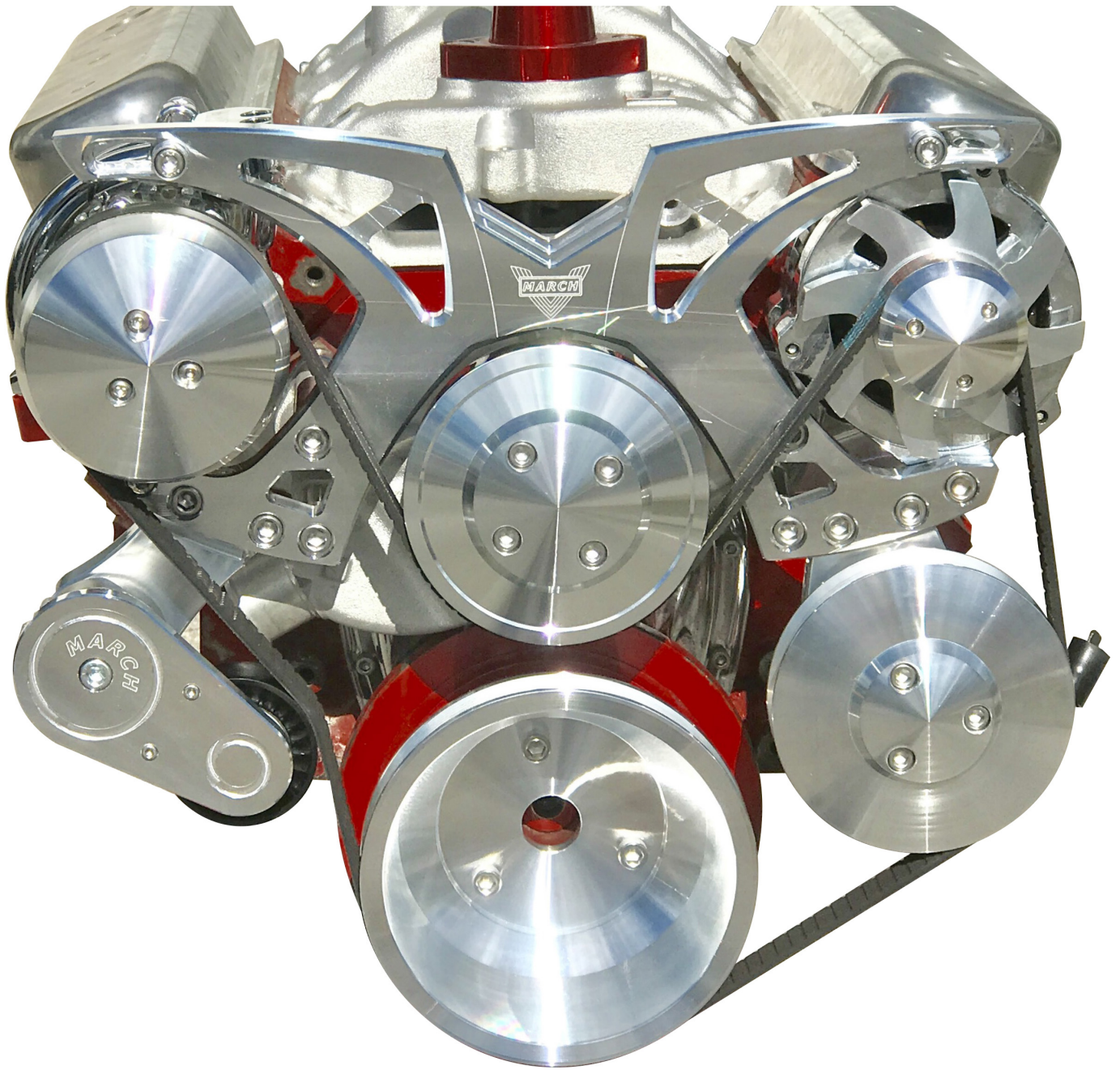




06-08-2023



Chevy Big Block

Installation Instructions

- #21200 Style Track (without Power Steering)*
- #21250 Style Track (with Remote Power Steering)*
- #21255 Style Track (with Saginaw Power Steering)*

Parts List

Main Front Bracket Kit P/N 21201

- 1 - 21201-A.....Main Front bracket body (Style Track)
- 6- S248 $\frac{3}{8}$ - 16 x 1" SHCS
- 4 - S339 $\frac{3}{8}$ - 16 x 3" Threaded Stud
- 1 - S550M8 - 1.25 x 20mm SHCS
- 2 - S553M8 - 1.25 x 35mm SHCS
- 4 - S7853.000" Threaded Spacer Stainless
- 2 - MM100.....Alum Bolt Cap

Alt Rear Support Bracket P/N 23602

- 1 - 23602-A.....Alt Support Bracket Body
- 1 - S277 $\frac{3}{8}$ - 16 x 4 $\frac{3}{4}$ " SHCS
- 2 - S676Paper Water Pump Gaskets
- 1 - TP3-1.890..... $\frac{3}{8}$ " ID x1.890" spacer

A/C Rear Support Bracket P/N 23603

- 1 - 23603-A.....A/C Support Bracket Body
- 1 - S660..... $\frac{5}{16}$ washer
- 1 - S216 $\frac{5}{16}$ - 18 x 2" hex head
- 2 - S676Paper Water Pump Gaskets
- 1 - TP3-.400..... $\frac{3}{8}$ " ID x .400 spacer

Power Steering Bracket P/N 21204

(For Kit # 21250 with Remote Pump)

- 1 - 21204-A.....Power Steering Bracket Body
- 2 - S260 $\frac{3}{8}$ - 18 x 2 $\frac{1}{4}$ " SHCS
- 2 - S356 $\frac{7}{16}$ - 14 x 2 $\frac{1}{4}$ " SHCS
- 2 - S556M8 - 1.25 x 40mm SHCS

Power Steering Bracket P/N 21205-09

(For Kit # 21255 with Saginaw Pump)

- 1 - 21205-A.....P/S Front Plate
- 1 - 21205-BP/S Rear Plate
- 1 - 20115-C.....Spacer Block
- 2 - S311 $\frac{3}{8}$ - 16 x $\frac{3}{4}$ " hex head bolts
- 1 - S325 $\frac{3}{8}$ - 16 x 1" flat head bolts
- 1 - TP3-.150..... $\frac{3}{8}$ " ID x .150 Spacer
- 2 - S384 $\frac{7}{16}$ - 14 x 3 $\frac{3}{4}$ " hex head bolts
- 2 - S672 $\frac{7}{16}$ washers

Belt Tensioner P/N 21209

- 1 - 21209-A.....Tensioner bracket
- 1 - P758.....Tensioner
- 1 - 759-A.....Tensioner cover
- 2 - S022.....8-32 x $\frac{3}{8}$ " SHCS
- 1 - S162..... $\frac{5}{16}$ x 3" Hex head
- 2 - S660..... $\frac{5}{16}$ washer
- 1 - S616..... $\frac{5}{16}$ -18 Lock nut

Chevy BB Pulley Kit P/N 7660-206

- 1 - 7666-A.....Crank Pulley body
- 1 - 6302-A.....Water pump Pulley Body
- 1 - 206-A.....Alternator Pulley Body
- 1 - 306-A.....Alternator Pulley Cap Body
- 1 - 221-A.....Alternator Fan
- 1 - 394-A.....A/C Cover Body
- 3 - S028 $\frac{8}{32}$ x 1" SHCS
- 3 - S520 M6 - 1.0 x 16mm button head bolts
- 3 - S124 $\frac{1}{4}$ - 20 x $\frac{3}{4}$ " button head bolt
- 4 - S183 $\frac{5}{16}$ " - 24 x $\frac{7}{8}$ " SHCS
- 3 - S248 $\frac{3}{8}$ - 16 x 1" SHCS
- 1 - S685 $\frac{11}{16}$ " Lock Washer
- 1 - S716Water Pump Bushing

$\frac{3}{4}$ "OD x $\frac{5}{8}$ " ID x $\frac{3}{16}$ " Long

- 1 - 650-A.....P/S Pulley (Type 2 remote)

(For Kit # 21250)

- 3 - S144..... $\frac{5}{16}$ -18 x $\frac{7}{8}$ " SHCS

- 1 - 535-A.....P/S Pulley (Keyed)

(For Kit # 21255)

- 1 - 302-A.....P/S Pulley Nose Cover

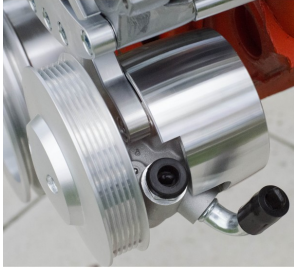
- 3 - S022 $\frac{8}{32}$ x $\frac{3}{8}$ " SHCS

Accessories

- 1 - P125BB Chevy Alum Water Pump
Rev. Rotation
- 1 - P412Sanden A/C Compressor (chrome)
- 1 - P417A/C Line Kit
- 1 - P572Alum Alternator (chrome)
- 1 - P314Remote P/S Pump
- 1 - P304Remote P/S Pump

(For Kit # 21255)

Optional parts for kits



Part # 480 or 480-08 type II power steering pump billet housing cover



We carry a selection of power steering remote reservoirs to complete your type II power steering installation.



Part # 418 or 418-08 a/c manifold wrap around fittings



Stainless braided hose packages for plumbing your power steering system



Part # P545 320amp alternator



Part # P306 power steering psi regulator kit. Typically required for most rack & pinion systems



We are specialists in matching aftermarket air conditioning systems such as Vintage Air, Old Air Products and Nostalic Air with our drive systems. Please contact us for help in selecting a matching kit for your application. 888-729-9070

Preparing to Install

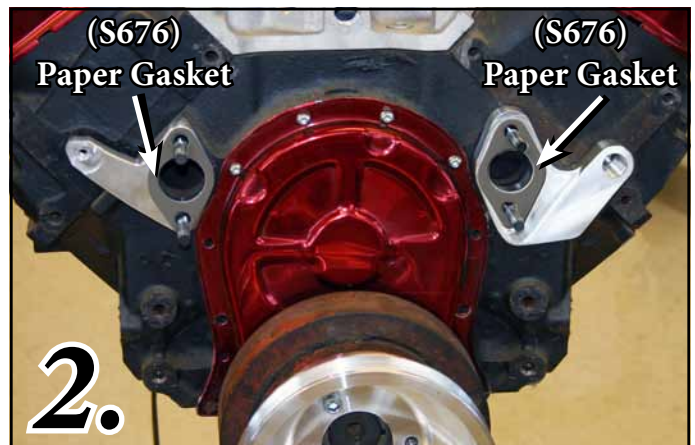
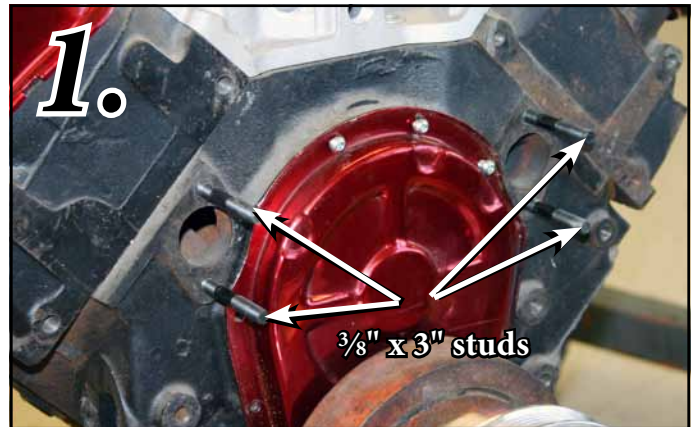
- Disconnect the battery to prevent accidental engagement of starter motor.
- Drain coolant from system
- If your A/C is intact and charged it must be evacuated. This is best done by a professional garage with proper recycling equipment
- Remove the existing alternator, air conditioning compressor and 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

Step-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) 3/8 x 3" mounting studs (S339) into the four water pump mounting holes 1/2" inch deep into block.

Step-2. Install the alternator rear support bracket (23602-A) on the driver side and a/c rear support (23603-A) on passenger side. Use the (4) provided paper gaskets (S676).

Step-3. Install the water pump (P125) over the studs and secure with (4) 3" threaded spacers (S785) as shown and tighten.



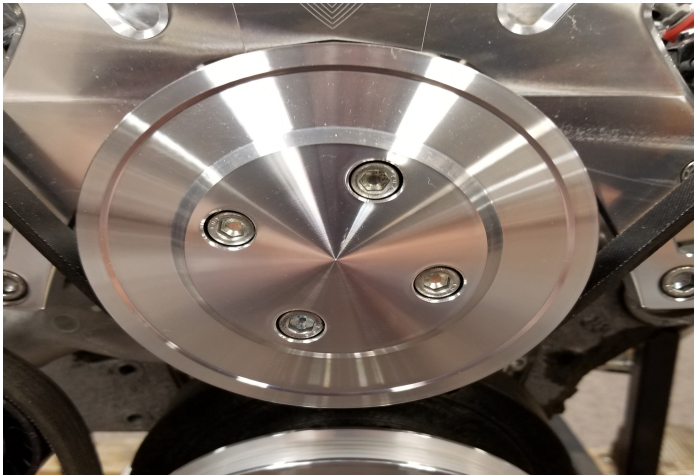
Step-4

Install main bracket (21201-A) to the four threaded spacers with four (S248) 3/8-16 x 1" SCHS.



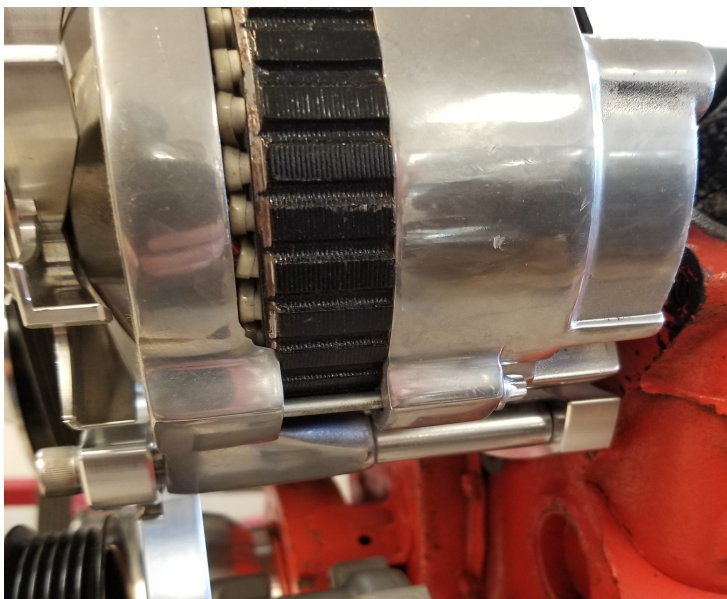
Step-5

First slide (S716) water pump pilot shaft bushing 5/8" i.d. x 3/4" o.d. on to pilot shaft of water pump. Now install (6302-A) water pump pulley to water pump with four (S183) 5/16-24 x 5/8" SHCS



Step-6

Install (7666-A) crank pulley with three (S248) 3/8-16 x 1" SCHC.



Step-7

Install the (P572) alternator in between the main bracket and rear support bracket on the driver side. Use a (TP3-1.890) spacer behind the lower alternator ear and the rear bracket. Then secure with a (S277) 3/8-16 x 4-3/4" SHCS.

Step-8

Secure alternator upper ear to main bracket slot with a (MM100-A) bolt bushing and a (S553) M8-1.25 x 35mm SHCS as shown. Now install alt fan (221-A) and pulley (206-A) and secure with lock washer (S685) and nut. Use impact to install to 70 lbs. Now install cover (306-A) with three (S028) 8-32 x 1" SHCS.



Step-9

To mount the (P412) a/c compressor, Use one (S550) M8-1.25 x 25mm SHCS through the front of the lower hole on the main bracket. On the top ear use a (MM100-A) bolt bushing and a (S553) M8-1.25 x 35mm SHCS through the slot on the main bracket. Now install clutch cover (394-A) with either three (S520) M6-1.0 x 20mm or three (S124) 1/4-20 x 3/4 button head bolts. These are to be installed a 1/4 turn past finger tight.

Step-10

The rear mounting ear will use a (S216) 5/16-18 x 2" hex head bolt through the front of the rear compressor ear with a (S660) 5/16 washer and thread in to rear support bracket. Use a TP3-.400 spacer between rear ear of compressor and bracket if there is a gap.





Step-11

Install (21209-A) tensioner bracket to main bracket on passenger side with two (S248) 3/8-16 x 1" SHCS.

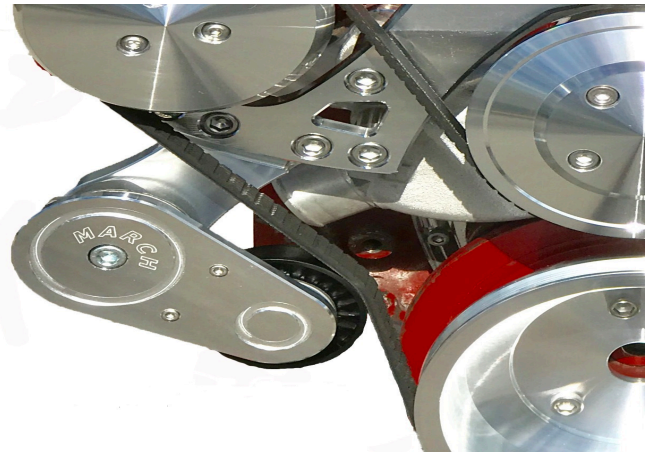


Step-12

Install (P758) pulley tensioner to tensioner bracket with one (S162) 5/16-18 x 3" SHCS, two (S660) 5/16 washers and one (S616) 5/16-18 lock nut. Install tensioner cover (759-A) with two (S022) 8-32 x 3/8" SHCS after belt is on.

Note: There are 3 positions the tensioner can be installed. Install in the middle location.

The additional positions and slotted adjustments on the main bracket are to aid in correcting variations in belt lengths or stretched belts. This will also help with custom applications.

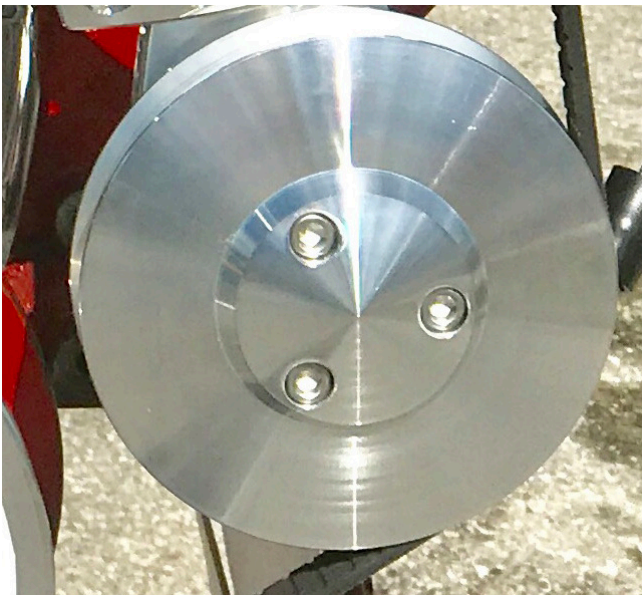


For kits with Type 2 remote power steering (21250)

Step-13

Install the power steering pump (P314). To the power steering bracket (21204-A) with two (S556) M8 x 40 mm SHCS. Bolts are installed from the rear of the bracket and into the pump. Now install power steering bracket (21204-A) and pump to the lower two holes on driver side of the engine block with two (S356) 7/16 x 2 1/4" or (S260) 3/8 X 2 1/4") SHCS depending on size of holes of the block.





Step-14

Install (650-A) power steering pulley to pump with three (S144) 5/16-18 x 7/8" SHCS

For kits with Saginaw power steering (21255)

Step-15

First **Remove stud** from back of (P304) power steering pump.



Step-16

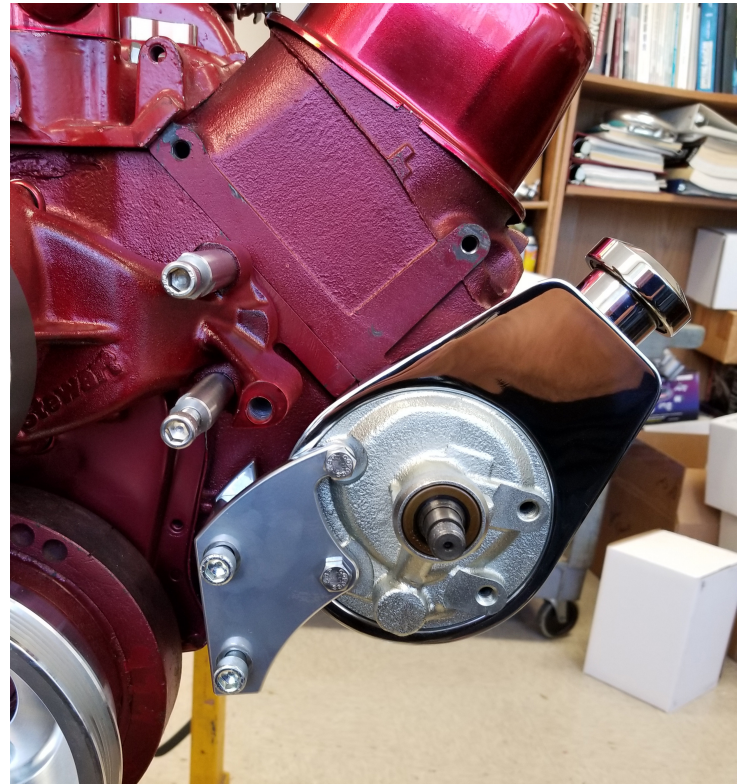
Install (21205A-09) to front of pump as shown with two (S311) 3/8-16 x 3/4" hex heads.





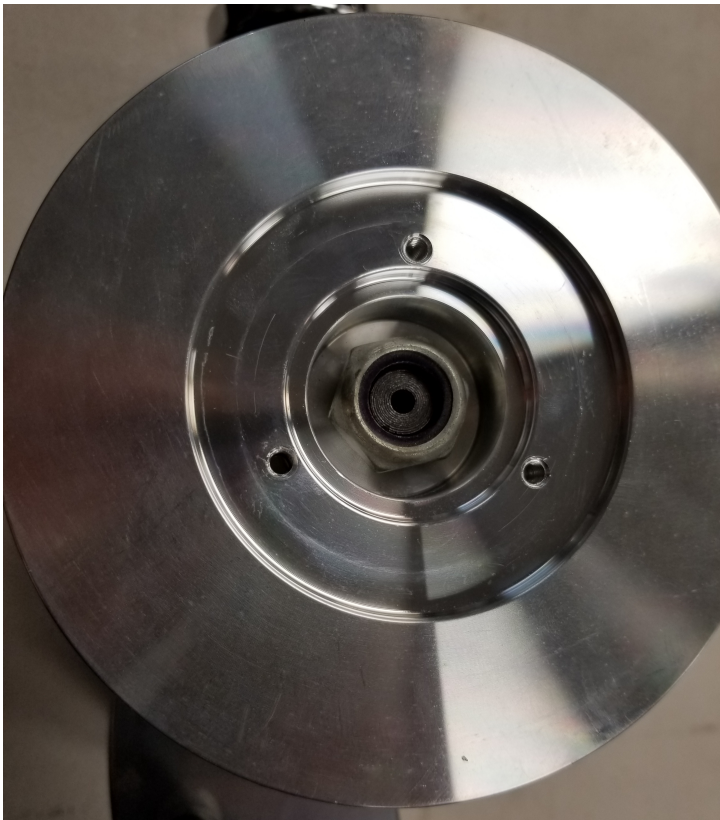
Step-17

Install (21205B-09) rear support bracket to backside of pump where stud was with a (S325) 3/8-16 x 1" flat head. Use (TP3-.150") spacer in between pump and bracket.



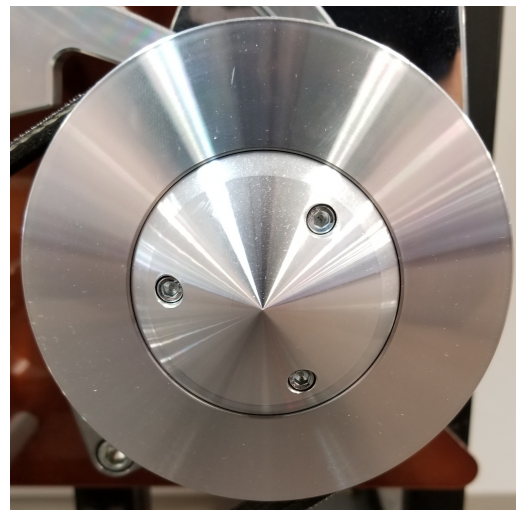
Step-18

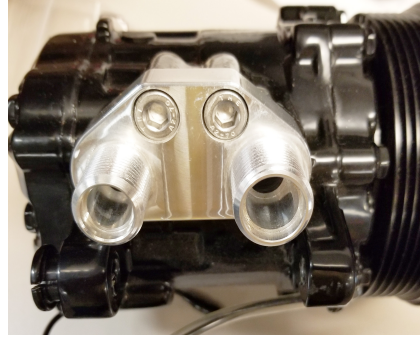
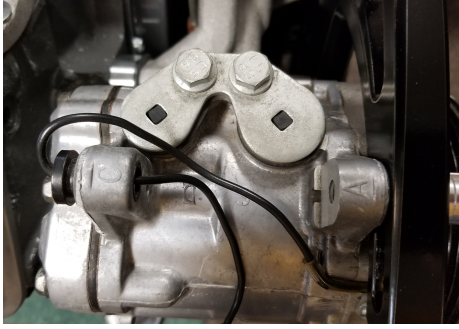
Install pump and bracket assembly to the lower driver side of the engine block with two (S384) 7/16-14 x 3 3/4" hex heads and two (S672) 7/16" washers and (20115C-09) spacer block in between the front and rear brackets as shown in photo.



Step-19

Install (535-A) to power steering pump and retain with lock nut. **Make sure woodruff key is straight on shaft of pump and does not slide up in rear upon install.** Now install pulley nose cover (302-A) with three (S022) 8-32 x 3/8" SHCS.





Step-20

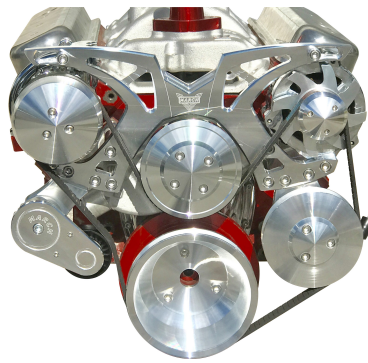
If installing air conditioning at this time, Remove block off plate from compressor and then install (417A-04) with two (S550) M8-1.25 x 20mm SHCS

Step-21

Installing belts. We recommend **Dayco** brand belts. To install belt make sure alternator and a/c compressor are all the way inward on the slots of the main bracket. Use a 1/2" drive to pull and release the tensioner. You can adjust the position of the components in the slots as well as adjust the position of the tensioner if needed to aid in custom applications or if a belt is too loose. See pictures below for routing and belt sizes.



**Kit 21200 no p/s
use a 65" 6 rib belt
(Dayco 5060650)**



**Kit 21250 with Type 2 p/s
use a 67.5" 6 rib belt
(Dayco 5060675)**



**Kit 21255 with
Saginaw p/s
use a 69" 6 rib belt
(Dayco 5060690)**

LIMITED WARRANTY

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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.

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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.

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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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