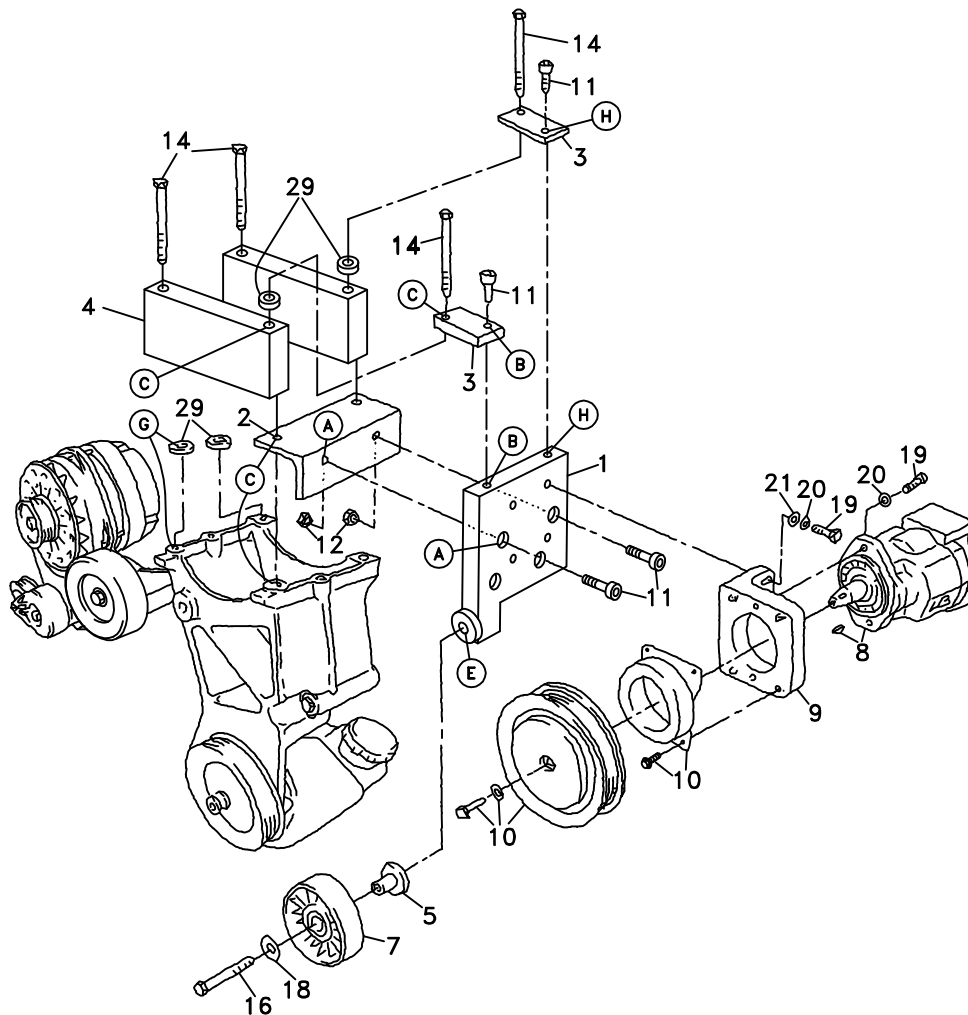


710071	Bracket Assy. (Inc. items 1-4)		Kit No.	70091
711022	Bracket Bolt Pkg. (Inc. items 11, 12, 14, 19-21, 29)		Make	Chevy
None	Pulley Bolt Pkg. (Inc. items)		Engine	454
711013	Idler Bolt Pkg. (Inc. items 5, 16, 18)		Fuel	Gas
None	Fan Spacer Bolt Pkg. (Inc. item)		Year	1996
			Options	Without A/C
			Revised	C 2-13-04

ITEM	PART #	DESCRIPTION			
1.	711023	Plate/Pump Mount	16.	110179	7/16NC x 2 3/4 bolt
2.	711017	Angle/Bottom Plate Mount	17.	-----	-----
3.	711016	Tab/Top Mount	18.	110670	7/16 Flat washer
4.	711025	Block/Replacement	19.	110425	3/8NC x 1 1/4 bolt
5.	711009	Idler Bushing	20.	110672	3/8 Lock washer
6.	-----	-----	21.	110676	3/8 Flat washer
7.	740151	Idler	22.	740209	Belt/Micro-V K061130
8.	*	Pump	23.	120068	Hose splice
9.	711216	Footmount	24.	511084	Hose clamp
10.	740144	Clutch/Serpentine	25.	OEM	Hose clamp
11.	110395	3/8NC x 1 Skt Hd Bolt	26.	700218	Hose adapter
12.	110612	3/8NC nut	27.	700216	Hose/Radiator
13.	-----	-----	28.	700217	Hose/Radiator
14.	110184	10mm x 110mm x 1.50 bolt	29.	711024	Spacer/AC Comp. .25"
15.	-----	-----			

* See Master List For Pump Part No.

FIG. 1



(A) Denotes bolt holes in engine to locate corresponding holes in Pump Brkt.

FIG. 2

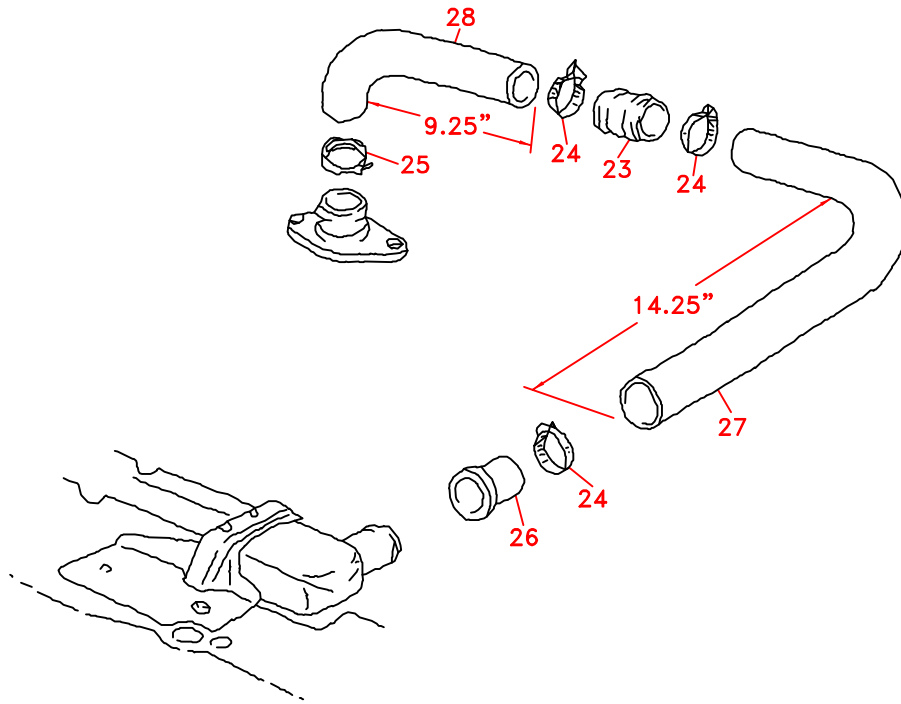
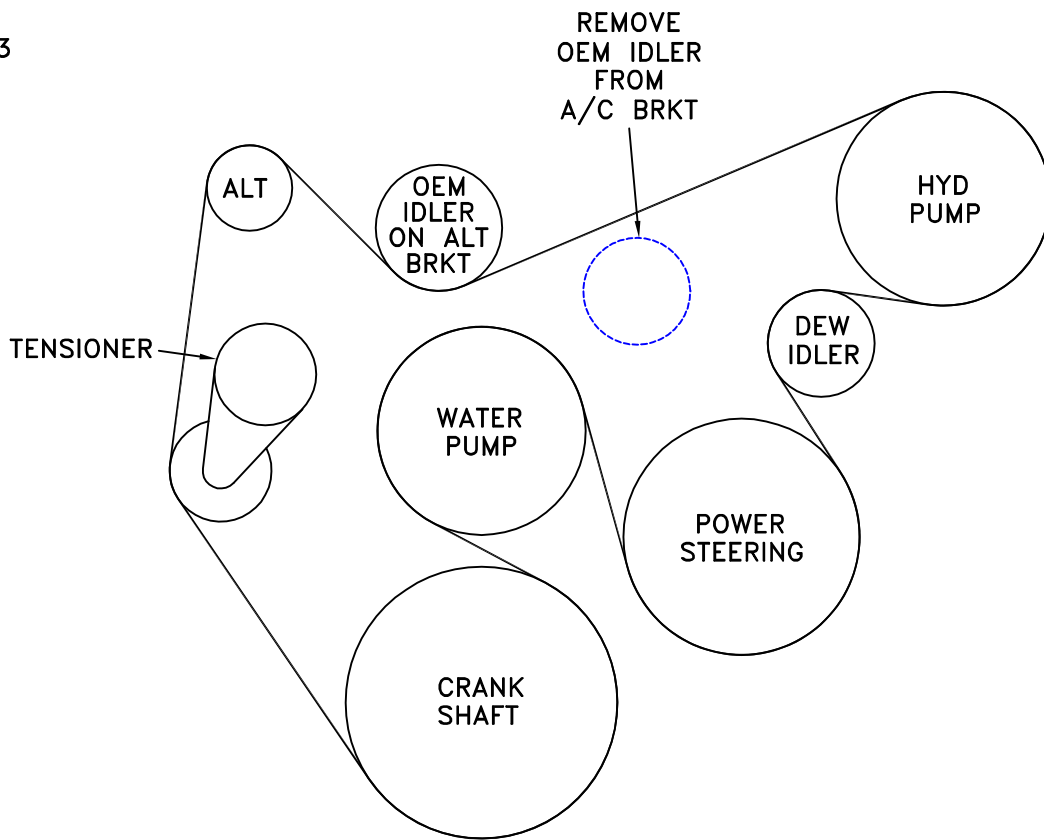


FIG. 3



Chevy 454 Without A/C
1996
Clutch Pump Kit #700091

INSTALLATION INSTRUCTIONS

NOTE: Suction hose to pump must be a wire braid hose; minimum 1" I.D. for 7 & 9 gpm pumps; 1 1/2" I.D. for 12 & 17 gpm pumps. Installations with smaller suction hoses will void the pump warranty.

1. Disconnect battery.
2. Remove fan and fan shroud.
3. Remove upper radiator hose.
4. Mount pump mounting plate (1) to angle bracket (2) at holes A using two 3/8 x 1 socket head bolts (11) and two 3/8 nuts (12).
5. Place angle bracket and pump plate assembly at holes C and place two .25" thick spacers (29) on holes G on air conditioner mounting bracket.
6. Place aluminum blocks (4) across angle bracket and spacers on top of air conditioning bracket. Thread two 10mm x 110mm bolts (14) in blocks in holes G in passenger side only. Do not tighten.
7. Place two tabs (3) on top of pump plate at hole B and H using a 3/8 x 1 socket head bolt (11) into pump plate and a 10mm x 110mm bolt (14) through other end of tab into block.
8. Mount idler (7) at hole E using bushing (5) on back side with 7/16 x 2 3/4 bolt (16) and 7/16 flat washer (18).
9. Place footmount (9) on plate (1) using four 3/8 x 1 1/4 bolts (19) with 3/8 lock washers (20) and 3/8 flat washers (21). Just make bolts snug. Do not tighten all the way.
10. Mount pump (8) on footmount using two 3/8 x 1 1/4 bolts (19) with 3/8 lock washers (20).
11. Mount clutch coil (10) using four small wiz bolts provided with clutch. Mount clutch pulley using bolt and heavy flat washer provided with clutch.
12. Install belt (22) as shown in Fig. 3.
13. Use a straight edge to align clutch pulley with other pulleys so belt runs straight. Tighten footmount bolts.
14. Refer to Fig. 2 for the following: Insert hose adapter (26) into long end of long hose (14.25", item 27). Secure with hose clamp (24).
15. Insert hose splice (23) into other end of hose (27). Place long end of short hose (9.25", item 28) over hose splice. Secure these with hose clamps (24).

16. Push short end of hose (28) onto water pump, securing with OEM hose clamp (25).
17. Reconnect the battery.
18. Run the engine and check for any clearance or alignment problems. Adjust as needed.
19. Replace fan and shroud.
20. Run the engine again, checking for any problems.

—