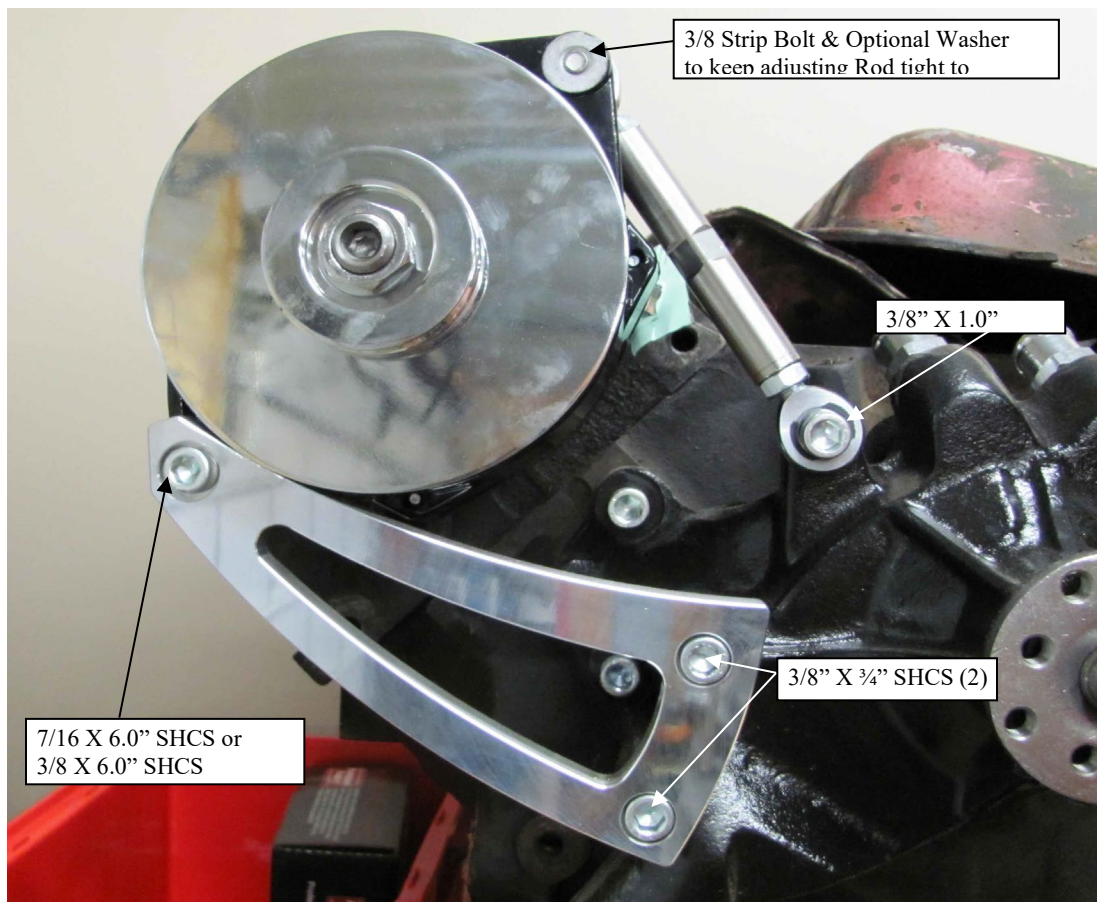


454-ALTBRKT Instructions Rev B

Chevy Big Block Alternator Bracket			
Item	Description	Qty	Comments
1	3/8-16 X 0.75" SHCS	2	Main Bracket to Water Pump
2	3/8-16 X 1.00" SHCS	1	Adjusting Rod to Water Pump
3	3/8-16 X 6.00" SHCS	1	Main Bolt to Cylinder Head (Early Heads)
4	7/16-14 X 6.00" SHCS	1	Main Bolt to Cylinder Head (Late Model Heads)
5	3/8 X 0.50 SHOULDER BOLT	1	Adjusting Rod to Alternator
6	3/8" X 0.05" Special Washer	3	Washer for use with 3/8" Bolt on Early Heads
7	3/8" USS Washer	1	Washer for removing slack on Strip Bolt
8	6257722-325 Spacer	1	Spacer between Alternator and Cylinder Head
9	235763-250-ASM	1	Stainless Steel Adjusting Rod
10	P/N 454522 – Main Bracket	1	Bracket that Bolts to Front of Water Pump
11	3/8 SAE Washer	3	Spacer between water pump and bracket
	Total Parts	16	8x6x2 Box
Note: SHCS = Socket Head Cap Screw, HHS = Hex Head Screw			



Step 1: Remove old alternator bracket.

Step 2: Attach Bracket to Water Pump using 3/8 X 3/4" SHCS.

IMPORTANT: Do not tighten any bolts until the end.

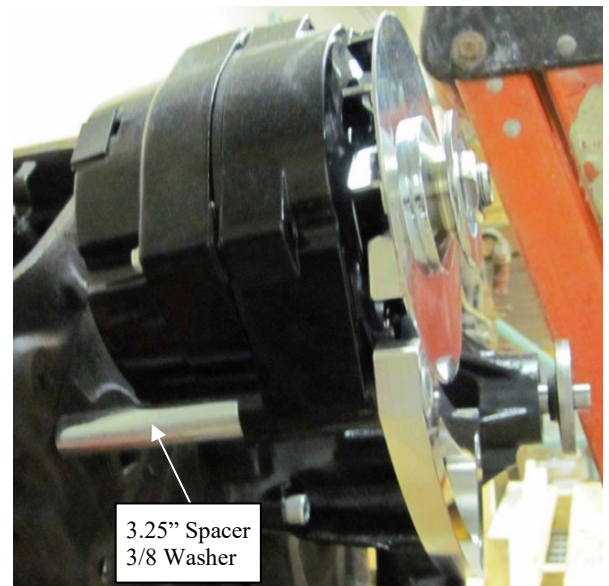
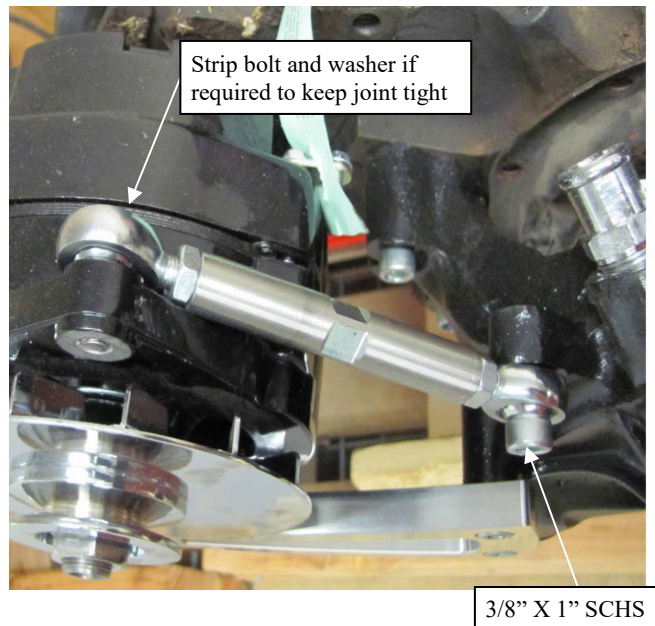
FOR AC KITS ONLY: add (3) 3/8 Washers to space bracket ~1/16" from water pump.

Step 3: Attach Alternator to Cylinder Head and Bracket using either 7/16" X 6.0" SHCS or 3/8" X 6.0" SHCS and washer: If using 7/16" Bolt you may need to drill out the spacer and alternator ear from 3/8" to 7/16". Place 3.25" spacer between alternator and cylinder head.

Step 4: Attach adjusting rod to water pump using 3/8" X 1.0" SHCS.

Step 5: Attach adjusting rod to alternator using 3/8" Strip bolt. You may need to use optional 3/8" washer to make sure that this joint is not loose after tightening the strip bolt.

Step 6: Tighten all bolts except the ones that will need to move during belt tensioning. Install belt, set proper belt tension and tighten all remaining bolts.



GENERAL FASTENER TORQUE SPECIFICATIONS

Use only when an application-specific torque value is not provided. Verify the grade or property class marked on the bolt head.
Lower torque may be required when fastening into aluminum or other soft materials.
Values assume clean, undamaged threads. Threadlocker is not a dry condition.

SAE COARSE THREAD				
FASTENER	GRADE	LUBRICATED K=15	LIGHTLY LUBRICATED K=17	DRY K=20
1/4"-20	5	76 in-lb	86 in-lb	101 in-lb
5/16"-18	5	157 in-lb	178 in-lb	209 in-lb
3/8"-16	5	23 ft-lb	26 ft-lb	31 ft-lb
7/16"-14	5	37 ft-lb	42 ft-lb	49 ft-lb
1/4"-20	8	107 in-lb	122 in-lb	143 in-lb
5/16"-18	8	221 in-lb	251 in-lb	295 in-lb
3/8"-16	8	33 ft-lb	37 ft-lb	44 ft-lb
7/16"-14	8	52 ft-lb	59 ft-lb	70 ft-lb

SAE FINE THREAD				
FASTENER	GRADE	K=15	K=17	K=20
5/16"-24	8	245 in-lb	278 in-lb	327 in-lb
3/8"-24	8	37 ft-lb	42 ft-lb	49 ft-lb

METRIC COARSE THREAD				
FASTENER	CLASS	K=15	K=17	K=20
M8 x 1.25	8.8 12.9	169 in-lb 283 in-lb	192 in-lb 320 in-lb	225 in-lb 377 in-lb
M10 x 1.5	8.8 12.9	28 ft-lb 47 ft-lb	32 ft-lb 53 ft-lb	37 ft-lb 62 ft-lb
M16 x 2.0	8.8	121 ft-lb	137 ft-lb	161 ft-lb

FASTENER TYPE: SAE values shown are for standard hex-head carbon/alloy steel bolts.
Socket, button, flat-head and stainless-steel fasteners require separate, generally lower values.
Verify the appropriate specification at Fastenal.com.