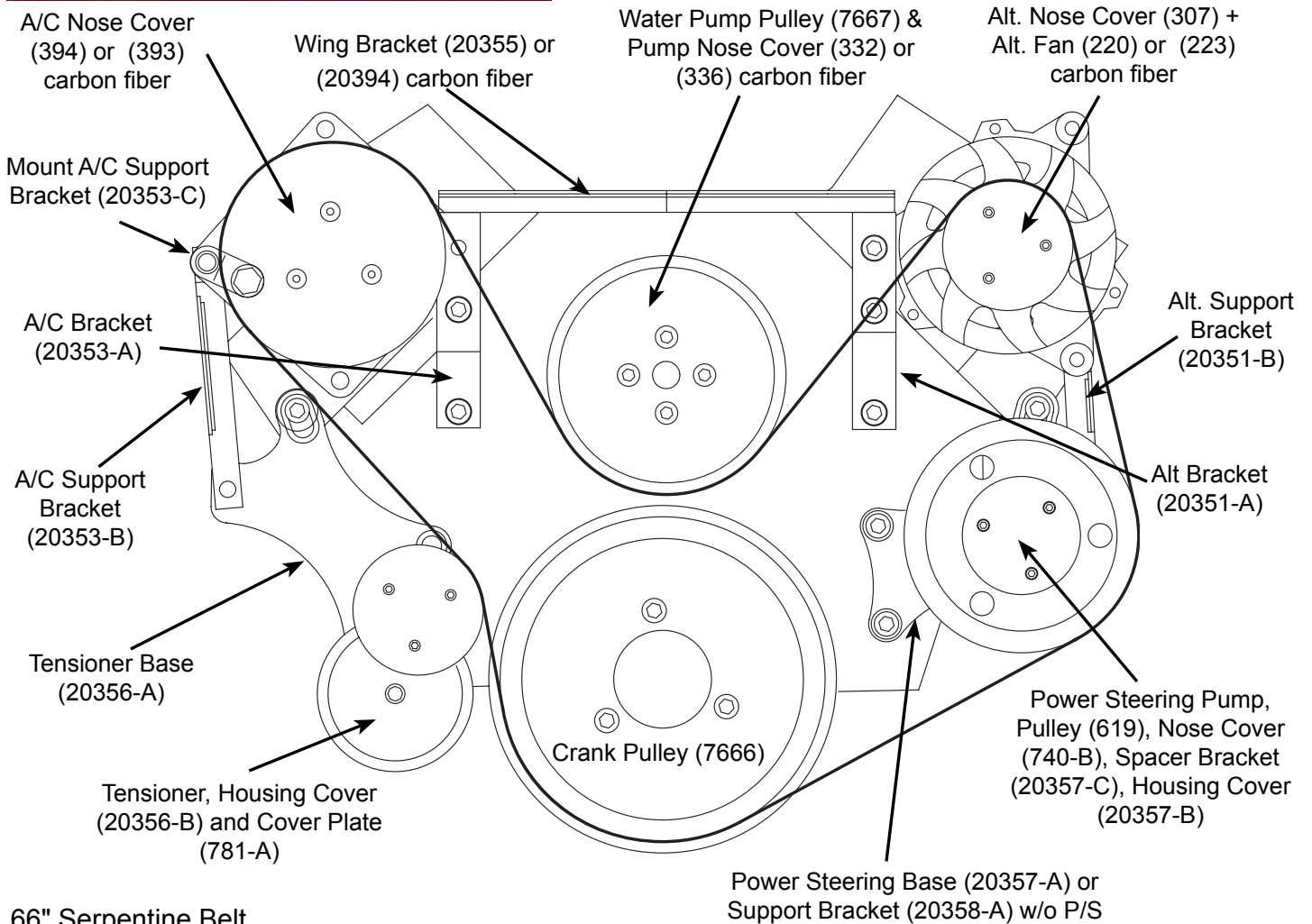




#20360 and #20365 (carbon fiber) Chevy Big Block Front Mount Kit



66" Serpentine Belt

Tensioner

1. Hold Tensioner Body in a vise to remove bolt & washer from tensioner pulley (note; bolt is a left handed thread, turn clockwise to remove). Discard washer.
2. Place Tensioner Cover Plate (781-A) on Tensioner Body & replace pulley.
3. Mount Tensioner Nose Cover Retainer (780-A) on tensioner pulley & replace bolt.
4. Mount Tensioner Assembly to Tensioner Housing Cover (20356-B) using one 3/8-16 x 3" socket head cap screw.
5. Mount Tensioner Base (20356-A) to engine block using two (2) 7/16"-14 x 1" socket head cap screws & to engine head using one Spacer (A7 .500) & one (1) 7/16"-14 x 1/2" socket head cap screw (note; some engine heads use 3/8"-16 x 1 1/2" socket head cap screw).

6. Mount Tensioner Housing Cover (20356-B) & Assembly to Tensioner Base (20356-A) using two (2) 3/8"-16 x 1" socket head cap screws (note; clocking position of Tensioner Pulley, approximately 2 o'clock).

Power Steering Pump (kits with power steering)

7. Mount Power Steering Pump to P/S Spacer Bracket (20357-C) & P/S Housing Cover (20357-B) using two M8X1.25 x 3/4" socket head cap screws.
8. Mount Power Steering Pump Assembly to P/S Base (20357-A) using two (2) 3/8"-16 x 3/4" socket head cap screws (note; line connections toward bottom).
9. Mount P/S Base (20357-A) to engine block using two (2) 7/16"-14 x 1" socket head cap screws & to engine head using one 7/16"-14 x 3/4" socket head cap screw

(note; some engine heads use 3/8"-16 x 3/4" socket head cap screw).

10. Mount P/S Pulley (619) to Power Steering Pump using a pulley installation tool.

11. Mount P/S Nose Cover (740-B) to P/S Pulley (619) using three 8-32 x 3/8" socket head cap screws.

Support Bracket

(kits without power steering only)

12. Mount Support Bracket (20358-A) to engine block using two (2) 7/16"-14 x 1" socket head cap screws & to engine head using one (1) 7/16"-14 x 1" socket head cap screw (note; some engine heads use 3/8"-16 x 1" socket head cap screw). This bracket replaces the power steering pump base on kits with out power steering.

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Alternator

13. Mount Alt. Bracket (20351-A) to Alternator using one (1) $\frac{3}{8}$ "-16 x $3\frac{1}{2}$ " socket head cap screw, one Positioning Bushing, & one (1) $\frac{3}{8}$ "-16 locknut (note; position of Alt. Bracket to Alternator, left side & down from Alternator) (leave loose for positioning).
14. Mount Alt. Bracket (20351-A) & Assembly thru Water Pump mounting holes into engine block using one (1) $\frac{3}{8}$ "-16 x $3\frac{3}{4}$ " socket head cap screw & one (1) $\frac{3}{8}$ "-16 x $5\frac{1}{2}$ " socket head cap screw.
15. Mount Alt. Support Bracket (20351-B) to Alternator using one (1) 8m x 1.25 x 70mm" socket head cap screw & to P/S Base (20357-A) using one (1) $\frac{5}{16}$ "-18 x $\frac{7}{8}$ " socket head cap screw.
16. Tighten Alt. Bracket (20351-A) to Alternator.
17. Mount Alt. Fan (220) or (223) (carbon fiber inserts) to Alternator using supplied nut.
18. Mount Alt. Nose Cover (307) to Alt. Fan (220) using three (1) $\frac{8}{32}$ " - 1" socket head cap screws.

Air Conditioner

19. Mount A/C Bracket (20353-A) to A/C Compressor using one (1) 8m x 1.25 x 100mm" socket head cap screw (note; position of A/C Bracket to A/C Compressor, A/C Compressor lines to the left, A/C Bracket right side & down from A/C Compressor) (leave loose for positioning).
20. Mount A/C Support Bracket (20353-B) & A/C Support Bracket (20353-C) to A/C Compressor using one (1) 8m x 1.25 x 120mm" socket head cap screw (leave loose for positioning).
21. Mount A/C Bracket (20353-A) thru Water Pump mounting holes into engine block using two (2) $\frac{3}{8}$ "-16 x $3\frac{1}{2}$ " socket head cap screws.
22. Mount A/C Nose Cover (394) or (393) (carbon fiber inserts) to A/C Compressor using three (3) $\frac{1}{4}$ "-20 x $\frac{3}{4}$ " button head cap screws.

Crank

23. Mount Crank Pulley (7666) to balancer using three (3) $\frac{3}{8}$ "-16 x 1" socket head cap screws.

Water Pump

24. Mount Water Pump Pulley (7667) & Water Pump Nose Cover (332) or (334) (carbon fiber inserts) to Water Pump using four (4) $\frac{5}{16}$ "-24 x $1\frac{1}{2}$ " socket head cap screws.

Wing Bracket

25. Mount Wing Bracket (20355) or (20394) (carbon fiber inserts) to A/C Bracket (20353-A) & Alt. Bracket (20351-A) using two (2) $\frac{1}{4}$ "-20 x $\frac{3}{4}$ " flat head screws.

Serpentine Belt

26. Install 66" Belt routed as shown (note; with the help of another person, apply a wrench to the tensioner pulley bolt and rotate counterclockwise to force load on tensioner, moving away from crank).(FIG 1)



Fig. 1

27. Mount A/C Support Bracket (20353-B) (with load still on tensioner) to Tensioner Base (20356-A) using one (1) $\frac{3}{8}$ "-16 x 1" socket head cap screw. (FIG 2)

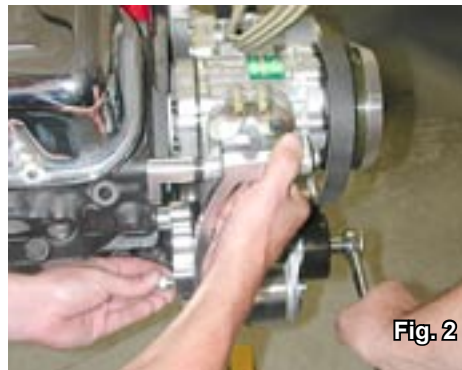


Fig. 2

28. Mount A/C Support Bracket (20353-C) to Head using one (1) $\frac{3}{8}$ "-16 x 1" Hex HCS & one $\frac{3}{8}$ "- $\frac{3}{4}$ " washer (note; some heads use $\frac{7}{16}$ "-14 x 1" Hex HCS). (FIG 3)



Fig. 3

29. Tighten A/C Support Bracket (20353-B) to A/C Compressor.
30. Tighten A/C Bracket (20353-A) to A/C Compressor (release tensioner load).
31. Mount Tensioner Nose Cover (307) to Tensioner Nose Cover Retainer (780-A) using three (3) $\frac{8}{32}$ "- $\frac{5}{8}$ " socket head cap screws.