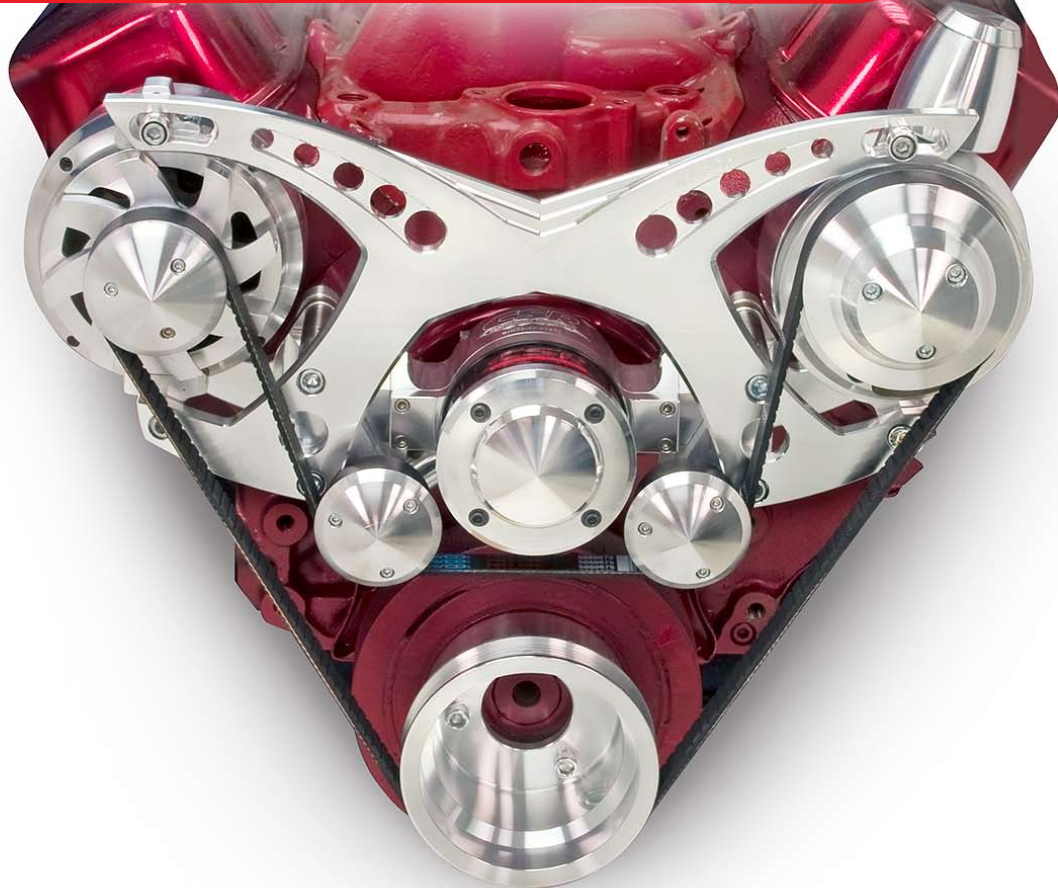


Revolver



Highly Styled, Low Cost Serpentine Drive

Installation Instructions

Chevy Big Block Electric

Water Pump Bracket Kit

#23100 (Billet Alternator & Power Steering Pump)

#23105 (Chrome Alternator & Power Steering Pump)



Parts List

Main Front Bracket - P/N 21267

- 1 - 21266-A..... Main Front Bracket
- 2 - S148 $\frac{5}{16}$ x $1\frac{1}{4}$ " SHCS
- 4 - S254 $\frac{3}{8}$ x $1\frac{3}{4}$ " SHCS
- 4 - S338 $\frac{3}{8}$ x $2\frac{1}{2}$ " Threaded Stud
- 1 - S551 8M x 25mm Metric SHCS
- 4 - S776 Modified 2.720" Lg Threaded Spacer
- 2 - MM100..... Bolt Cap Alum

P/S Rear Support Brk - P/N 21268

- 1 - 21262-A..... P/S Rear Support Bracket Body
- 1 - S276 $\frac{3}{8}$ x $4\frac{1}{2}$ " SHCS
- 1 - S676 Water Pump Gasket
- 1 - TP3-1.630..... 1.630" Lg Spacer Tube
- 1 - TP3-1.890..... 1.890" Lg Spacer Tube

Alternator Rear Support - P/N 21263

- 1 - 21263-A..... Alt Rear Support Bracket Body
- 1 - S278 $\frac{3}{8}$ x 5" SHCS
- 1 - S450 $\frac{5}{8}$ x $1\frac{1}{8}$ " Set Screw
- 2 - S622 $\frac{3}{8}$ " Lock Nut
- 1 - S676 Water Pump Gasket
- 1 - TP3-1.400..... 1.400" Lg Spacer Tube

Idler Left Hand Bracket - P/N 23101

- 1 - 23101-A..... Idler Left Hand Bracket Body
- 1 - 740-A Idler Pulley
- 1 - 302-A Idler Pulley Cap
- 3 - S022 $\frac{8}{32}$ x $\frac{3}{8}$ " SHCS
- 1 - S262 $\frac{3}{8}$ x $2\frac{1}{2}$ " SHCS
- 1 - TP3-.520..... .520" Lg Spacer Tube

Idler Right Hands Bracket - P/N 23102

- 1 - 23102-A..... Idler Right Hand Bracket Body
- 1 - 740-A Idler Pulley
- 1 - 302-A Idler Pulley Cap
- 3 - S022 $\frac{8}{32}$ x $\frac{3}{8}$ " SHCS
- 1 - S262 $\frac{3}{8}$ x $2\frac{1}{2}$ " SHCS
- 1 - TP3-.520..... .520" Lg Spacer Tube

Power Steering Adaptor Ring - P/N 21074

- 1 - 21074-A..... Power Steering Adaptor Ring Body
- 2 - S244 $\frac{3}{8}$ x $\frac{3}{4}$ " SHCS
- 1 - S312 $\frac{3}{8}$ x 1" Hex Hd Bolt

Belt Adjustment Tool - P/N 21206

- 1 - MM101..... RH Rod End
- 1 - MM102..... LH Rod End
- 1 - MM105..... 13" Lg Threaded Rod

Pulleys

- 1 - 7211-A..... Crank Shaft Pulley
- 1 - 206-A Alternator Pulley Body
- 1 - 221-A Alternator Fan Body
- 1 - 306-A Alternator Cap
- 1 - 360-A Power Steering Pulley Cap
- 1 - 345-A Water Pump Cover
- 1 - 629-A Power Steering Pulley
- 3 - S028 $\frac{8}{32}$ x 1" SHCS
- 4 - S047 10-24 x 3" SHCS
- 3 - S106 $\frac{1}{4}$ x $1\frac{1}{4}$ " SHCS
- 3 - S248 $\frac{3}{8}$ x 1" SHCS
- 1 - S685 $1\frac{1}{16}$ " Lock Washer

Accessories

- 1 - P900 CSR Electric Water Pump
- 1 - P908 Water Hose Adaptor
- 1 - 9600 Billet Alternator
KIT # 23100 ONLY
- 1 - 9650 Billet Power Steering
KIT # 23100 ONLY
- 1 - P304 Saganaw Chrome Power Steering
KIT # 23105 ONLY
- 1 - P555 Alternator Chrome
KIT # 23105 ONLY

Required Tools and Materials

- RTV Silicone
- Loc-Tite® Thread Locker
- Anti-seize Compound
- Gasket Scraper, Steel Wool or Sandpaper to clean gasket surfaces
- $\frac{3}{16}$ " Allen Head Driver
- $\frac{5}{16}$ " Allen Head Driver
- $\frac{1}{4}$ " Allen Head Driver
- 6mm Allen Head Driver
- $\frac{5}{8}$ " Combo Wrench
- $\frac{9}{16}$ " Combo Wrench
- $1\frac{1}{16}$ " Combo Wrench
- $\frac{3}{4}$ " Combo Wrench
- Socket Wrench & Extension
- 10mm 12pt. socket
- 12mm 12pt. socket
- 66" Serpentine Belt

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.

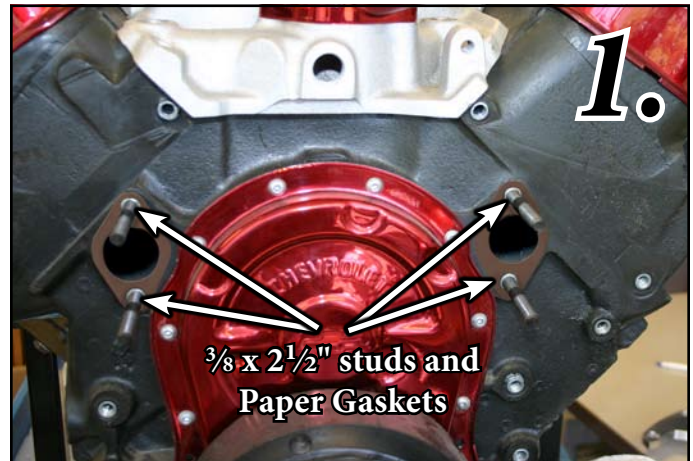


Photo-2 Install (2) Paper Gasket (S676) over the studs and the on the passenger side install the Alternator Rear Support Bracket (21263-A). On the drivers side install the Power Steering Rear Support Bracket (21262-A). Install the second set of Paper Gaskets over the studs that are included with water pump.

Photo-3 Slide the CSR Electric Water Pump (P900) over the studs and secure with the (4) $\frac{3}{8}$ O.D. x 2.750" Stainless Steel Threaded Spacers (S776) as shown. Install the Water Pump Cap (345-A) using the (4) 10-24 x 3" SHCS (S047)

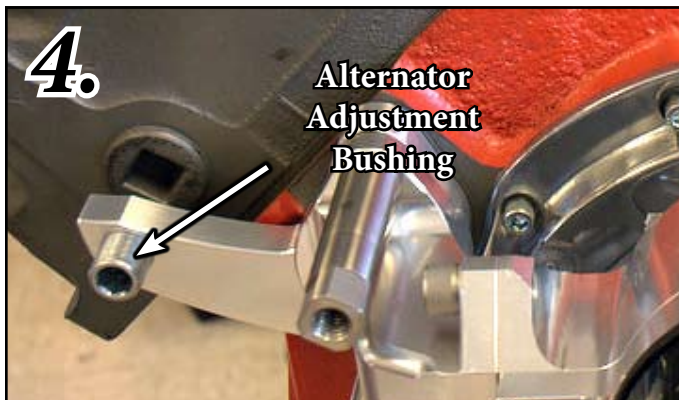


Photo 4 Install the $\frac{5}{8}$ x $1\frac{1}{8}$ " Adjustment Bushing (S450) into the Rear Alt Support. Install the Water Hose Adaptor (P908).

Photo-5 Install the Idler Brackets (23101-A Passenger Side) and (23102-A Drivers Side) between the Main Front Bracket (21266-A) and the Stainless Steel Spacers. Make sure the tapped holes are facing the center of the water pump and the pockets of the Idler Brackets are facing toward the block. Now install Main Front Bracket over the idler brackets using the (4) 3/8 x 1 3/4" SHCS (S254). Tighten at this time.

Install the (2) Idlers (740) into the Idler Brackets using two 3/8 x 2 1/2" SHCS (S262) (2) .520" Steel Spacers (TP3-.520) Between the Idlers and the Idler Brackets.

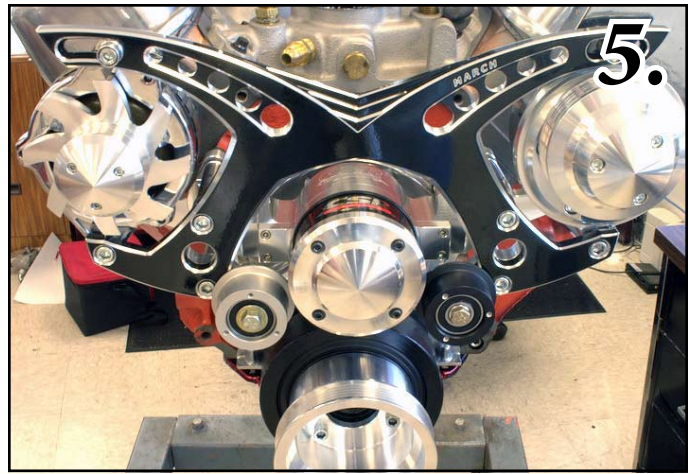


Photo-6 Install the power steering Adapter Ring (21074-A) to the power Steering pump using (2) 3/8 x 3/4" SHCS (S244) and (1) 3/8 x 1" Hex Bolt (S312) as shown.

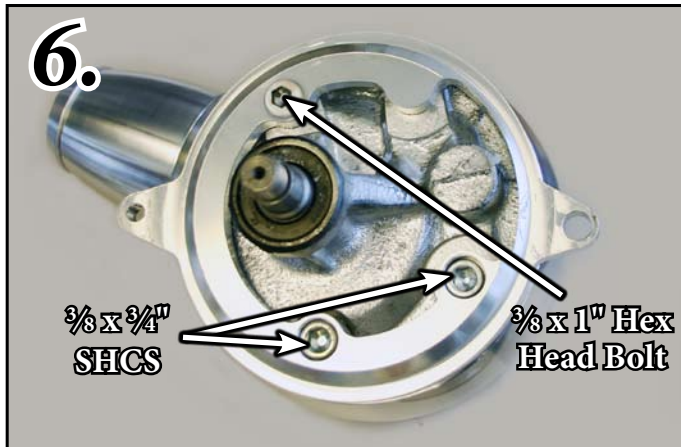


Photo 7 Install the power steering unit (9650 or P304) to the Main Bracket using a 3/8 x 4 1/2" SHCS (S276) in the bottom mount with (1) (TP3-1.630) Spacer and (1) (TP3-1.890) Spacer between the rear support and the lower clearance hole of the power steering relocation bracket. Secure with 3/8" locknut (S622).



Photo 8 Install the Alternator (9600 or P555) using a 3/8 x 5" SHCS (S278) and a 3/8" lock nut (S622). Place (1) Billet Spacer Bushing (TP3-1.400) between the Alternator and the Adjust Set Screw (S450). Adjust S450 to take up any space between the lower alternator support and the spacer. (snug only at this time).

(NOTE: If using the billet Alt. Unit use a 5/16 x 1 1/4" SHCS (S148) in place of the metric bolt 8M x 25mm SHCS (S551).)



Photo 9 In the upper Alternator and Power Steering slots use the two (MM100) Alum. Bolt bushings and the (2) 5/16 x 1 1/4" SHCS (S148) (snug only at this time)



Photo 10 Apply Loc-Tite to the threads of the (3) $\frac{3}{8}$ -16 x 1" SHCS (S248). Place the crank pulley (7211-A) on damper and align holes. Thread the (3) screws through pulley and into damper, tighten firmly (50 ft/lbs.)

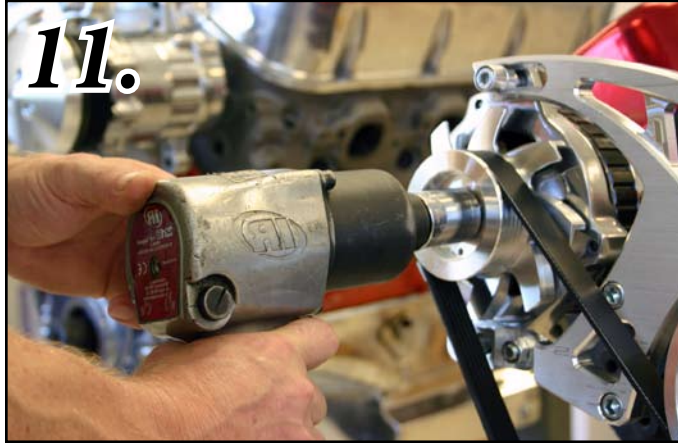


Photo 11 Install alternator fan (221-A) and pulley (206-A) over the alternator shaft. Use the lockwasher (S685) and then tighten pulley nut (impact to 90 ft, pounds). Install Alt Cap (306-A) with (3) $\frac{8}{32}$ x 1" SHCS (S028).

Photo 12 Slip the Power Steering Pulley (629-A) and tighten with Locknut. Install the Power Steering Pulley Cap (360-A) with (3) $\frac{1}{4}$ x $1\frac{1}{4}$ " SHCS (S106). Push the Alternator and A/C inward to their fullest position and Install a 66" belt, running the belt under the Water Pump and under the idlers.

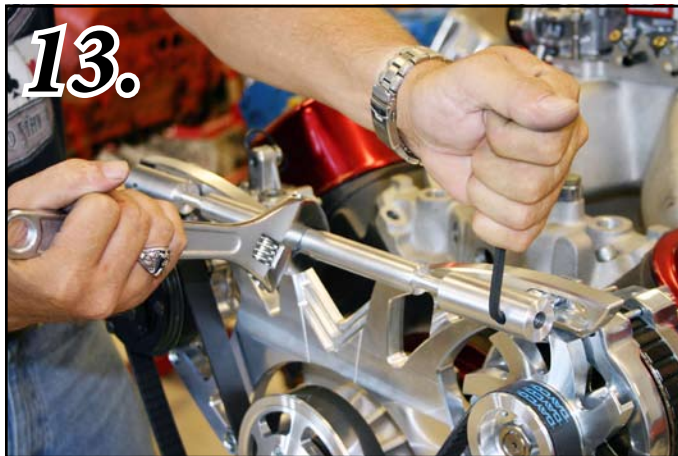


Photo 13 Slip the supplied March Adjustment tool (21206) over the two (MM100) bushings. Use a wrench to turn the adjustment tool outward to tighten the serpentine belt to 100 ft. lbs. Use the holes in the adjustment tool to tighten both 8M socket head cap screws when correct belt tension has been achieved. Remove the adjustment tool and keep for future use. Install the Idler Caps (302-A) using (3) $\frac{8}{32}$ x $\frac{3}{8}$ " SHCS (S022).

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.

MARCH PERFORMANCE, INC. • 16160 PERFORMANCE WAY • NAPLES, FLORIDA 34110
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.

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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:

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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
- 70% 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.

RGA# _____ CT# _____ Issued by: _____ Date _____

Purchaser's Name _____ Phone _____

Address _____

Purchased Directly Through _____ Invoice# _____

Product ID _____ Invoice Date _____

Reason _____

**** MOUNTED PRODUCTS ARE NONREFUNDABLE ****