

NOTICE

TO PROTECT & PRESERVE YOUR BLACK POWDER
PAINTED OR CHROME PLATED BRACKETS' FINISH,
BE SURE AND APPLY A GOOD QUALITY WAX SUCH AS
CARNAUBA, AS NEEDED.



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INSTALLATION INSTRUCTIONS

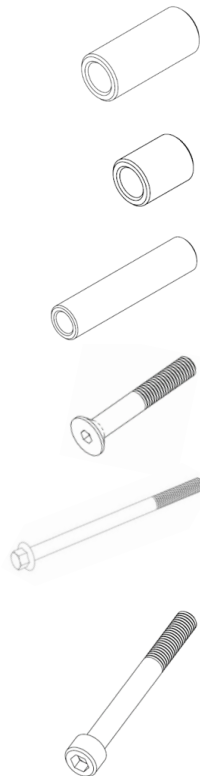
1500 Series

916-68044

TO MAKE INSTALLATION EASIER, PLEASE READ ALL THE INSTRUCTIONS BEFORE INSTALLING THE BRACKET.

Installation Kit for Bill's Hot Rods LS Accessory Drive Bracket Kits - Part Number 916-68044

Required for 1999 – 2013 Truck crankshaft pulley when installing
Speedway Motors / Bill's Brackets part number 916-68040 or 916-68041.



QTY	DESCRIPTION	APPLICATION
9	Alternator Bracket Spacer, 40 mm	Between Driver's Side Bracket & Head, & Passenger's Side Bracket & Water Pump
2	A/C Bracket Spacer, 18 mm	Between Passenger's Side Rear Bracket & Head
1	Mid A/C Bracket Spacer, 78 mm	Between Passenger's Side A/C Brackets
1	Flat Head Cap Screw, M10 x 1.5 x 45	Passenger's Side Rear A/C Bracket to Head
2	Hex Head Bolt w/ Washer, M8 x 1.25 x 120	Water Pump Mounting Bolt
1	Socket Head Cap Screw, M10 x 1.5 x 45	Rear Passenger's Side A/C Bracket
2	Socket Head Cap Screw, M10 x 1.5 x 65	Driver's & Passenger's Side Brackets
5	Socket Head Cap Screw, M10 x 1.5 x 110	Driver's Side Bracket to Head
1	Socket Head Bolt, M10 x 1.5 x 145	Passenger's Side Ribbed Idler Pulley

TORQUE 10MM CAP SCREWS TO 37 FT. LBS. AND 8MM CAP SCREWS TO 22 FT. LBS.

When used with **PART # 916-68040**

HOW TO INSTALL YOUR LS SWAP ALTERNATOR KIT

1

REMOVE the plastic sleeves from existing socket head cap screws in the bracket assembly.

2

REMOVE 4 10x1.5x65 socket head cap screws from bracket.

3

From spacer kit, install 4 10x1.5x110 socket head cap screws.

4

From spacer kit, install 4 42mm length spacers on socket head cap screws so as to locate them between the head and bracket assembly.

5

Bolt the bracket assembly to the cylinder head.

If you plan to install A/C Bracket 916-68042, skip steps 6 through 9.

6

REMOVE 2 10x1.5x30 socket head cap screws from the passenger side idler assembly.

7

From the spacer kit, install 2 10x1.5x45 socket head cap screws.

8

From the spacer kit, install 2 22mm length spacers on socket head cap screws so as to locate them between the water pump and bracket assembly.

9

Bolt the bracket assembly to the water pump.

When used with **PART # 916-68041**

HOW TO INSTALL YOUR LS SWAP ALTERNATOR/POWER STEERING PUMP KIT

1

REMOVE the plastic sleeves from existing socket head cap screws in the bracket assembly.

2

REMOVE 4 10x1.5x65 socket head cap screws from bracket.

3

From spacer kit, install 4 10x1.5x110 socket head cap screws and 1 10x1.5x65 socket head cap screw.

4

From spacer kit, install 5 42mm length spacers on socket head cap screws so as to locate them between the head and bracket assembly.

5

Bolt the bracket assembly to the cylinder head.

If you plan to install A/C Bracket 916-68042, skip steps 6 through 9.

6

REMOVE 2 10x1.5x30 socket head cap screws from the passenger side idler assembly.

7

From the spacer kit, install 2 10x1.5x65 socket head cap screws.

8

From the spacer kit, install 2 42mm length spacers on socket head cap screws so as to locate them between the water pump and bracket assembly.

9

Bolt the bracket assembly to the water pump.

When used with PART # 916-68042

HOW TO INSTALL YOUR LS SWAP A/C COMPRESSOR KIT

1

Depending on your water pump, it may be necessary to remove it to gain access to the bolt hole in the cylinder head that is closest to the center of the engine.

2

REMOVE the plastic sleeves from existing socket head cap screws in the bracket assembly.

3

REMOVE the 10x1.5x25 flat head cap screw and the 10x1.5x30 socket head cap screw from the bracket.

4

From spacer kit, install a 10x1.5x45 flat head cap screw and a 10x1.5x45 socket head cap screw in the bracket.

5

From spacer kit, install the 2 18mm length spacers on the cap screws so as to locate them between the head and bracket assembly.

6

BOLT the bracket assembly to the cylinder head.

7

If you found it necessary to remove the water pump, install it at this time.

8

REMOVE the passenger side grooved idler assembly.

9

REMOVE the 122mm socket head cap screw and the 52mm spacer.

10

From the kit, install the 145mm socket head cap screw and the 78mm spacer.

11

BOLT the outer plate to the inner plate. Do not fully tighten.

12

REMOVE the 10x1.5x30 socket head cap screw from the idler bracket and the 10x1.5x80 socket head cap screw from passenger side smooth idler pulley assembly.

13

From the kit, install 1 10x1.5x45 socket head cap screw and the 10x1.5x122 socket head cap screw in the bracket that was removed in step 9 from the smooth idler pulley.

14

From the spacer kit, install 2 42mm length spacers on the cap screws so as to locate them between the water pump and bracket assembly.

15

Bolt the front plate to the rear plate.

16

On the driver's side, remove the 2 lower water pump cap screws from the water pump.

17

From the spacer kit, install 2 8x1.5x120 hex head cap screws along with 2 42mm spacers and attach the smooth idler pulley assembly to the water pump.

- Use caution when attaching to the water pump as different castings may require adding spacers to or removal of material from the water pump to keep proper alignment of the idler pulley.

18

Using the socket head cap screws and horse shoe shaped retainer included with the bracket assembly, attach the power steering pump to the bracket assembly.

- The power steering bracket is designed for use with a 1998-2002 F-Body power steering pump (GM Part # 26086074) and pulley (GM Part # 12559885). Other type 2 pumps may fit, however there may be pulley interference issues.