



## *Highly Styled, Low Cost Serpentine Drive*

Installation Instructions

### *Chevy 409c.i.*

*Kit #21350 (without Power Steering)*

*and #21360 (with Saginaw Style Power Steering)*



## Included Parts List

### Main Front Bracket P/N 21351

- 1 - 21351-A.....Main Front Bracket Body
- 4 - 740-A.....Idler Pulley Body
- 4 - 302-A.....Idler Pulley Cap
- 12 - S022..... $\frac{8}{32}$  x  $\frac{3}{8}$ " SHCS
- 2 - S248..... $\frac{3}{8}$  x 1" SHCS
- 6 - S256..... $\frac{3}{8}$  x 2" SHCS
- 2 - S277..... $\frac{3}{8}$  x 4- $\frac{3}{4}$ " SHCS
- 2 - S339..... $\frac{3}{8}$  x 3" Threaded Stud
- 1 - S550.....8M x 20mm Metric SHCS
- 2 - S551.....8M x 25mm Metric SHCS
- 4 - S666..... $\frac{3}{8}$  id Flat Washer
- 2 - S677.....Gasket Water Pump
- 2 - S785.....3" Threaded Spacer
- 2 - MM100.....Bolt Cap
- 2 - AC3-3.880.....3.880" Lg Alum Spacer

### A/C Rear Support Bracket P/N 21352

- 1 - 21352-A.....A/C Rear Support Bracket Body
- 1 - S150..... $\frac{5}{16}$  x 1 $\frac{1}{2}$ " SHCS
- 2 - S660..... $\frac{5}{16}$ " id Flat Washer
- 1 - S616..... $\frac{5}{16}$ " Lock Nut

### Alternator Rear Support Bracket P/N 21353

- 1 - 21353-A.....Alternator Rear Support Brk Body
- 1 - S276..... $\frac{3}{8}$ " x 4 $\frac{1}{2}$ " SHCS
- 1 - AC3-1.880.....1.880" Lg Alum Spacer

### Belt Adjustment Tool P/N 30436

- 1 - MM101.....R.H. Rod End
- 1 - MM102.....L.H. Rod End
- 1 - MM106.....14 $\frac{3}{4}$ " Threaded Rod

### Power Steering Bracket P/N 21356

#### ONLY IN KIT #21360

- 1 - 21356-A.....Front Power Steering Bracket Body
- 1 - 21356-B.....Rear Power Steering Bracket Body
- 1 - 21356-C.....Power Steering Bracket Spacer
- 2 - S244..... $\frac{3}{8}$ " x  $\frac{3}{4}$ " Hex Hd Bolt
- 1 - S248..... $\frac{3}{8}$ " x 1" SHCS
- 2 - S364..... $\frac{7}{16}$ " x 3 $\frac{1}{2}$ " SHCS
- 1 - TP3-.150......150" Lg Tube Spacer

### Pulley Kit P/N 7790-208

- 1 - 7791-A.....Crank Shaft Pulley Body
- 1 - 7792-A.....Water Pump Pulley Body
- 1 - 208-A.....Alternator Pulley Body
- 1 - 221-A.....Alternator Fan Body
- 1 - 307-A.....Alternator Cap
- 1 - 312-A.....Water Pump Pulley Cap
- 1 - 394-A.....A/C Cover
- 3 - S028..... $\frac{8}{32}$ " x 1" SHCS
- 4 - S186..... $\frac{5}{16}$ " x  $\frac{7}{8}$ " SHCS
- 3 - S292..... $\frac{3}{8}$ " x 1" Fine Thd SHCS
- 3 - S520.....6mm x 20mm Button Hd Bolt
- 1 - S685.....1 $\frac{1}{16}$ " Lock Washer

- 1 - 535-A.....Power Steering Pulley Body  
ONLY IN KIT # 21360
- 1 - 302-A.....Power Steering Pulley Cap  
ONLY IN KIT # 21360
- 3 - S022..... $\frac{8}{32}$ " x  $\frac{3}{8}$ " SHCS  
ONLY IN KIT # 21360

### Accessories

- 1 - P148.....Chevy 409 Alum Water Pump
- 1 - P304.....Saganaw Chrome P/S Pump  
ONLY IN KIT # 21360
- 1 - P412.....A/C Compressor Chrome
- 1 - P417.....A/C Line Adaptors
- 1 - P572.....Alternator Chrome

## 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

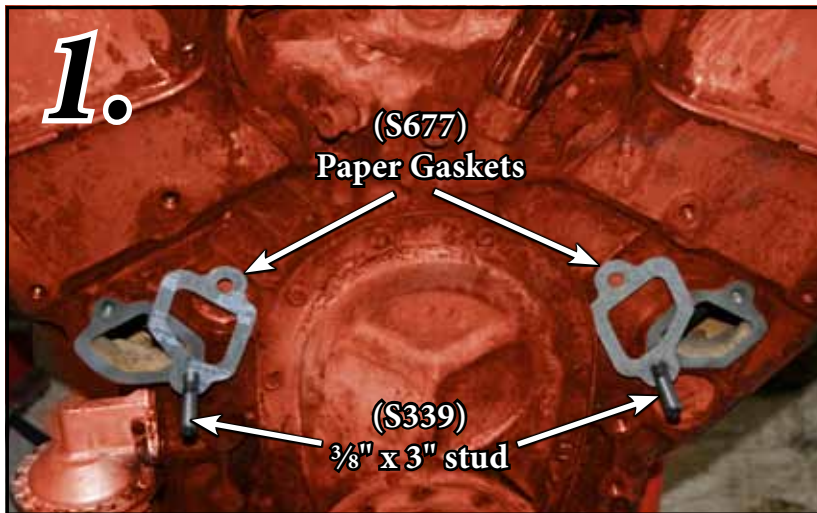
### Serpentine Belt

- 66" for Kits Without Power Steering
- 83 $\frac{1}{2}$ " for Kits With Power Steering

## 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



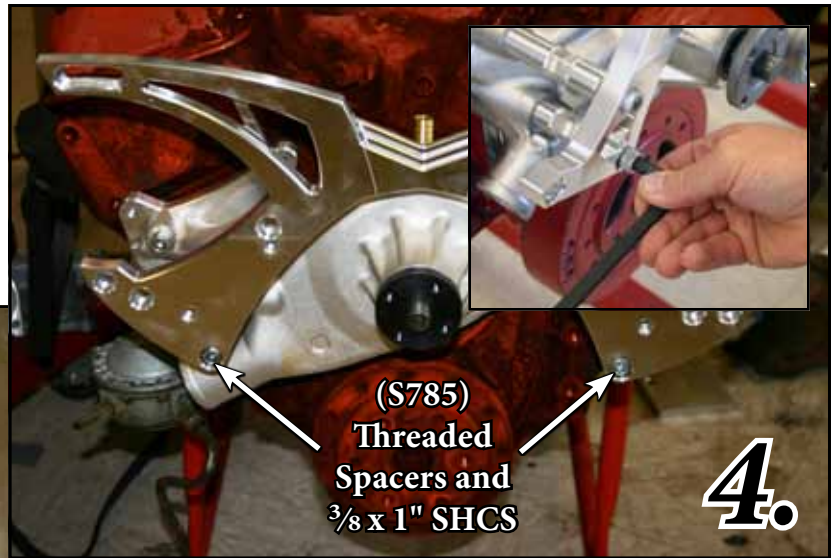
**Photo 1:** Ensure the sealing face of the coolant outlets are clean, flat and free of old gasket material. Apply a small amount of RTV silicone to one end of each mounting stud to prevent coolant seepage. Install the (2) 3" threaded Studs (S339) into the (2) lower waterpump mounting holes then slide (2) waterpump paper gaskets in place (S677).

**Photo 2:** Install the (2) Rear Supports (21352-A) Passenger Side ( $\frac{5}{16}$ " hole in plate) and (21353-A) Drivers Side ( $\frac{3}{8}$ " Tapped Hole in plate) over the studs with the  $\frac{3}{8}$ " Tapped holes leaning to the center of the block.



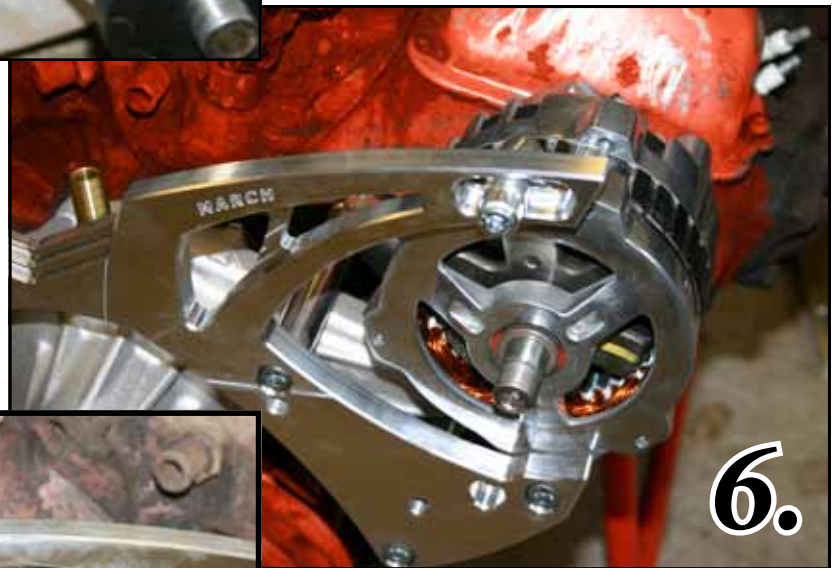
**Photo 3:** Slide The Second Pair of Gaskets (S677) over the studs and install the Provided Water pump (P148). Make sure the gasket mounting holes are in line and secure with (2)  $\frac{3}{8}$  x 2" SHCS (S256) in the upper two water pump holes as shown.

**Photo 4:** Install the (2) 3" Stainless Threaded Spacers (S785) into the two lower water pump holes where the studs are located. Install the Main Plate (21351-A) to the (2) lower threaded Spacers using (2)  $\frac{3}{8}$ " x 1" SHCS (S248) As Shown.



**Photo 5:** Thru the upper two counterbored holes install (2)  $\frac{3}{8}$  X  $4\frac{3}{4}$ " SHCS (S277) and use (2)  $\frac{3}{4}$ " O.D x 3.880 Alum. Spacers (AC3-3.880) Between the Front Main Plate and the two Rear Support Plates

**Photo 6:** Install the Alternator (P572) using a  $\frac{3}{8}$  x  $4\frac{1}{2}$ " SHCS (S276) and a AC3-1.880 Aluminum Spacer between the alternator and the Rear Support. In the upper slotted hole use one MM100 Bushing and one 8M x 25 mm SHCS (S551). (leave loose at this time for adjustment later)



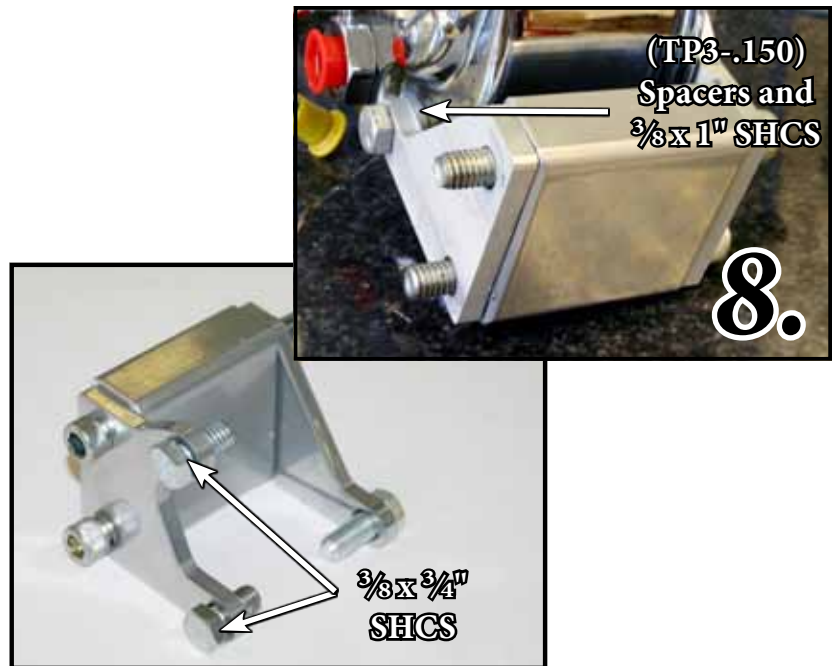
**Photo 7:** Install The A/C Unit (P412). In the upper Slotted Hole use one MM100 Bushing and one 8M x 25 mm SHCS (S551) as per the alternator.

In the lower front mounting hole use one 8M x 20 MM SHCS (S550) and in the rear tying to the Rear lower ear. Use a  $\frac{5}{16}$  x  $1\frac{1}{2}$ " SHCS (S150) and a  $\frac{5}{16}$ " Washer (S660) between the rear support and the A/C mounting ear, Use  $\frac{5}{16}$ " Locknut (S616).

## Kit 21360 with Canister Style Power Steering Pump.

**Photo 8:** Installing the Power Steering unit (P304) and Power Steering bracket. use (2)  $\frac{3}{8}$  x  $\frac{3}{4}$ " SHCS (S244) to mount the power steering pump to the front bracket. (21356-A) Use (1)  $\frac{3}{8}$  x 1" SHCS (S248) and one TP3-.150 Spacer to mount the rear bracket (21356-B) to the pump (P304). Use the spacer between the rear bracket and the pump. Install the spacer block (21356-C) between the two brackets and then install the unit to the block using (2)  $\frac{7}{16}$  x  $3\frac{1}{2}$ " SHCS (S364).

Install the power steering pump pulley (535-A) and attach the pulley cap (302-A) using (3)  $\frac{8}{32}$ " x  $\frac{3}{8}$ " SHCS (S022).



**Photo 9:** Install the (4) Idlers (740-A) into the (4)  $\frac{3}{8}$ " Tapped holes using (4)  $\frac{3}{8}$  x 2" SHCS (S256) and (4)  $\frac{3}{8}$ " Washers (S666).

**Photo 10:** Install the (4) Idler Caps (302-A) with the provided  $\frac{8}{32}$ " SHCS (S022).

Apply Loc-Tite to the threads of the four (S186)  $\frac{5}{16}$ "-24 x  $\frac{7}{8}$ " SHCS. Place the water pump pulley (7792-A) to the water pump and thread the cap screws through pulley and pulley cover (312-A) and into water pump pulley flange, tighten to (28 ft/lbs.) Apply Loc-Tite to the threads of the three  $\frac{3}{8}$ "-24 x 1" SHCS (S292). Place the crank pulley (7791-A) on damper and align holes. Thread the (3) screws through pulley and into damper, tighten to (50 ft/lbs.)



**Photo 11:** Install alternator fan (221-A) and pulley (208-A) and using a  $\frac{11}{16}$ " lock washer tighten pulley nut (impact to 90 ft, pounds). Install Alt Cap (308-A) with (3)  $\frac{8}{32}$ " x 1" SHCS (S028). Place the compressor clutch cover (394-A) onto the compressor clutch and align. Thread the three (3) 6M - 1.0 x 20mm Button Head Bolts (S520), through the cover and into the clutch and tighten. **Caution – Do not over-tighten!**



**Photo 12:** Push the Alternator and A/C units in toward the W/P and mount the drive belt as shown.

**83½" belt for kits with power steering. Non power steering kits will bypass the P/S pulley with a shorter 66" belt.**

Slip the supplied March Adjustment tool (30436) over the (2) (MM100) bushings and use a wrench to turn the adjustment tool outward to tighten the serpentine belt to 100ft. lbs. Use the holes in the adjustment

tool to tighten both M8 socket head cap screws when correct belt tension has been achieved. Remove the adjustment tool and keep for future use. **Important Note: Adjustment tool is NOT designed to be kept on engine while operating.**

Check and tighten all bracket bolts and alternator and A/C 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.

## Final Assembly

If you are going to be installing your air conditioning hoses and charging the system at this time, remove the cover plate on top of the compressor body. Install the (P417) A/C adapter lines, hoses and connect clutch wire and charge system.

**Important:** If you are NOT installing hoses and charging the system at this time, leave cover plate on compressor. Do not connect the clutch wire or apply power to clutch wire without the hoses connected and the system charged – **Serious damage will occur to compressor.**

**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.

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March Performance does not warrant any Product that is damaged from abuse, misuse or misapplication or not used for its intended purposes.

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Normal wear and tear and damage to the Product not caused by March Performance are also excluded from this Warranty.

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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 \*\***