60415
CHEVROLET SMALL BLOCK ENGINE ACCESSORY BRACKETS
INSTALLATION INSTRUCTIONS
(60416, 60417 and 60418 also included)

The 60415 Chevrolet small block bracket kit includes the 60416 power steering kit, the 60417 a/c compressor kit and the 60418 alternator kit. These kits are designed to mount the accessories using factory pulleys, reverse rotation water pump and a serpentine belt. The compressor recommended is a Sanden style, the alternator is a standard Delcotron and the power steering pump is a late 70's and later GM.

The following GM pulley part numbers are for your convenience.

Crankshaft - 10085754
Water pump - 10085760
Alternator - 1985964
Power steering - 10085755

NOTE; The 1"X 3/8" thick wall spacer included is for spacing the pulley on the alternator when changing from a "V"belt to serpentine style.

NOTE: Be sure that all head and block mounting holes are clean and free of burrs before starting assembly.

A/C COMPRESSOR

1: Mount water pump on engine using all 4 original bolts for proper pump alignment. After tightening the 2 bolts on the drivers side, remove the 2 bolts on the passenger side as illustrated in photo 1.

2: Install the support bracket to the intake manifold with a 1 1/4" bolt and lock washer and finger tighten as in photo 2.

3: Install the front support bracket to the water pump with 2 - 4" bolts, lock washers and 1 1/2" spacers ,between the pump and the bracket, and finger tighten as shown in photo 3.

4: Install the slotted adjusting bracket (slot up), the "v" shaped support bracket and a 3/16" spacer, in that order, to the head with a 1 1/4" bolt and lock washer and finger tighten as shown in photo 4.

5: Install the compressor to the brackets using 1 1/2" bolts, lock washers and nuts. Note the water pump and manifold brackets are on the front of the mounting lugs. The "v" and slotted brackets are on the rear of the mounting lugs a shown in photo 5.
ALTERNATOR AND POWER STEERING PUMP

1: Preassemble the front (flat) alternator bracket to the rear (offset) alternator bracket using 3 - 3/8 X 4 3/4" bolts and 3 - 3 1/4" spacers (between the brackets). Install the power steering bracket on to the lower 2 bolts and add a 1/4" spacer to each bottom bolt and a 7/16" spacer to the remaining top bolt. See photo 6.

2: Attach assembly to head and tighten bolts only enough to hold assembly in place as shown in photo 7.

3: Attach outer pump support bracket to the main bracket with 2 - 3/8 X 4" bolts and lock washers using 2 - 2 5/8" spacers between the brackets and 2 - 1/4" spacers between the main bracket and the engine block as shown in photo 8.

4: Install the pump to the outer support bracket as shown in photo 9.

5: Attach the pump to the main bracket with the adjusting stud, through the adjusting slot, and with the lower support bolt. A 1/4" spacer must be installed between the pump and the lower support, of the main bracket, as shown in photo 10.

6: Tighten all mounting bolts being sure of proper alignment of all pulleys.

7: Install the belt, as shown in photo 11, and tighten the remaining adjusting bolts.

8: Start engine and check for proper operation.

ALTERNATOR WITHOUT POWER STEERING (SHOWN IN PHOTO 12)

1: Assemble the flat (front) and the offset (rear) brackets together using 3 - 4 3/4" bolts and 3 - 3" spacers and the attach assembly to the head using 7/16" spacers between the rear bracket and the head. Finger tighten the bolts.

2: Install the alternator between the brackets using the 3/8 X 3" bolt, lock washer and nut.

3: Install the adjusting bracket on the alternator with the 5/16 X 1"bolt and finger tighten

4: Install the 3/8 X 1 1/4" bolt through the adjusting slot in the front bracket and the hole in the adjusting bracket. Install a lock washer and nut and finger tighten.

5: Install the belt and tighten all bolts and nuts. See illustration for proper belt installation. Start engine and check for proper operation.

1/19/98

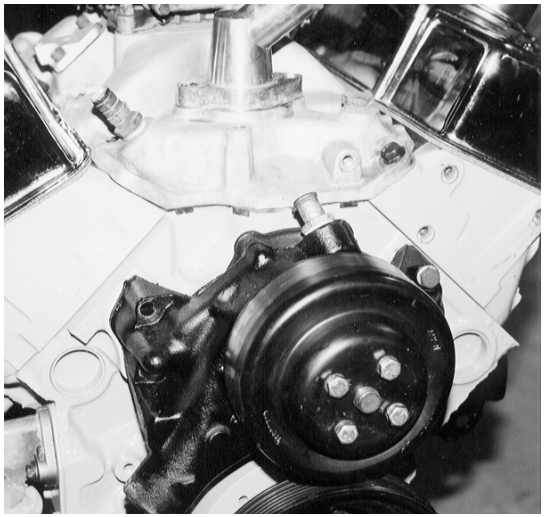


PHOTO #1

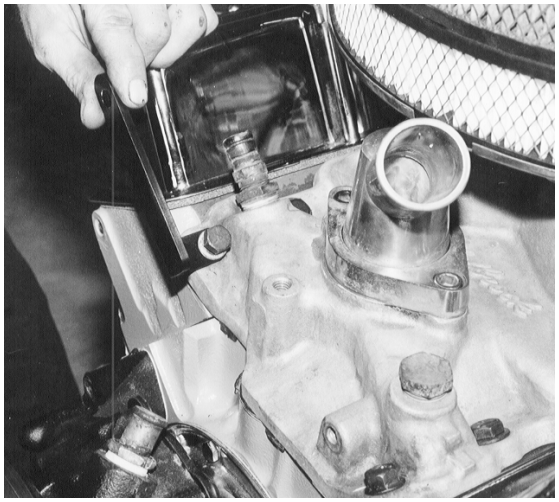
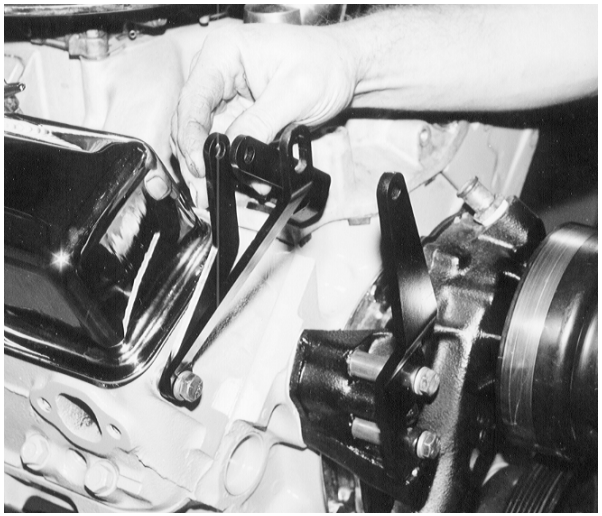


PHOTO #2

PHOTO #3



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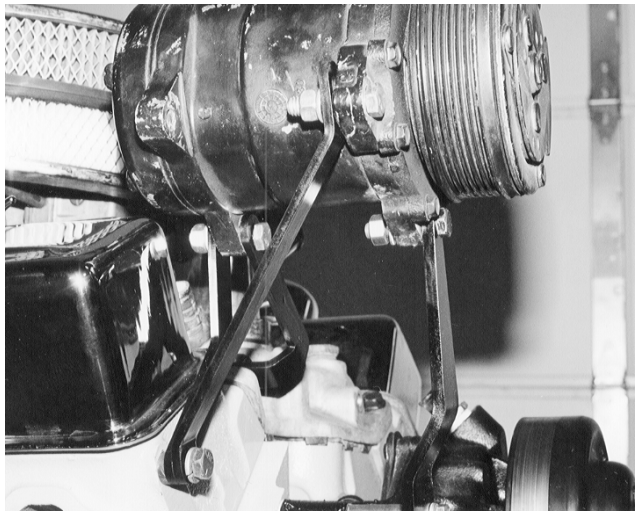
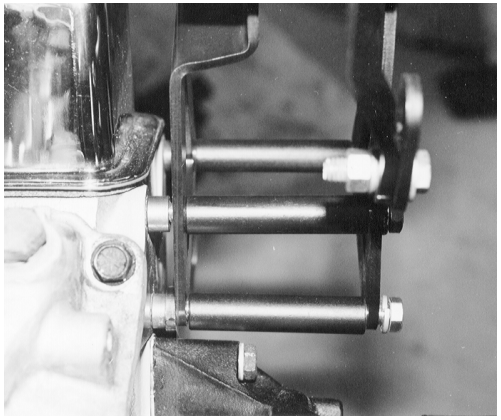


PHOTO #5

PHOTO #6



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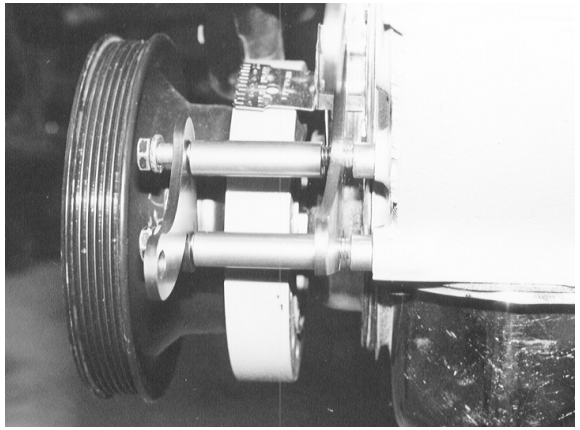

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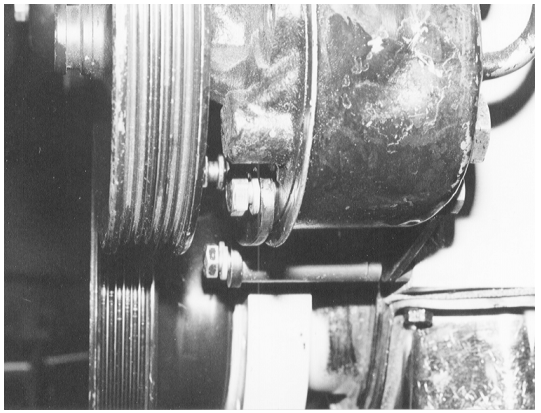

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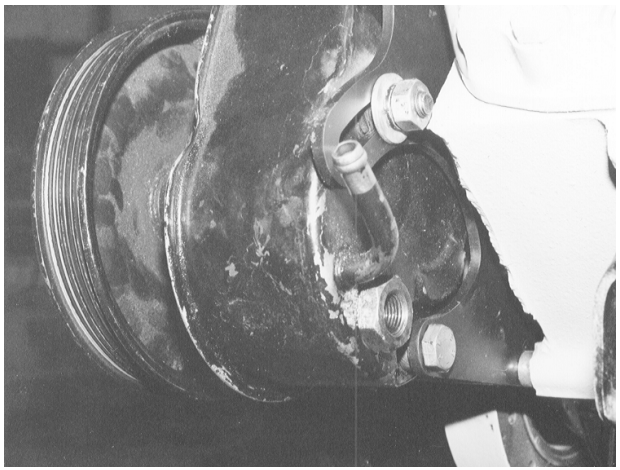

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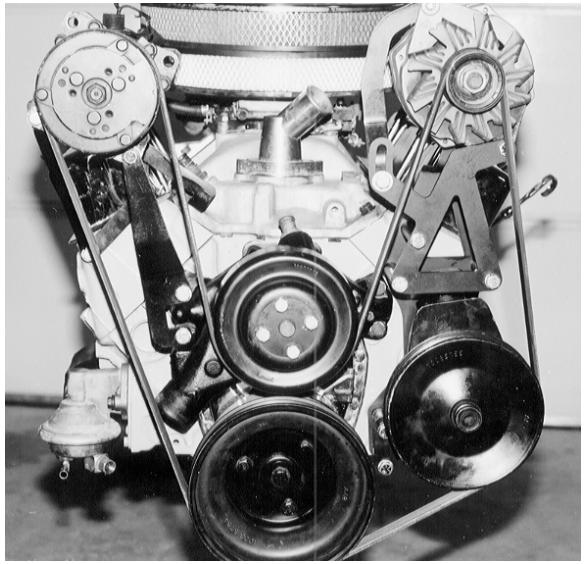

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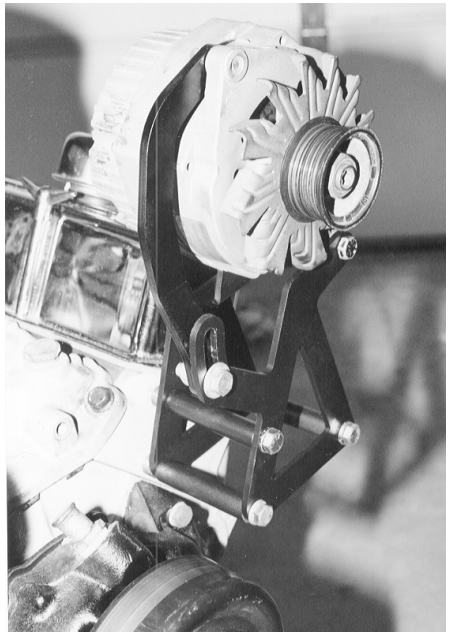

PHOTO #12