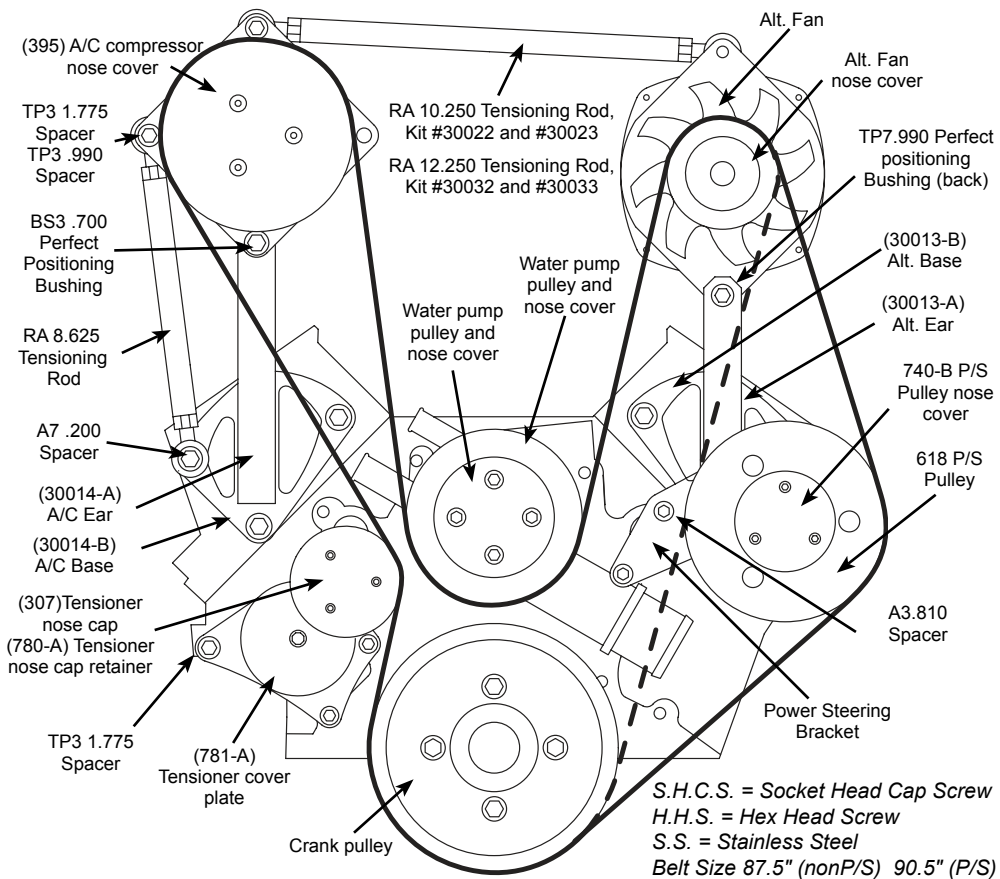




# Ford Small Block High Mount

**#30022 + #30023 (non P/S)**  
**#30032 + #30033 (w/ P/S)**

Revised 8-8-07



## Assembly Instructions

### 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 Nose Cover (307) to Tensioner Nose Cover Retainer (780-A) using three 8-32 x 5/8" socket head cap screws.
5. Mount Tensioner to Tensioner Base (30019) using one 5/16-18 x 3" socket head cap screw.
6. Mount Tensioner Base (30019) to engine block thru water pump mounting holes using two 5/16-18 x 2 3/4" socket head cap screws & to engine block using one 3/8-16 x 3"

socket head cap screw & one Spacer (TP3 1.775), placing Spacer (TP3 1.775) between Tensioner Base (30019) & engine block.

### Power Steering Pump (P/S Kits)

7. Mount P/S Base (30016) & pump per assembly instructions (5.0 Street Rod Power Steering Bracket).

8. Mount P/S Pulley.

### Alternator

9. Mount Alt. Bracket Assembly (30013) to engine head using three 7/16-14 x 1" socket head cap screws (note; some engine heads use 3/8-16 x 1" socket head cap screw).
10. Mount Alternator to Alt. Ear (30013-B) using one 7/16-14 x 4 1/2" socket head cap screw, one Perfect Positioning Bushing (TP7 .990), & one 7/16-14 Locknut.

### Air Conditioner

11. Mount A/C Bracket Assembly (30014) to engine head using two 7/16-14 x 1" socket head cap screws (note; some engine heads use 3/8-16 x 1" socket head cap screw).
12. Mount A/C Compressor to front part of A/C Ear (30014-B) using one 3/8-16 x 1 1/2" socket head cap screw & one 3/8-16 Locknut.
13. Mount A/C Compressor to back part of A/C Ear (30014-B) using one 3/8-16 x 1 3/4" socket head cap screw, one Perfect Positioning Bushing (BS3 .700), & one 3/8-16 Locknut.
14. Mount Tensioner Rod (RA 6.625) end to A/C Compressor using one Spacer (TP3 1.775-between rod end & rear of A/C Compressor), one Spacer (TP3 .990-between rod end & front of A/C Compressor), one 3/8-16 x 5" socket head cap screw, & one 3/8-16 Locknut.
15. Mount other end of Tensioner Rod (RA 8.625) to engine head thru A/C Base (30014-A) using one 7/16-14 x 2" socket head cap screw (note; some engine heads use 3/8-16 x 2" socket head cap screw) & one Spacer (A7 .200-between rod end & A/C Base).

### Pulleys

16. Install Pulleys (3 piece) per assembly instructions (PT# 1000- Instructions for 5.0L Ford 3 piece).

### Serpentine Belts

17. Install Belt routed as shown.
18. Mount Tensioner Rod (\*RA 10.250) end to Alternator from back using one 3/8-16 x 1 1/4" socket head cap screw.
19. Mount other end of Tensioner Rod (\*RA 10.250) to A/C Compressor using one 3/8-16 x 1 1/2" socket head cap screw & one 3/8-16 Locknut.
20. Adjust Tensioner Rods (RA 8.625 & \*RA 10.250) to appropriate belt tension.

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