



## INSTALLATION INSTRUCTIONS

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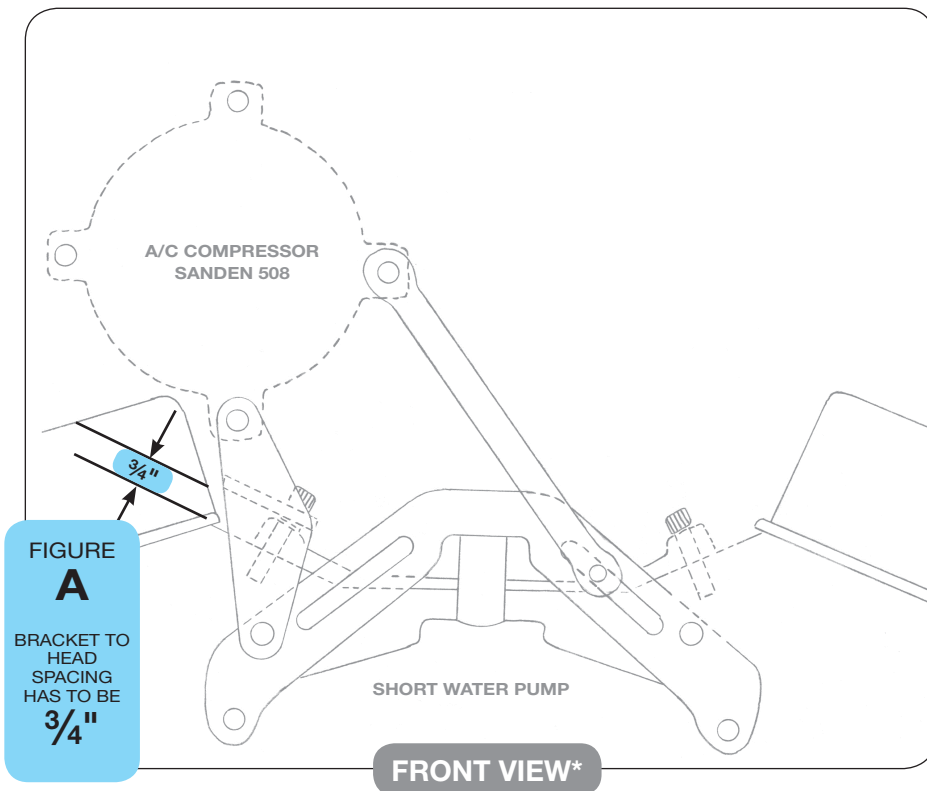
**916-67923**  
**404 / 405 / 406**

Air Conditioner bracket designed for the Big Block Chevy

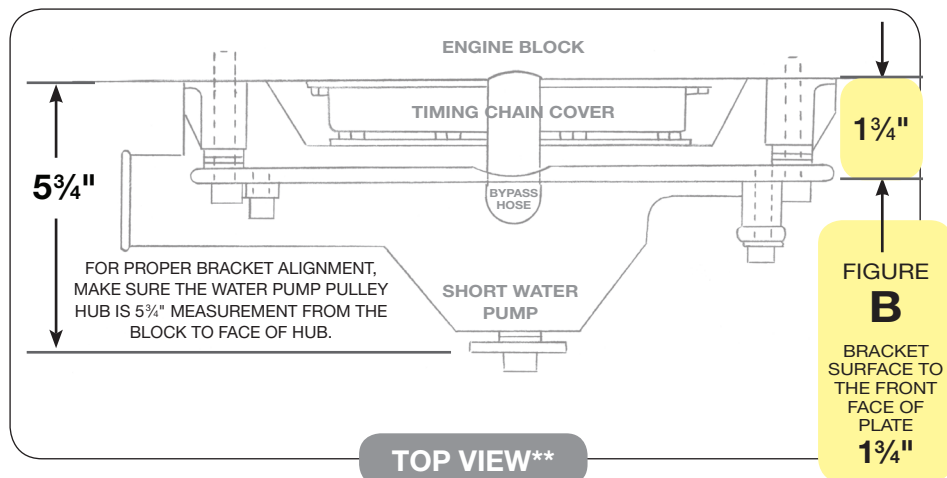
Bracket will work with Chevy Big Block 396 to 502 Engines  
with the **SHORT WATER PUMP ONLY**

Positions the air conditioner unit over the intake manifold and  
just to the inside edge of the valve cover

Mounting is achieved using **ONLY** the water pump  
and intake manifold bolts



\* VIEW LOOKING AT BRACKET FROM FRONT OF ENGINE COMPARTMENT



\*\* VIEW LOOKING FROM ABOVE ENGINE COMPARTMENT DOWNWARD

### TROUBLE SHOOTING:

If the brackets are **NOT** aligning properly to the belt groove in the pulleys, check to see that:

- The water pump pulley is aligned with the crank pulley, since there are variations on the water pump flange spacing. If this is not correct, you will either have to push or pull the flange to align, or change the pulley to get the proper alignment or use our water pump pulley shims, part #1003.
- The intake manifold to bracket thickness is  $\frac{3}{4}$ " or as close as possible (plus or minus  $\frac{1}{16}$ ").
- The adjusting plate is set at the  $1\frac{3}{4}$ " distance. Too far out will push the bracket alignment up; too far in will pull the bracket down and can also cause the bracket to rotate a little and cause misalignment on the horizontal plane.

### WARRANTY INFORMATION:

Our products are guaranteed against faulty parts or workmanship for one year from date of purchase. All warranty work must be accompanied by the original invoice (photo copy acceptable). Parts will then be repaired or replaced as needed. The warranty is void due to customer misuse or any alteration of the product.

### 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.**



phone 800.979.0122 fax 800.736.3733

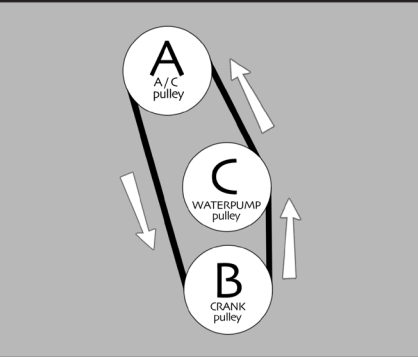
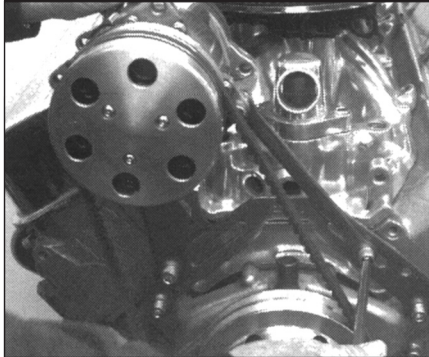
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## BELTS INSTALLATION

### AIR CONDITIONER BELT INSTALLATION

**SUGGESTED BELT: TRY GATES BELT # 7541 or 7545**



**7**

#### INSTALL THE AIR CONDITIONER BELT IN THE FOLLOWING ORDER:

FIRST (A) A/C Pulley, SECOND (B) Crank Pulley, THIRD (C) Water Pump Pulley  
ADJUST the tension, tighten all the bolts and check for proper alignment.

#### BELT ADJUSTING TIPS:

**NOTE:** Due to the limited adjustment range of the belt when the A/C is put between the valve covers and the intake manifold, you may have to do one or both of the following steps to get a belt to adjust properly.

- If the belts you try are too short on the pulleys, but the next size is too long, try a narrower belt first. If that does not work, proceed to the next step.
- Take the top bolt out of the A/C that holds the adjusting arm to the A/C. Slip the belt over the crank pulley first, then over the water pump pulley, and then into the A/C pulley, then pull the unit up to where you can put in the bolt for the adjusting arm and snug up. Then proceed to use the adjusting arm as normal to get the proper tension. This works well for use when there are no alternate belt lengths or widths to try, but are close to one of them so adjustment can be achieved.

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

### 6 STEPS FOR EASY INSTALLATION:

- **TOOLS REQUIRED:** 1/4" Allen Wrench, 5/16" Allen Wrench

- **COMPONENT NEEDED:**

Use a SANDEN SD-508 Compressor

- **PRE-ASSEMBLED:**

The brackets come pre-assembled with all the bolts and spacers in the positions they will be in when installed on the engine. This, along with the drawings and photos to refer to, will make assembly easier.

When installing the bracket, leave all the bolts slightly loose until alignment of the belt, belt length and bracket positioning have been verified. If it looks good, go ahead and tighten the bolts and adjust the belt tension.

- **ALIGNMENT:**

For proper bracket alignment, there are 2 dimensions that must be as close as possible to the ones shown on the diagrams on page 2.

First set the adjusting plate 1 3/4" from the block surface (at water pump base) to the face of the plate, see **FIGURE B.**

Second, the bracket to the head surface spacing is 3/4" see **FIGURE A.**

- **WASHERS:**

All washers are 1/16" thick stainless steel washers, except for 2, which are 1/8" thick steel washers. Simply add or subtract as needed to achieve the required dimensions.

- **FINAL ASSEMBLY OF BRACKETS ON ENGINE:**

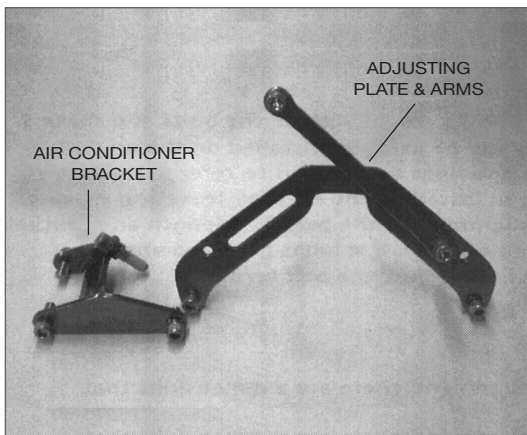
Use **LOCTITE #242** (Blue) on all bolts to prevent bolt loosening.

## PRE-PREP FOR INSTALLATION



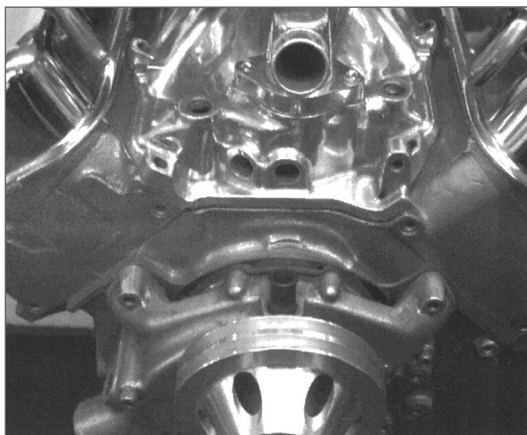
**1**

STRAIGHT OUT OF THE BOX, you will find your bracket is PRE-ASSEMBLED and ready for you to install.



**2**

REMOVE the air conditioner bracket and set to the side, keeping the adjusting arm together as shown in the photo.

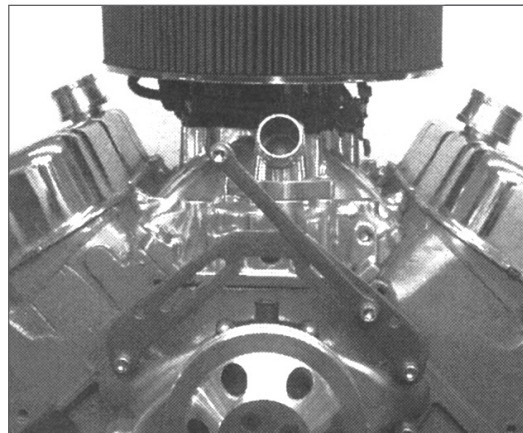


**3**

REMOVE the 2 upper water pump bolts.

REMOVE the right front (passenger side) intake manifold bolt.

## BRACKET INSTALLATION



**4**

INSTALL the Adjusting Plate, Arm to the Water Pump with the bolts provided.

Be sure and achieve the required 1 3/4" Spacing.

See **FIGURE B** on the dimension diagram chart on page 2.



**5**

ATTACH the A/C Bracket to the Adjusting Plate and add washers as needed to achieve the 3/4" total thickness needed from the manifold gasket surface to the bracket base.

See **FIGURE A** on the dimension diagram chart on page 2.



**6**

MOUNT the A/C to the bracket.

Next, BOLT the adjusting arm to the compressor as shown below.

