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|--------|------------------------------------|--|---------|-------------|
| 710077 | Bracket Assy. (Inc. item 1) | | Kit No. | 700309 |
| 711112 | Bracket Bolt Pkg. (Inc. items 2,3) | | Make | Chevy |
| None | Pulley Bolt Pkg. | | Engine | (7.4L) 454 |
| None | Idler Bolt Pkg. | | Fuel | Gas |
| None | Fan Spacer Bolt Pkg. | | Year | 1996-97 |
| | | | Options | Without A/C |
| | | | Revised | NC 5-27-97 |

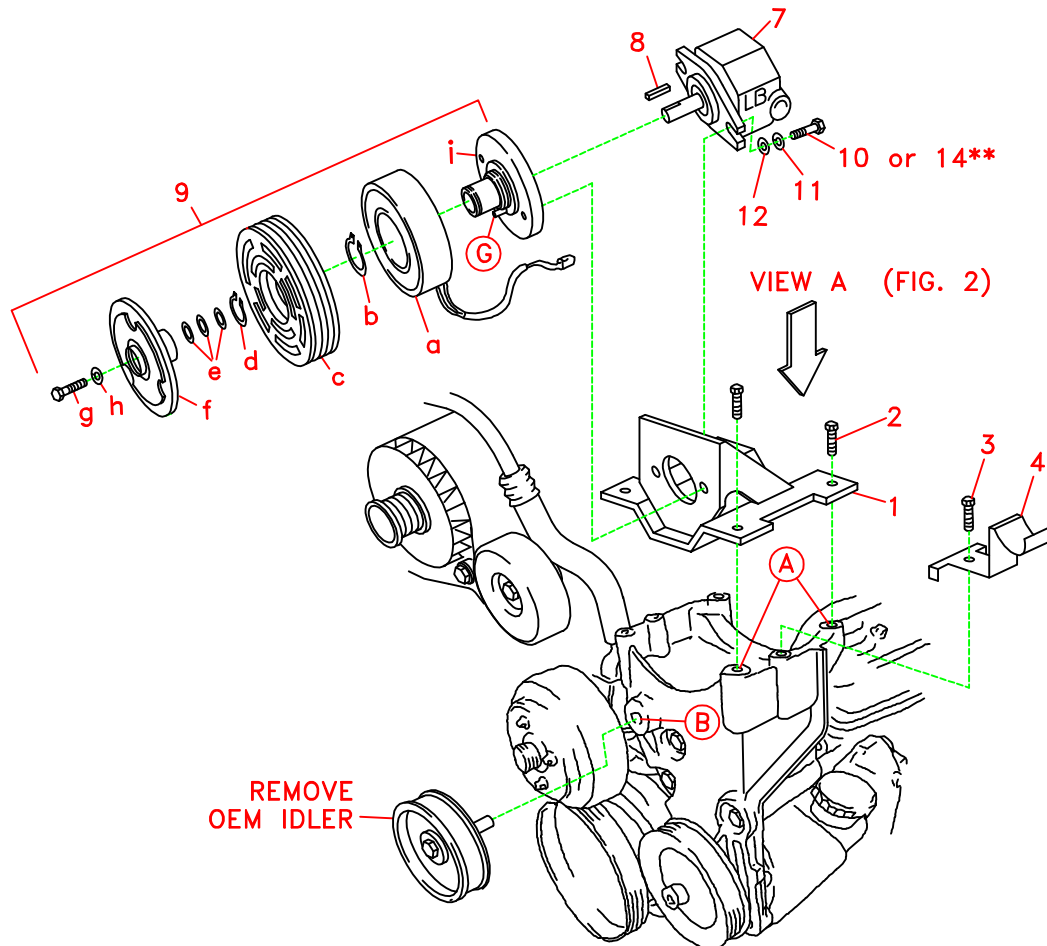
| ITEM | PART # | DESCRIPTION | | | |
|------|--------|---------------------|-------|--------|-------------------------|
| 1. | 710077 | Pump mount plate | 9d. | ----- | Snap ring/small |
| 2. | 110479 | 10mm x 30mm Bolt | 9e. | ----- | Shim |
| 3. | 110469 | M8 x 20 x 1.25 Bolt | 9f. | ----- | Hub/armature |
| 4. | OEM | Hose support | 9g. | ----- | Bolt |
| 5. | ----- | ----- | 9h. | ----- | Lock washer |
| 6. | ----- | ----- | 9i. | ----- | Hub/clutch |
| 7. | * | Pump | **10. | 110425 | 3/8NC x 1 1/4 Bolt |
| 8. | 710918 | Key | 11. | 110672 | 3/8 Lock washer |
| 9. | 740162 | Clutch, serpentine | 12. | 110676 | 3/8 Flat washer |
| 9a. | ----- | Coil | 13. | 740245 | Micro-V Belt/K060997 |
| 9b. | ----- | Snap ring/large | **14. | 110395 | 3/8NC x 1 Skt. hd. bolt |
| 9c. | ----- | Pulley | | | |

Items 9a - 9i are not available individually. They are listed only for reference in instructions.

* The only pumps available for this kit are 'AA' mount. See master list for pump part number.

** Bolt 10 is used with pump 720178 (Rexroth). Bolt 14 is used with pumps 720176, 720202 and 720206 (Commercial Intertech).

FIG. 1



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

FIG. 2

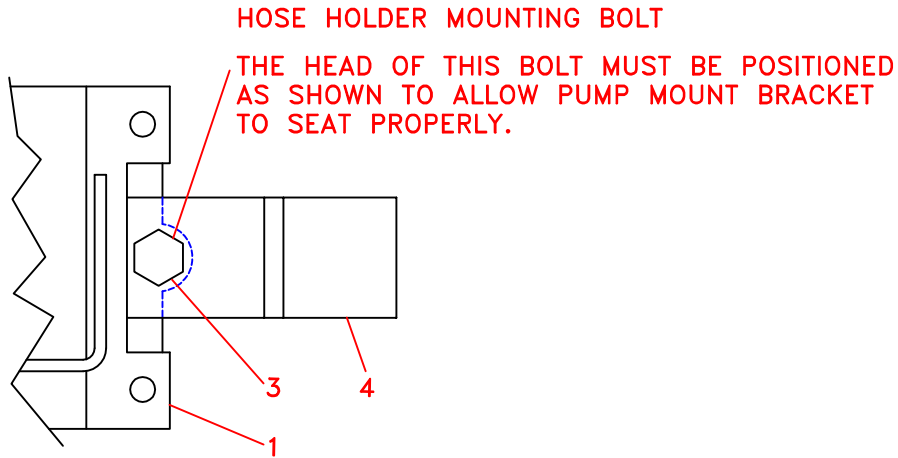
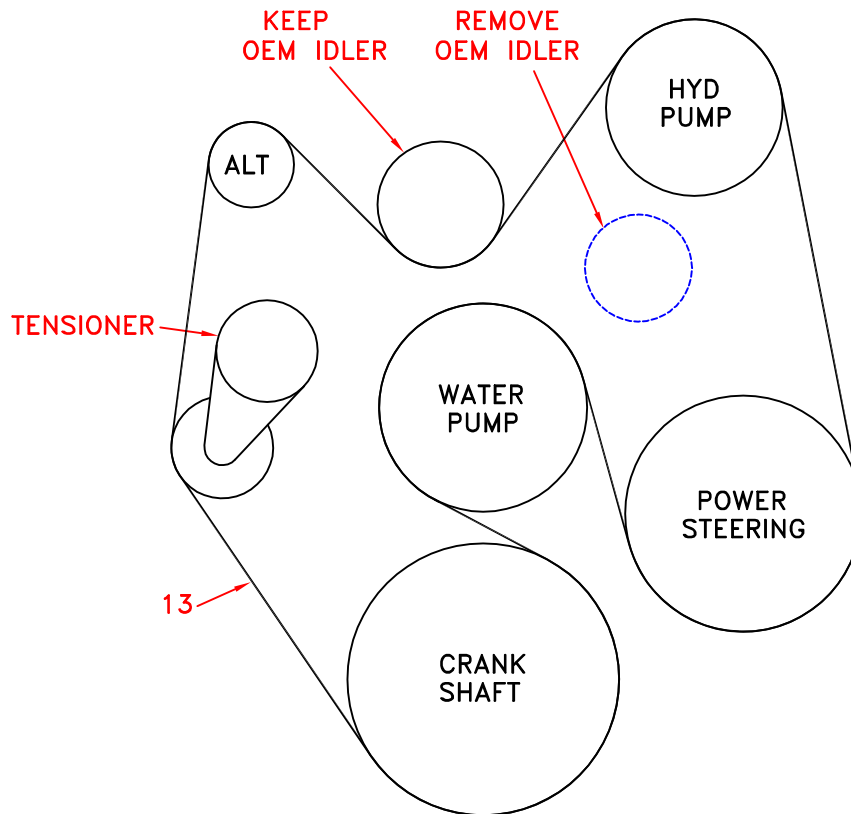


FIG. 3



DewEze

Clutch Pump Kit
#700309
Chevy 454
Without A/C
1996-97

INSTALLATION INSTRUCTIONS

NOTE: Suction hose to pump must be a wire braid hose; minimum 1" I.D. for 7 & 9 gpm pumps; 1 1/4" I.D. for 12 & 17 gpm pumps. Installations with smaller suction hoses will void the pump warranty.

1. Disconnect battery.
2. Remove OEM serpentine belt.
3. Remove OEM idler pulley at location B.
4. Remove OEM bolt mounting hose support bracket. Replace with M8 x 20 bolt (3). Position head of bolt as shown in Fig. 2 to allow clearance for pump mount bracket.
5. Hold pump (7) onto back of mounting plate (1) and clutch hub (9i) onto front of mounting plate, making sure anti-rotation pin (G) on front of hub is on the side that will be away from the engine. Place two 3/8 x 1 1/4 bolts (10), 3/8 lock washers (11), and 3/8 flat washers (12) through pump, through mounting plate and thread into hub.
6. Slide coil (9a) over hub, aligning hole in the back plate of coil with the anti-rotation pin (G) in the hub. The wires from the coil should be on the same side as the pin (G). Install large snap ring (9b) to hold coil in place.
NOTE: THE BEVEL ON BOTH SNAP RINGS MUST FACE AWAY FROM THE PUMP. REFER TO INSTRUCTION SHEET FOR THE CLUTCH FOR CORRECT INSTALLATION OF SNAP RINGS.
7. Slide clutch pulley (9c) onto hub. Install small snap ring (9d) to hold pulley in place.
8. Place the key (8) onto the pump shaft. Slide the hub/armature (9f) onto the pump shaft aligning the keyways.
NOTE: SET THE AIR GAP BETWEEN THE HUB/ARMATURE AND THE PULLEY USING SHIMS (9e) ACCORDING TO INSTRUCTION SHEET FOR CLUTCH.
9. Thread bolt (9g) and lock washer (9h) into pump shaft. Torque to value in clutch instruction sheet.
10. Bolt on pump mounting plate (1) using four 10mm x 30mm (2) in holes A at top of OEM air conditioner bracket.
11. Install belt (13) as shown in fig. 3.
12. Reconnect the battery.
13. Run the engine and check for any clearance or alignment problems. Adjust as needed.