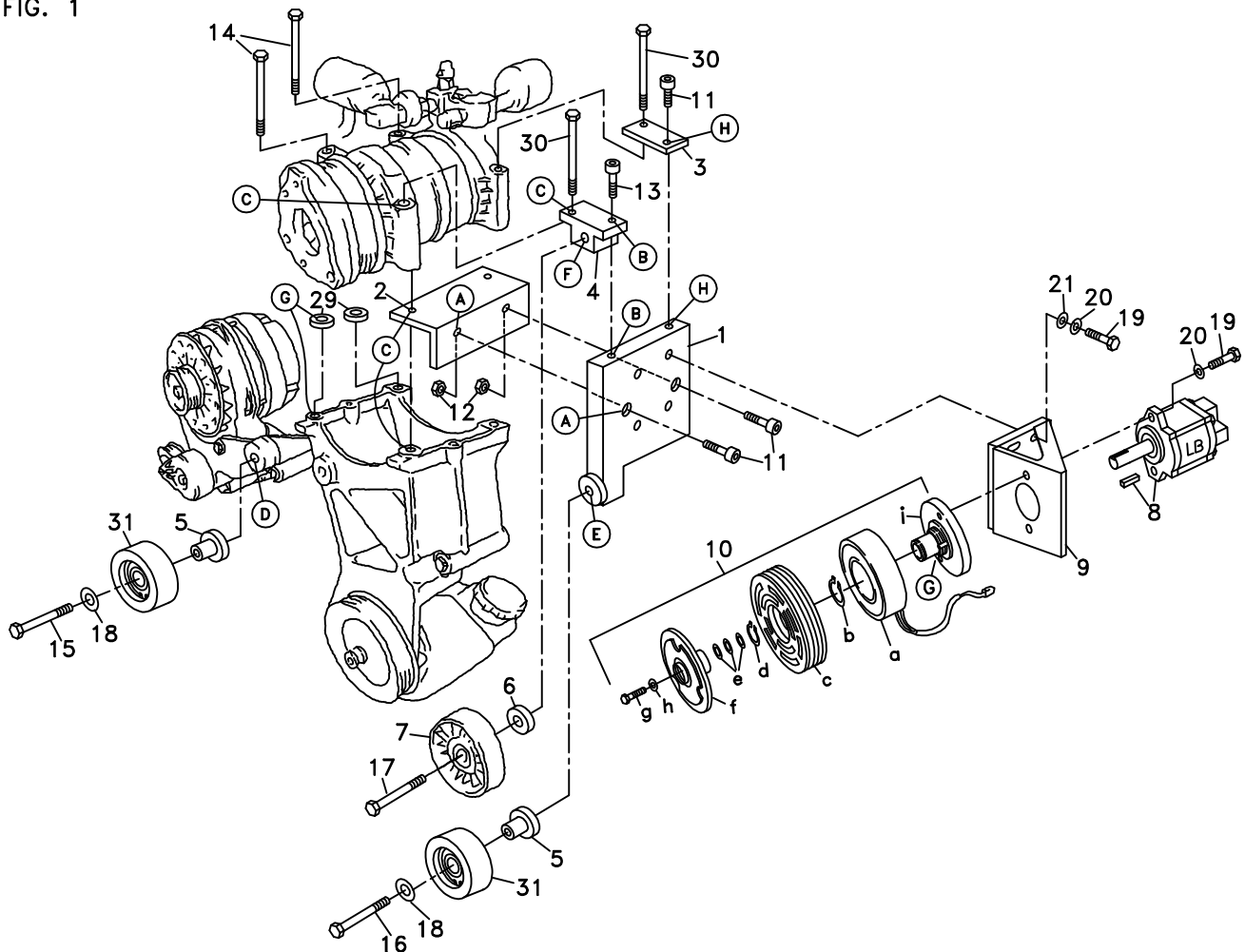


710081	Bracket Assy. (Inc. items 1-4)		Kit No.	700324
711020	Bracket Bolt Pkg. (Inc. items 11-13, 29, 30)		Make	Chevy
None	Pulley Bolt Pkg. (Inc. items)		Engine	454
711013	Idler Bolt Pkg. (Inc. items 5, 16, 18)		Fuel	Gas
711014	Idler Bolt Pkg. (Inc. items 5, 15, 18)		Year	1996-97
711021	Idler Bolt Pkg. (Inc. items 6, 17)		Options	With A/C
None	Fan Spacer Bolt Pkg. (Inc. item)		Revised	A 3-13-01

ITEM	PART #	DESCRIPTION	ITEM	PART #	DESCRIPTION
1.	711023	Plate/Pump Mount	17.	110477	5/8NC x 3 bolt
2.	711017	Angle/Bottom Plate Mount	18.	110670	7/16 Flat washer
3.	711016	Tab/Top Mount	19.	110425	3/8NC x 1 1/4 bolt
4.	711018	Idler Tab	20.	110672	3/8 Lock washer
5.	711009	Idler Bushing	21.	110676	3/8 Flat washer
6.	711019	Idler Spacer .55"	22.	740209	Belt/Micro-V K061130
7.	740151	Idler Pulley	23.	120088	Hose splice
8.	*	Pump	24.	511084	Hose clamp
9.	711126	Footmount	25.	OEM	Hose clamp
10.	740162	Clutch/Serpentine	26.	700218	Hose adapter
11.	110395	3/8NC x 1 Skt Hd Bolt	27.	700216	Hose/Radiator
12.	110612	3/8NC nut	28.	700217	Hose/Radiator
13.	110178	3/8NC x 1 1/2 Skt Hd Bolt	29.	711024	Spacer/AC Comp. .25"
14.	OEM	Bolt	30.	110184	10mm x 110mm x 1.50 Bolt
15.	110180	10mm x 60mm x 1.50 bolt	31.	740242	Idler Pulley
16.	110179	7/16NC x 2 3/4 bolt			

* See Master List For Pump Part No.

FIG. 1



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

FIG. 2

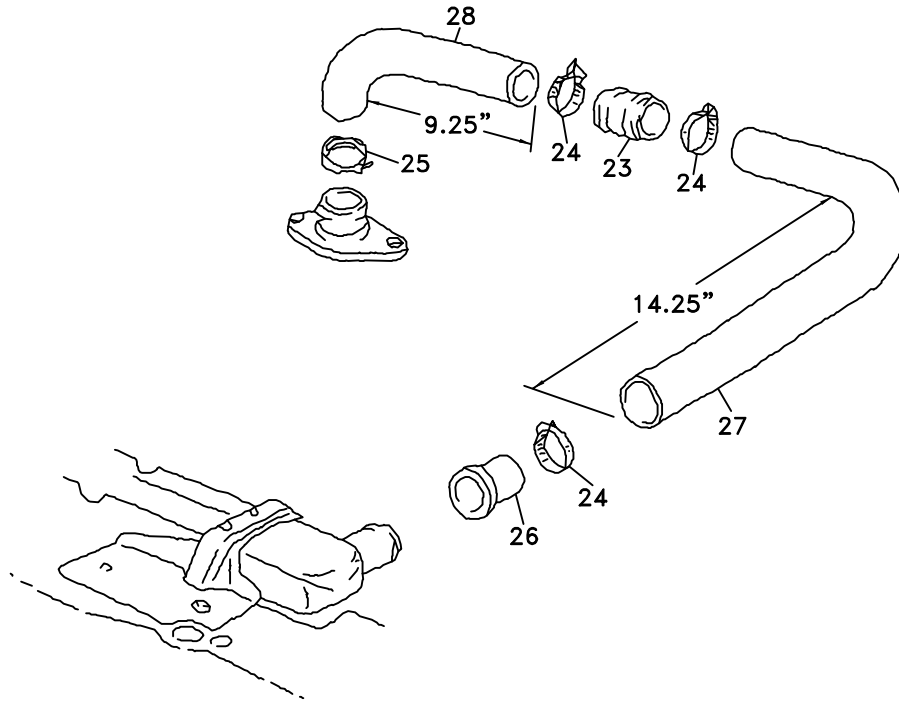
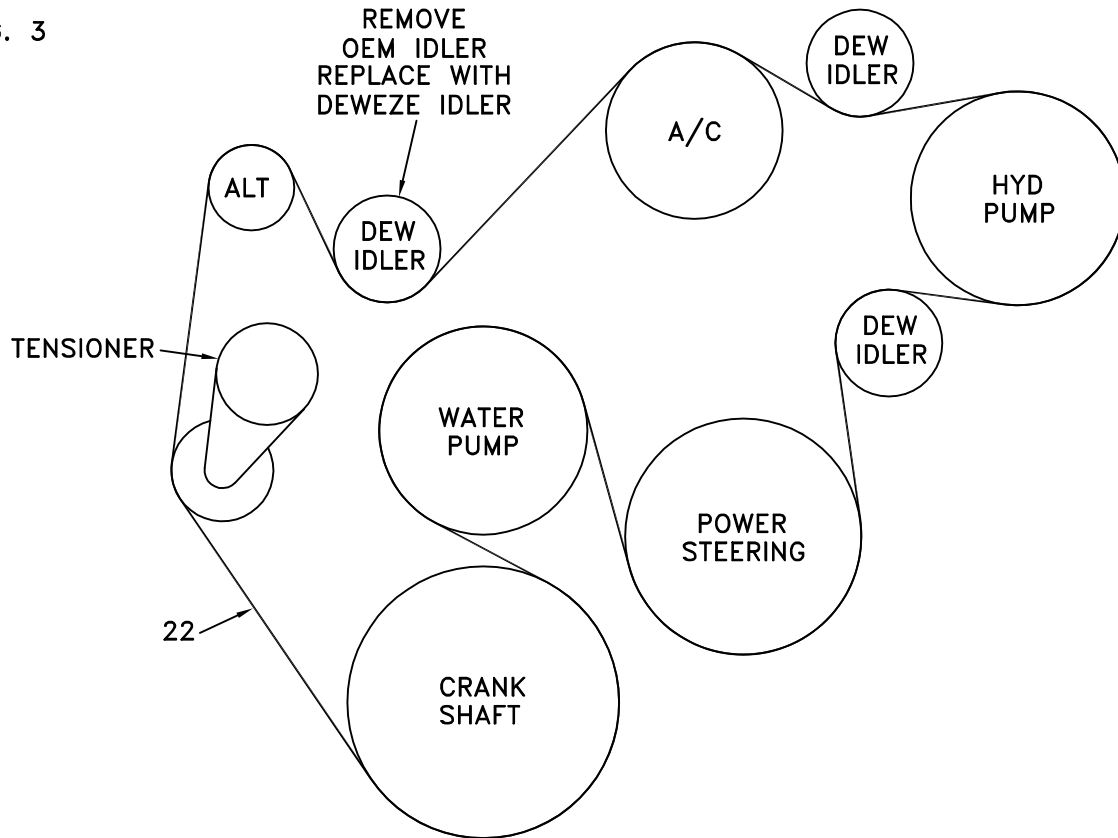


FIG. 3



DewEze

Clutch Pump Kit
#700324
Chevy 454
With 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. 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. Remove 4 bolts holding air conditioner compressor. These will not be used again.
5. 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).
6. Lift up compressor and 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. Set compressor back down.
7. Place two 10mm x 100mm bolts (14) in compressor in holes G in passenger side only. Do not tighten.
8. Place tab (3) on top rear of pump plate at hole H using 3/8 x 1 socket head bolt (11) and a 10mm x 110mm bolt (30) through other end of tab into compressor.
9. Place idler mount tab (4) on top front of pump plate at hole B using 3/8 x 1 1/2 socket head bolt (13) and a 10mm x 110mm bolt (30) through other end of tab into compressor at hole C. 5/8 tapped hole is offset closer to one end of tab. Mount tab so hole is offset toward pump plate.
10. Mount one cast idler pulley (31) with snap ring facing forward, away from engine, at hole D using bushing (5) on back side with 10mm x 60mm bolt (15) and 7/16 flat washer (18).
11. Mount the other cast idler pulley (31) with snap ring facing forward, away from engine, at hole E using bushing (5) on back side with 7/16 x 2 3/4 bolt (16) and 7/16 flat washer (18).
12. Mount plastic idler (7) at hole F using .55" thick spacer (6) on back side with 5/8 x 3 bolt (17).
13. Place footmount (9) on plate (1) using four 3/8 x 1 1/4 bolts (19) with 3/8 lock washers (20). Just make bolts snug. Do not tighten all the way.
14. Hold pump (8) onto back of footmount (9) and clutch hub (10i) 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 (14), 3/8 lock washers (15), and 3/8 flat washers (23) through pump, through mounting plate and thread into hub.
15. Slide coil (10a) 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 (10b) 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.**

16. Slide clutch pulley (10c) onto hub. Install small snap ring (10d) to hold pulley in place.
17. Place the key (8) onto the pump shaft. Slide the hub/armature (10f) onto the pump shaft aligning the keyways. **NOTE: SET THE AIR GAP BETWEEN THE HUB/ARMATURE AND THE PULLEY USING SHIMS (10e) ACCORDING TO INSTRUCTION SHEET FOR CLUTCH.**
18. Thread bolt (10g) and lock washer (10h) into pump shaft. Torque to value in clutch instruction sheet.
19. Install belt (22) as shown in Fig. 3.
20. Use a straight edge to align clutch pulley with other pulleys so belt runs straight. Tighten footmount bolts.
21. 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).
22. 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).
23. Push short end of hose (28) onto water pump, securing with OEM hose clamp (25).
24. Reconnect the battery.
25. Run the engine and check for any clearance or alignment problems. Adjust as needed.
26. Replace fan and shroud.
27. Run the engine again, checking for any problems.

NOTE: The small cast idler pulleys (31) replace two plastic idler pulleys (same as 7). This was done so the belt is not so tight and is easier to install.