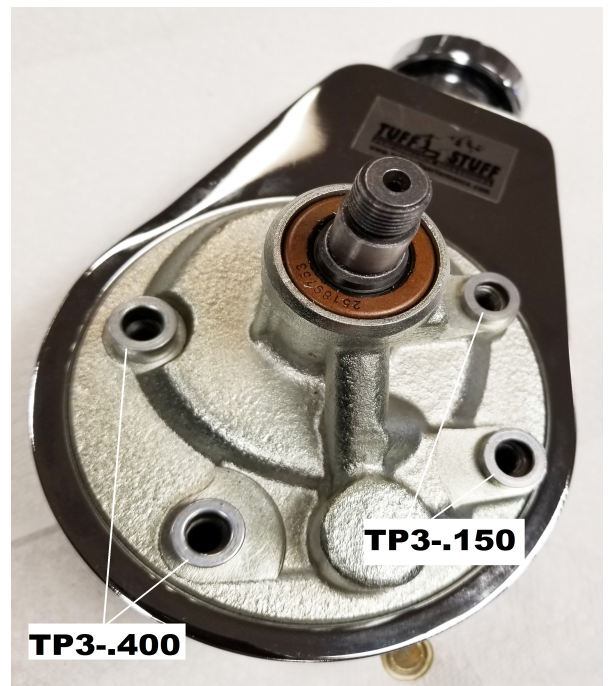
Step 8

Install (221-A) alternator fan, (206-A) alternator pulley and provided (S685) lock washer with alternator nut. Use impact to secure nut or torque to 90 lbs. Install (306-A) alternator pulley nose cover with three (S028) 8-32 x 1" shcs.



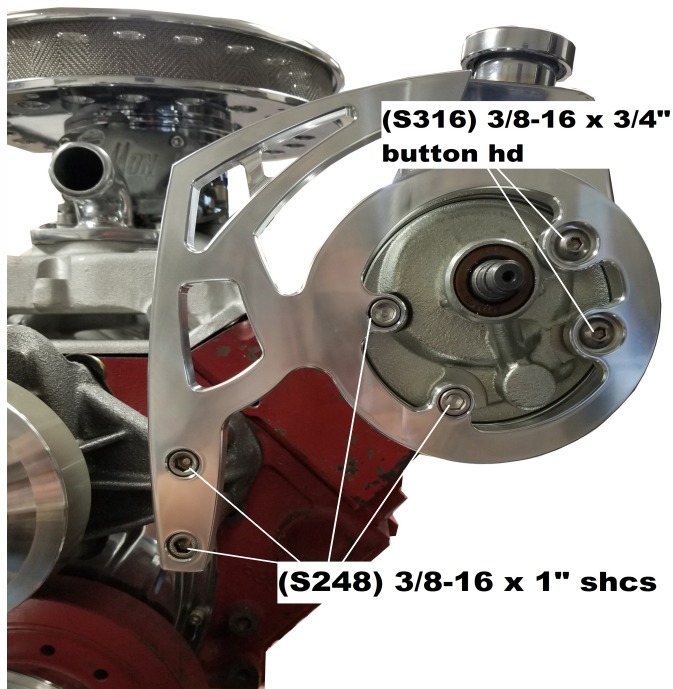
Step 9

If your power steering pump has a stud or bolt (as shown in photo) on backside of pump it will need to be removed. Now install (25114-B) rear support bracket with a TP3-.700 spacer in between pump and bracket using a (S323) 3/8-16 x 2" hex bolt and a (S666) 3/8 x 3/4" washer. Leave slightly loose for now.



Step 10

On front of power steering pump add two (TP3-.150) spacers to the right two hole positions of power steering pump and two (TP3-.400) spacers to the left side mounting holes of the pump as shown.

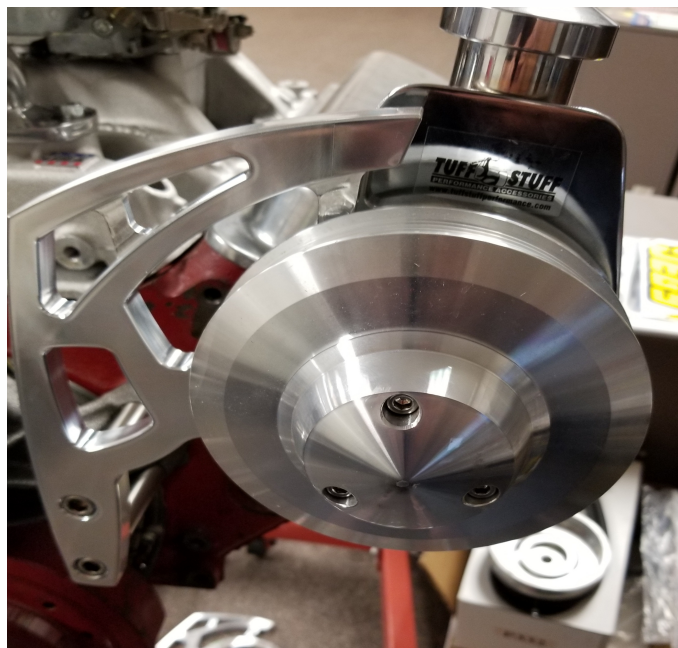
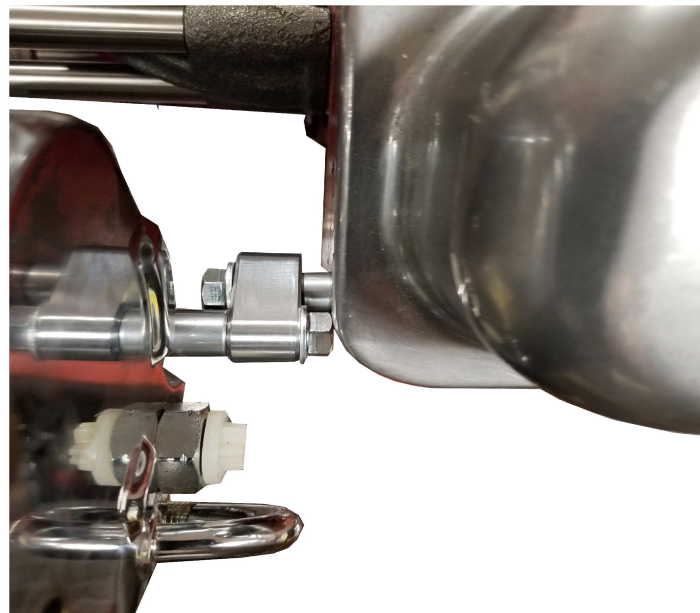


Step 8

Install (25114-A) power steering main bracket to power steering pump with two (S248) 3/8-16 x 1" shcs and two TP3-.400 spacers as shown in step 7. On right side install two (S316) 3/8-16 x 3/4" button head bolts and two TP3-.150 spacers also as shown. Now install pump and bracket to (S775) stainless threaded spacers with two (S248) 3/8-16 x 1" shcs but leave loose as you will need movement to install rear support bracket.

Step 9

Install (25114-B) to outer cylinder head bolt with a (S322) 3/8-16 x 1 1/2" hex bolt and a (S666) 3/8 x 3/4" washer. In between bracket and cylinder head use a (TP3-.300) spacer. Now tighten the front main power steering bracket bolts and then the two rear support bracket bolts. **Note: due to variations in cylinder heads it may be necessary to add shims to rear support bracket.**



Step 10

To install power steering pulley. Kit 25100 includes (623-A) keyway pulley which is installed by lining up pulley with key on shaft and then slide pulley on. Retain pulley with nut. **Note: Make sure key does not move in shaft when installing pulley as this may cause pulley failure.** Kit 25110 includes (624-A) this pulley is installed with a power steering pulley install press tool. Press pulley on until correct alignment is achieved. Now install (360-A) pulley cover with three (S106) 1/4-20 x 1 1/4" shcs.

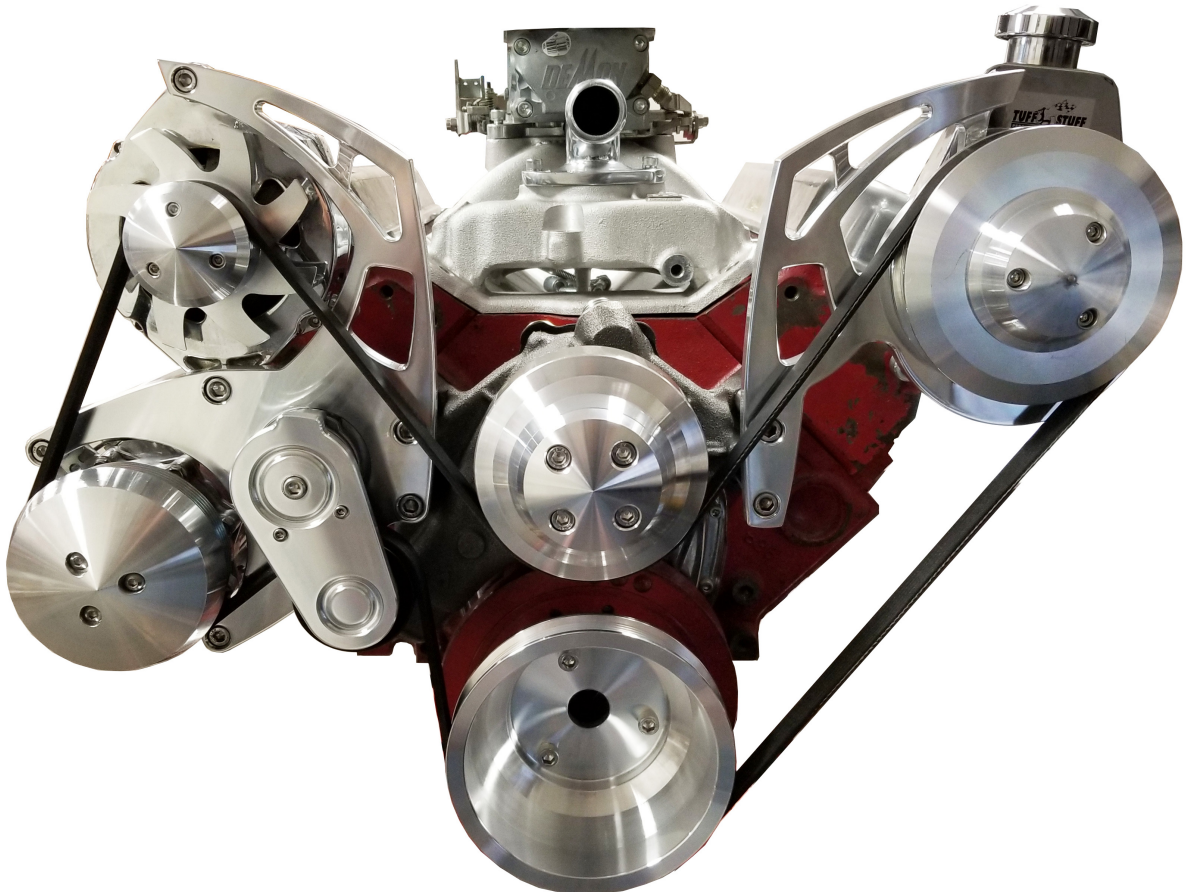
Step 12

Install (P758) spring tensioner to alternator bracket pocket. Use two (S660) 5/16 washers, (S160) 5/16-18 x 2 3/4" shcs and a (S616) 5/16 lock nut. One washer on the front of tensioner and one on the rear of bracket. There are 3 positions the tensioner can be installed in. This is to aid with variations in belt length and custom configurations. For the recommended belt, install the tensioner first in the middle position. Before tightening the bolt install belt over tensioner pulley as shown then tighten tensioner bolt.



Step 13

To install belt, use a 1/2" drive ratchet and rotate clockwise and install a 82.5" 6 rib belt and route belt as shown below. We recommend **Dayco part # 5060825**. After belt is on, install (759-A) tensioner cover with two (S022) 8-32 x 3/8" shcs.



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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.

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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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