



Highly Styled , Low Cost Serpentine Drive Systems



Chevy Small Block Mid Mount A/C Kit

#22072

#22082

#22087

Included Parts List

20160 Power Steering Bracket

1-20145-AP/S Bracket Body
2-TP3-.520.....Spacer Tube
2-S272.....3/8-16 x 3-3/4" SHCS
1-S266.....3/8 x 3" SHCS
1-S312.....3/8-16 x 1" Hex Bolt
1-20175-A.....Lower front support bracket
1-20175-B.....Lower rear support bracket
1-S266.....3/8-16 x 3" SHCS
3-S311.....3/8-16 x 3/4" Hex Bolt
4-S664.....3/8 x 1" Washer
2-S666.....3/8 x 3/4" Washer
2-S667.....3/8 x 5/8 Washer

1-20188 Alt. & A/C combo Bracket

1-20188-A.....Front Bracket
1-20188-B.....Rear Support Bracket
1-740-A.....IdlerPulley
1-302-A.....Idler pulley Cap
1-20142-A.....Re-locator Bracket
W/1-S144 & 1 S248
1-S150.....5/16 x 1-1/2" SHCS
1-S244.....3/8 x 3/4" SHCS
2-S248.....3/8 x 1" SHCS
2-S260.....3/8 x 2-1/4" SHCS
1-S282.....3/8 x 6" SHCS
1-S321.....3/8 x 1-3/4" Hex Bolt
2-S550.....M8 x 1.25 x 20 MM SHCS
1-S616.....Lock nut
1-S666.....Washer
1-RA-1.625.....Adjustment Rod
2-TP3-1.400.....Spacer tube
1-TP3-3.250.....Spacer tube
3-SO22.....8/32 x 3/8 SHCS

Pulley Kit Number 6322-208-623

1-6386-A.....Crank Pulley
1-6322-A.....Water pump Pulley
1-623-A.....Power Steering pulley (key)
1-208-A.....Alt. Pulley
1-221-A.....Alt pulley Fan
1-314-A.....W/P pulley Cover
1-394-A.....A/C cover
1-307-A.....Alt Cover

3-SO28.....8/32 x 1" SHCS
1-S685.....Lock Nut
4-S183.....5/16-24 x 5/8 SHCS
3-S292.....3/8-24 x 1" SHCS
3-S124.....1/4-20 x 3/4" SHCS

Required tools and Materials

RTV silicone	6mm Allen head
Lock-Tite	5/8 Combo wrench
Gasket Scraper	9/16 Combo wrench
3/16 Allen head	11/16 Combo wrench
5/16 Allen head	3/4 Combo wrench

Photo-1

Install the crank pulley 6386-A To the balancer using three 3/8-24 x 1" SHCS (S292) as shown.



Photo-2

Mount the Alt & A/C front bracket (20188-A) to the two tapped holes on the water pump. In the upper hole use a 3/8 x 1" SHCS (S248) In the lower hole use a 3/8 x 3/4" SHCS (S244).

Photo-3

Mount the Idler pulley (740-A) to the Alt. bracket in the tapped hole. Use a 3/8 washer (S666) and a 3/8 x 1-3/4 Hex Bolt (S321). Then install the idler cap (302-A) using three 8/32 x 3/8 SHCS. (S022)

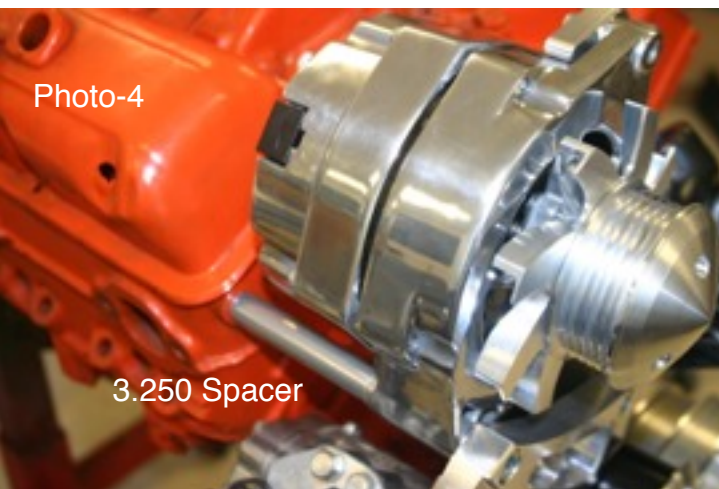


Photo-4

Mount your GM Alternator to the bracket use a (TP3-3.250) Spacer between the head and the rear of the Alt. Mounting ear Install with a 3/8 x 6" SHCS (S282) as shown. You may now install the Alt. Fan (221-A) and the Alt. Pulley (208-A) And the (685) lock washer making sure to use a impact to secure the pulley and fan. Then install the Alt Cap (307-A) Using three 8/32 x 1" SHCS (SO28).

Photo-5

Mount the Rear A/C support Bracket (20188-B) To the Pass. Side two lower holes using two (TP3-1.400) Spacers between the block and the rear support securing with two 3/8 x 2-1/4" SHCS (S260).



Photo-5



Photo-6

Photo-6

Mount the A/C compressor to the A/C & Alt Main bracket . Use two M8 x 20 MM SHCS (S550).

(Note) the metric bolts have a larger head then the standard socket caps. Now thru the rear A/C ear use a 5/16 x 1-1/2" SHCS (S150) and secure with a 5/16 locknut (S616).

Photo-7

Mount the Alt. Re-locator (20142-A) to the tapped hole of the Alternator using the provided 5/16 x 7/8 SHCS (S144) then attach the (RA-1.625) Adjustment rod to the Re-locator with a 3/8 x 1" SHCS (S248). You can now attach the rod to the water pump Using the second provided 3/8 x 1" SHCS As shown.

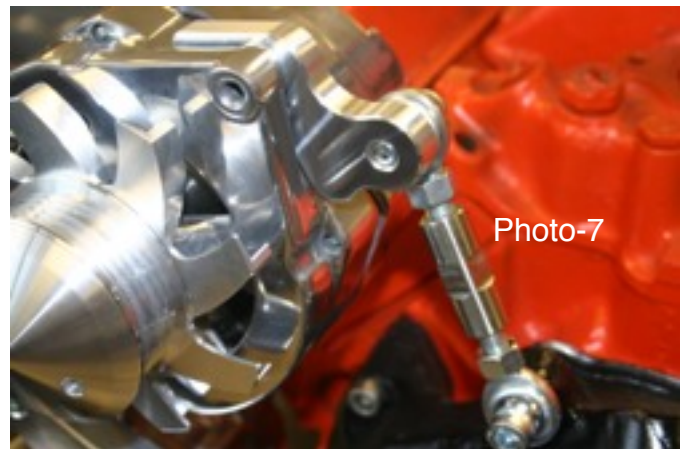


Photo-8

Now install the water pump Pulley (6322-A) and if your using it, the pulley cap (314-A) use four 5/16 x 5/8 SHCS (S183). At this point you may add your ALT.&A/C belt P.N. 5060620 (62") Or if your using P/S move to the next step.

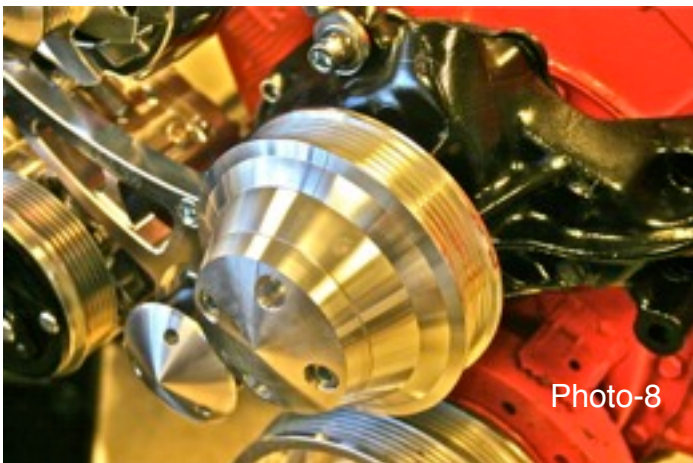


Photo-9

Mounting the P/S. If your P/S pump came with a mounting stud at the rear lower part of the pump use a 11/16 wrench and remove it .



Photo-9

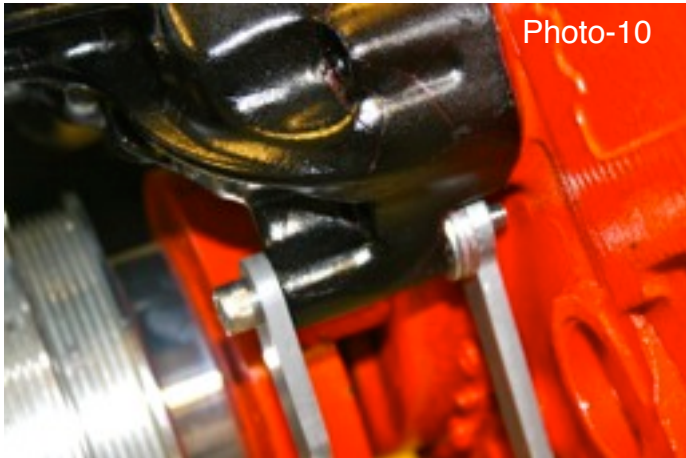


Photo-10

Photo-10

Mount the Power steering brackets that came with your kit to the water pump boss (20175-A) front & (20175-B) rear. Use a 3/8 x 3" SHCS (S266) Place three 3/8 x 3/4" Washers (S664) between the water pump and the rear support bracket and install to not tighten at this time. (NOTE) due to variances in the mounting boss from OEM it may be necessary to change this shim set using the washers to get proper alignment of the power steering pulley.

Photo-11

Secure the P/S pump to the lower brackets use two 3/8 x 3/4 Hex bolts (S311) in the front bracket see photo 11-A. And one 3/8 x 3/4 hex bolt to the rear lower hole of the P/S pump using one 3/8 x 3/4 washer between the rear bracket and the P/S pump (S666) see photo 11-B .



11-A

Photo-12

Install the front Power steering bracket (20145-A) to the water pump using two 3/8 x 3-3/4" SHCS (S272) and two (TP3-1.520) spacer tubes between the Bracket and the Water Pump.



Rear of P/S pump

11-B

20175-B
With 3/4 hex bolt



Photo-12

Photo-13

Check the distance between the front bracket and the power steering pump there should be a gap big enough to fill with one 3/8 washer. If the distance is greater it may be necessary to remove one washer from the rear of the lower rear support to move the pump forward this will achieve a movement of 3/32 of one inch.

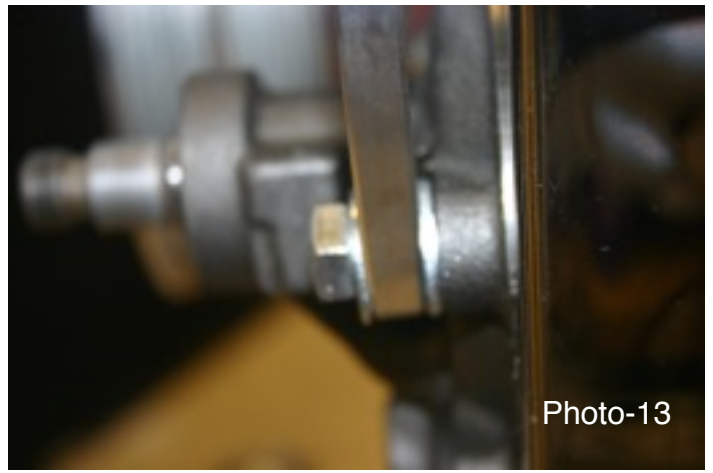


Photo-13

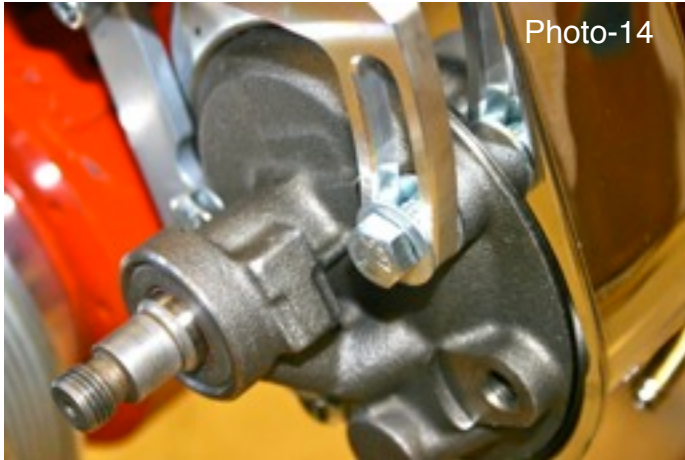


Photo-14

Photo-14

Once proper spacing is achieved secure the front bracket to the pump thru the slot use a 3/8 x 3/4" washer (S666) and a 3/8 x 1" hex bolt (S312) . Note the extra washers provided are for shimming due to differences in the boss on the water pump casting .

Photo-15

Mount the power steering pulley to the pump (623-A) keyed or (624-A) press fit. And check alignment in relation to the crank pulley . Install the power steering belt 5060350 (35") From the crank to the P/S pulley and tighten. Use the adjustment bolt in the P/S slot to secure the belt position with no more the 1/4" of twist in the belt when tight.



Photo-15



Photo-16

Photo-16

If you have not installed the A/C cover (394-A) Do so using three 1/4 x 3/4 Button heads (S124). Now install the 62" belt and tighten with the adjustment rod. Re-check all bolts start motor idle for five minutes and check all bolts and belts. Tech Questions can be answered at March Performance 1-888-729-9070

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