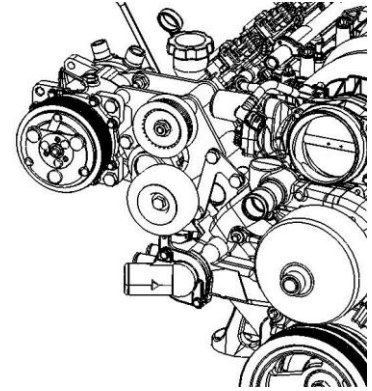




K10163 Air Conditioner Bracket Kit for LS based Vortec truck engines and 2010 and up Camaro engines

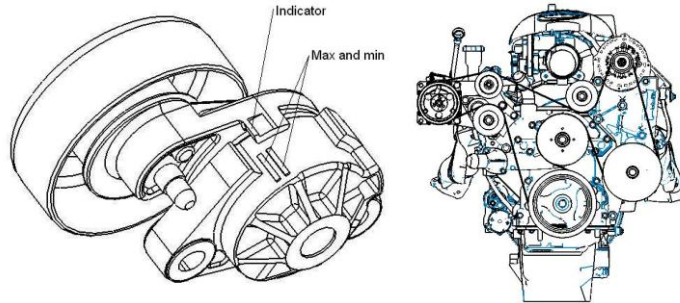
Kit contents:

- Front and rear compressor attachment plates.
- Water pump brace plate.
- Spacer tubes and idler pulley mount
- Idler pulley, Gates 38012 or equivalent.
- All fasteners needed to attach the bracket to the engine and the compressor to the bracket.



In addition, the following parts are required:

- The truck tensioner must be replaced with an LS1 main belt tensioner, GM part number 12560344 or equivalent. Request the tensioner for a 2002 Camaro Z28.
- Air conditioner compressor, Sanden “508” style, current model number is SD5H14. The most popular configuration used by most all aftermarket AC makers is the “6629” which indicates it has a 7-groove serpentine pulley and 3/4” and 7/8” O-ring ports pointing upward. We offer this compressor on the Accessories page of our web site: <http://kwikperf.com/accessories.html>.
- If using a Kwik Performance alternator bracket, use the belt suggested in the alternator bracket instructions. If using the factory truck alternator bracket, use a six-rib belt, length approximately 114 inches, so that the tensioner indicator arrow is between the max and min marks. Gates number K061140 (114 1/2”) is suggested for truck engines. If using a 2010+ Camaro factory bracket, Gates number K061037 (104 1/4”) is suggested.



Pre-installation

Before installing the brackets, the tensioner must be modified. Remove the six-groove pulley, which will be used as the idler pulley. The smooth idler pulley listed above will be used on the tensioner, but it can be installed after the tensioner is bolted in place to make the 140mm bolt easier to install.

Notes

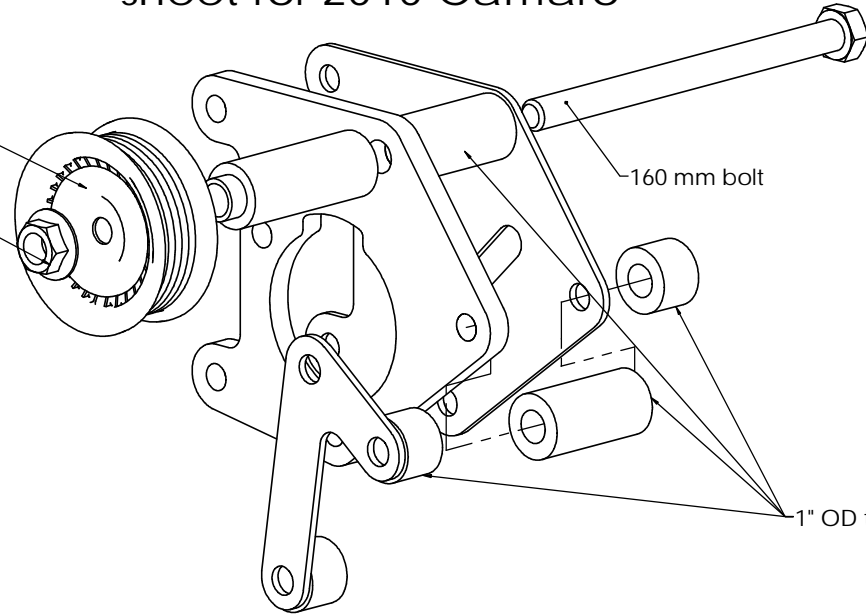
- Install the 160mm idler bolt from the rear, because the flange nut must be placed against the idler pulley. This must be done before bolting any brackets in place, or the bolt will not clear the valve cover.
- Shim plate under tensioner lower boss counteracts play in the tensioner pivot.
- **Some water pumps require a 3/8” washer to be installed between the L-plate and main plate.**
- **Leave all bolts loose until all parts are installed. Lift up on the front of the compressor when tightening the bolts. Tighten first the 2 bolts that screw into the head to square up the plates, then tighten the 2 bolts that screw into the water pump. After that, the bolts may be tightened in any order.**
- Torque all 10mm bolts to 37 ft-lbs (50 N-m), and torque the 12mm bolt to 50 ft-lbs (68 N-m).
- The belt is installed on the forward 6 grooves of the 7-groove compressor pulley.
- **Install the 16mm washer on the tensioner under the smooth 38012 pulley for alignment.**
- See additional sheet for 2010 and up Camaro installation.

1. Assemble idler pulley.

K10163 A/C Bracket for LSx Truck Installation Instructions-see additional sheet for 2010 Camaro

Remove bearing cover if desired for max thread engagement.

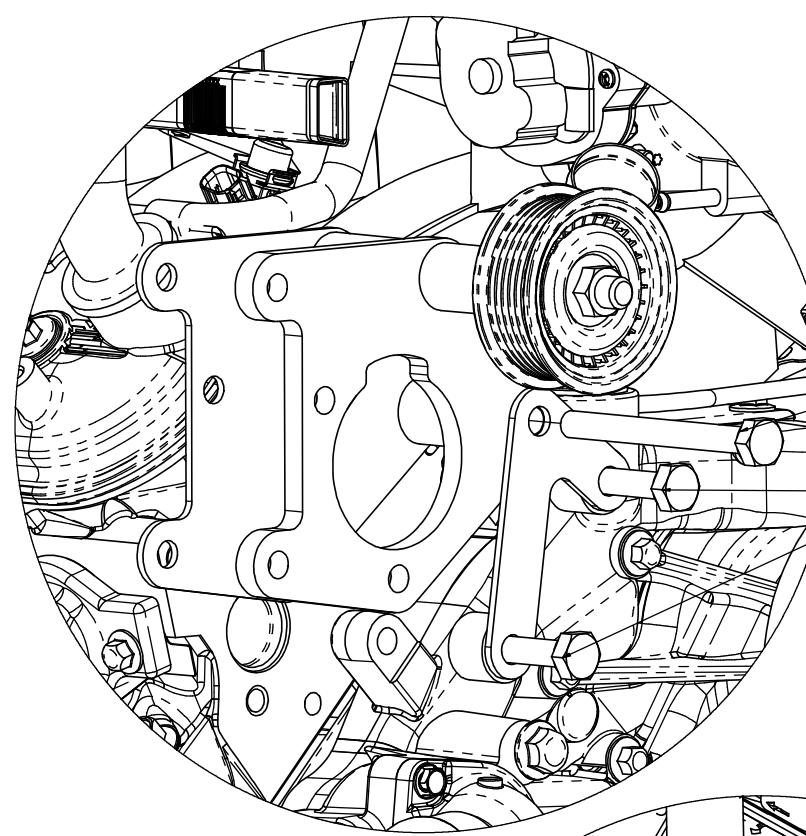
Flange nut



160 mm bolt

1" OD tubes

2. Mount brackets.



100mm bolt
Screws into head

35mm bolts with short tubes
Screw into water pump

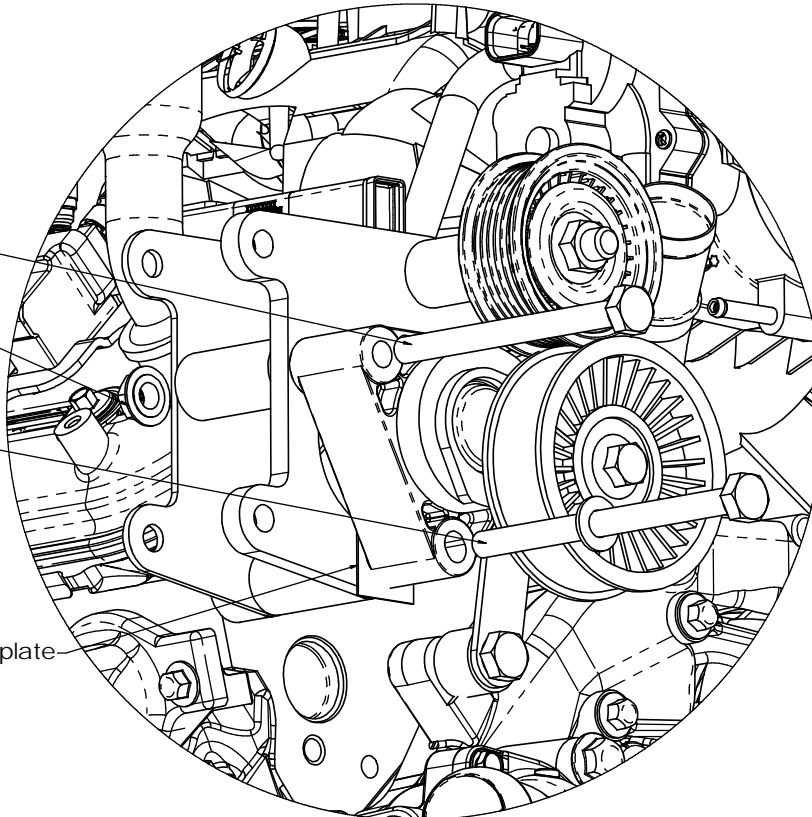
3. Install tensioner

120mm bolt

Flange nut

140mm bolt with washer
Screws into head

Install shim between tensioner and main plate



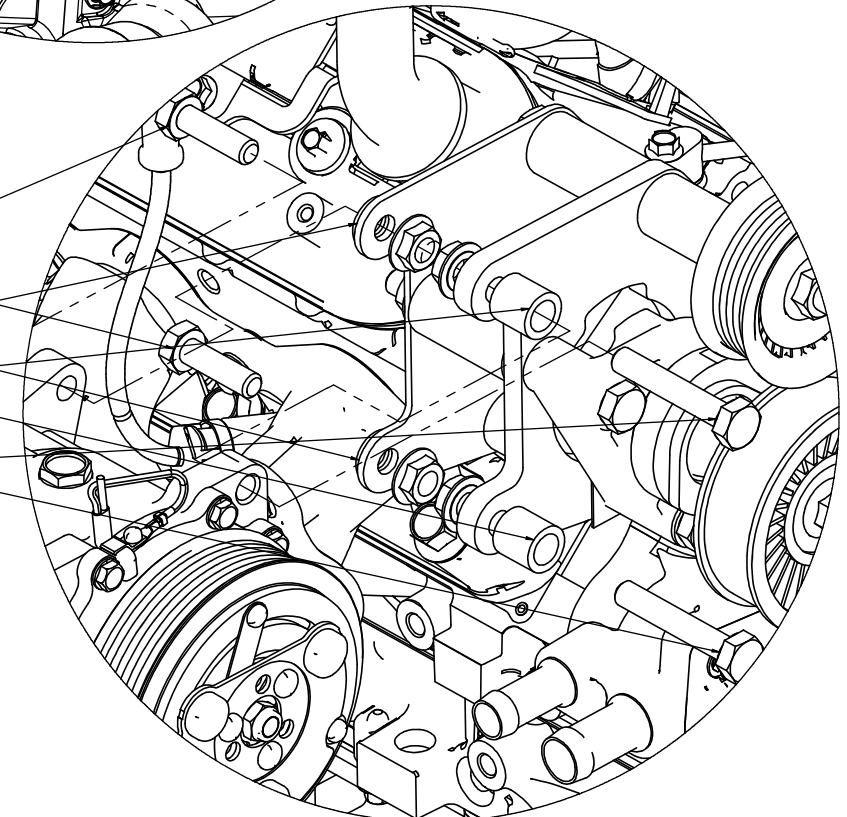
4. Install compressor

35mm bolts and flange nuts

Washers (omit if not needed)

3/4" OD tubes

60mm bolts and flange nuts



5. See page 1 for bolt tightening sequence.

Tighten 10mm fasteners to 37 ft-lbs (50 N-m), tighten 12mm fasteners to 50 ft-lbs (68 N-m)

Adjustment Instructions

2010 Camaro instructions

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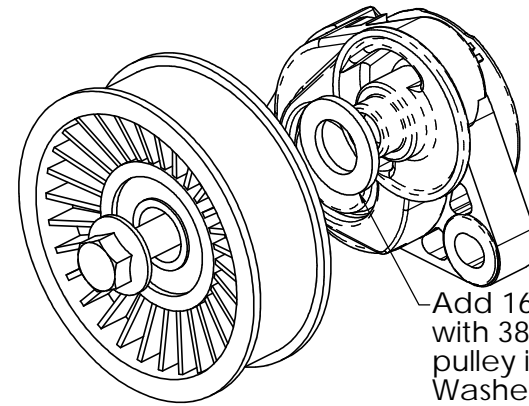
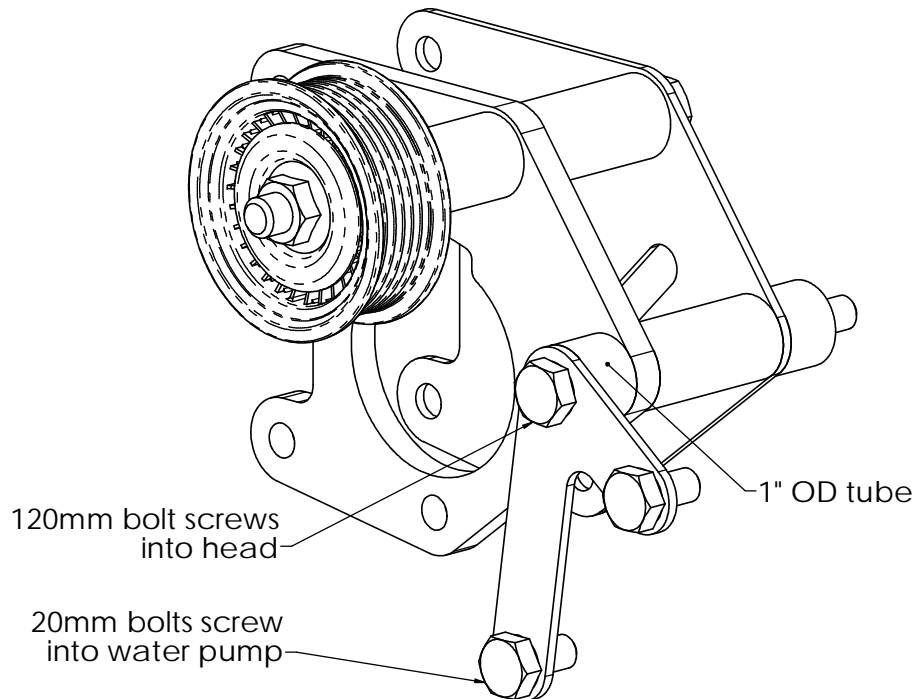
A/C Compressor bracket for LSx engines

1. Leave all fasteners slightly loose until all parts are in place. Then lift up on the compressor pulley while tightening down the two bolts that screw into the cylinder head. This squares up the bracket to the head. Then tighten the water pump bolts, then the rest of the bolts.

2. Due to variations in tensioners, a washer may be needed for proper alignment of tensioner pulley 38001 or 38006. The back of the serpentine belt should run less than 1/8" from the back of the 38001 or 38006 pulley.

Washer is always used with 38012 pulley to prevent interference between the pulley and the tensioner arm.

3. Special instructions for 2010 and later Camaro engines:



Add 16mm washer with 38001 or 38006 pulley if needed. Washer must always be used with 38012 pulley.