

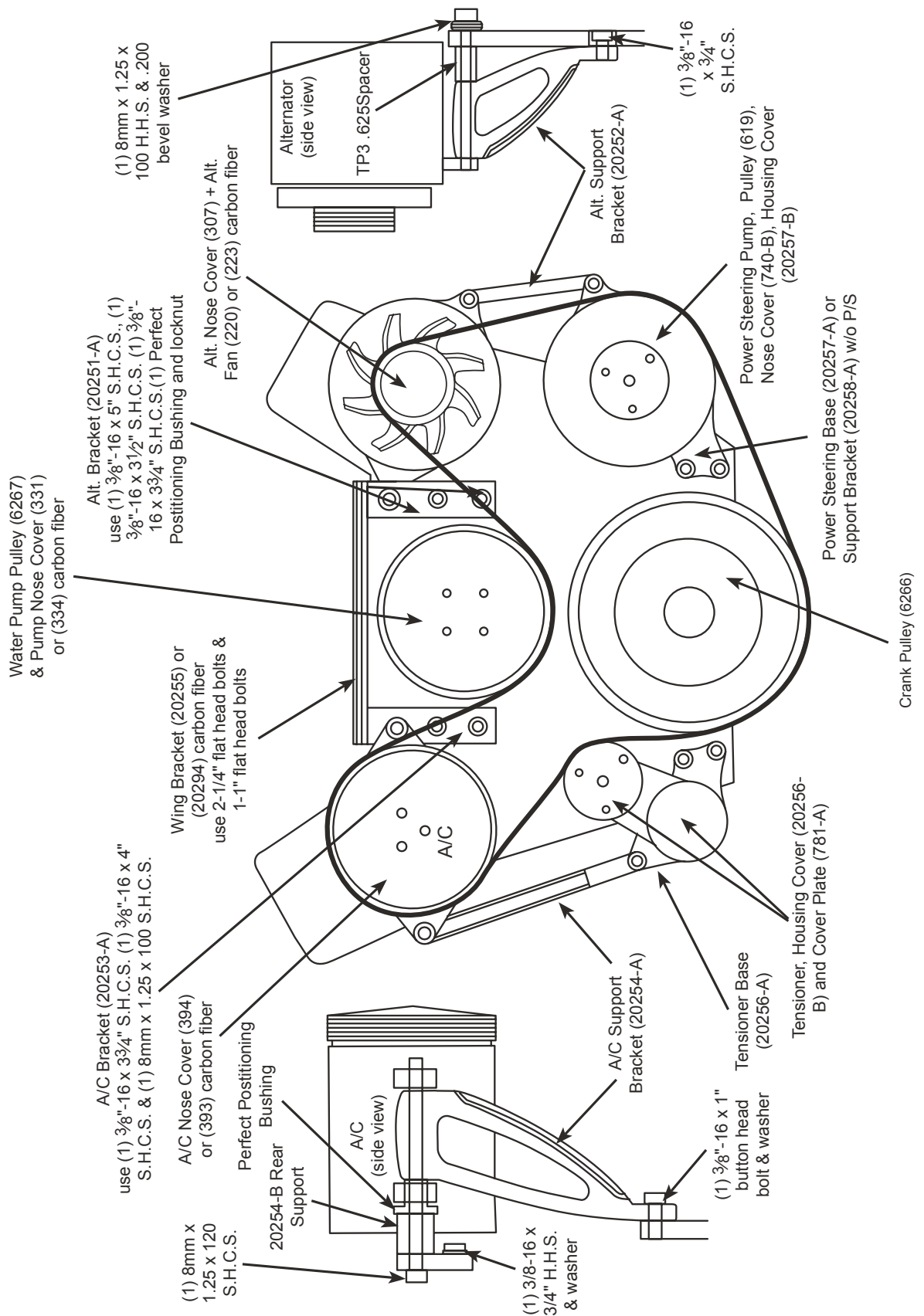


#20250, #20265 #20266, #20260 #20270, #20280

Chevy Small Block Front Mount Kit

Revised 7-1-06

#20270, 20280, Deluxe Kits (w/o Alt Fan, W/P Nose Cover, and A/C Nose Cover)



62" Serpentine Belt (with power steering)  
 61" Serpentine Belt (with out power steering)

S.H.C.S. = Socket Head Cap Screw H.H.S. = Hex Head Screw S.S. = Stainless Steel

## 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.
3. Mount Tensioner Nose Cover Retainer (780-A) on tensioner pulley & replace bolt.
4. Mount Tensioner Assembly to Tensioner Housing Cover (20256-B) using (1)  $\frac{3}{8}$ "-16 x  $3\frac{1}{4}$ " socket head cap screw.
5. Mount Tensioner Housing Cover (20256-B) & Assembly to Tensioner Base (20256-A) using (2)  $\frac{3}{8}$ "-16 x 1" socket head cap screws (note; clocking position of Tensioner Pulley, approximately 2 o'clock).
6. Mount Tensioner Assy. (20256-A) to engine block using (2)  $\frac{3}{8}$ "-16 x 1" socket head cap screws.

## Power Steering Pump (kits with power steering)

7. Mount Remote Power Steering Pump to P/S Housing Cover (20257-B) using two M8X1.25 x 20mm socket head cap screws.
8. Mount Power Steering Pump Assembly to P/S Base (20257-A) using (2)  $\frac{3}{8}$ "-16 x  $\frac{3}{4}$ " socket head cap screws (note; line hose toward bottom).
9. Mount P/S Base (20257-A) to engine block using (2)  $\frac{3}{8}$ "-16 x 1" socket head cap screws. Insert .200 bevel washer and (1) 8-1.25 x 1-- H.H.S. Through upper base bracket hole (fig. 2 item A) Bolt must be in P/S before bolting to engine due to exhaust clearance.
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  $\frac{3}{8}$ " socket head cap screws.

## Support Bracket (kits without power steering only)

12. Mount Support Bracket (20258-A) to engine block using (2)  $\frac{3}{8}$ "-16 x 1" socket head cap screws. This bracket replaces the power steering pump base on kits with out power steering. Insert .200 bevel washer and (1) 8-1.25 x 1-- H.H.S. Through upper base bracket hole (fig. 2 item A) Bolt must be in P/S before bolting to engine due to exhaust clearance.

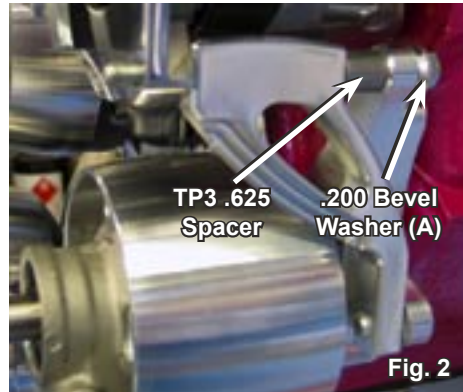
## Alternator

13. Mount Alt. Bracket (20251-A) to Alternator using (1)  $\frac{3}{8}$ "-16 x  $3\frac{3}{4}$ " socket head cap screw, one Positioning Bushing,

& (1)  $\frac{3}{8}$ "-16 locknut (note; position of Alt. Bracket to Alternator, left side & down from Alternator) (leave loose for positioning). (Note: perfect positioning bushing will draw alt into position when tightened).

14. Mount Alt. Bracket (20251-A) & Assembly thru Water Pump mounting holes into engine block using (1)  $\frac{3}{8}$ "-16 x 5" socket head cap screw in top hole and (1)  $\frac{3}{8}$ "-16 x  $3\frac{1}{2}$ " socket head cap screw in bottom hole.

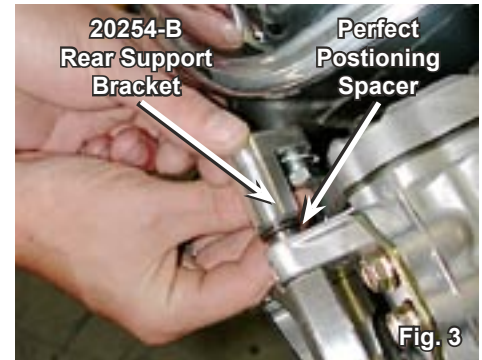
15. Mount Alt. Support Bracket (20251-B) to Alternator using (1) 8mm x 1.25 x 100mm" hex head screw, and TP3 .625 spacer between P/S bracket and support bracket as shown (fig.2). Mount support bracket (20251-B) to P/S Base (20257-A) using (1)  $\frac{3}{8}$ "-16 x  $\frac{3}{4}$ " socket head cap screw.



16. Tighten Alt. Bracket (20251-A) to Alternator.
17. Using an impact gun mount Alt. Fan (220) to Alternator using supplied nut and lock washer
18. Mount Alt. Nose Cover (307) to Alt. pulley Fan (220) or (223) carbon fiber using (1)  $\frac{8}{32}$ " - 1" socket head cap screws.

## Air Conditioner

19. Mount A/C Bracket (20253) to A/C Compressor using one (1) 8mm x 1.25 x 100 hex head 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 (20254-A) & A/C Support Bracket (20253-B) to A/C Compressor using (1) 8mm x 1.25 x 120 socket head cap screw making sure to run bolt through rear support bracket first and then perfect positioning bushing (fig.3) (leave loose for positioning).
21. Mount A/C Bracket (20253-A) through Water Pump mounting holes into engine block using (1)  $\frac{3}{8}$ "-16 x  $3\frac{3}{4}$ " socket head cap screw in bottom hole and (1)  $\frac{3}{8}$ "-16 x 4" socket head cap screw in top hole.



22. Mount rear support bracket (20254-B) to cylinder head using (1)  $\frac{3}{8}$ "-16 x  $\frac{3}{4}$ " hex head bolt and (1)  $\frac{3}{8}$ " x  $\frac{3}{4}$ " flat washer.
23. Attach A/C support bracket (20254-A) to tensioner base (20256-A) using (1)  $\frac{3}{8}$ " x 1" button head bolt and (1)  $\frac{3}{8}$ " x  $\frac{5}{8}$ " flat washer.
24. Mount A/C Nose Cover (394) or (393) carbon fiber to A/C Compressor using (3)  $\frac{1}{4}$ "-20 x  $\frac{3}{4}$ " button head cap screws.

## Crank

23. Mount Crank Pulley (6266) to balancer using three (3)  $\frac{3}{8}$ "-24 x 1" socket head cap screws. Reinstall dampener bolt per factory specs.

## Water Pump

24. Mount Water Pump Pulley (6267) & Water Pump Nose Cover (331) or (334) carbon fiber 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 (20255) or (20294) with carbon fiber inserts to A/C Bracket (20253-A) & Alt. Bracket (20251-A) using (2)  $\frac{1}{4}$ "-20 x  $\frac{3}{4}$ " flat head screws. Wing Bracket (20255) has an extra center mounting hole to your water pump center use a 1" flat bolt there, you may need a washer there. Make sure all bolts on assembly are tight.

## Serpentine Belt

26. Install 62" (61" non power steering kit) 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).
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.