



Big Block Chevy Serpentine Belt Conversion Kit

Adapts small block V8 and V6 serpentine belt drive to big-block Chevy

Kit contents:

- Seven high quality 6061-T6 heat-treated aluminum adapter plates
- All nuts and bolts to attach the adapter plates to a big block Chevy engine.
- **Note: Both 3/8 and 7/16 bolts are included for the passenger side head, since the holes vary for different years.**
- **Note: It may be necessary to drill out some of the holes on the SBC cast brackets to accept 7/16” bolts.**

Additional parts needed to complete the engine (not included in this kit):

- Driver side and passenger side aluminum drive brackets off of 1990-1995 Chevy 350 V8 or 4.3L V6 truck, with casting numbers 10118701 (driver side) and 10118751 (passenger side). These are the brackets shown below. Notice that the passenger side bracket does not have an arm for mounting an air pump. Earlier passenger side brackets with the air pump mount (casting number 10129515) can be used as long as the idler and tensioner are positioned as shown below. Also notice the zigzag pattern ribs at the top of the driver’s side bracket under the alternator. These brackets were used for other years and models, too. A salvage yard or GM dealer may be able to help find them. See pictures. The passenger side bracket should include the idler and tensioner.
- Air conditioner compressor and pulley, alternator and pulley, and power steering pump and pulley off the donor engine. Note: A good reason to use 1994 or 1995 truck parts is that the compressor will be for R134a refrigerant.
- A water pump pulley off the donor engine. Do not use a pulley with a groove. The belt surface must be smooth. GM part number is 10085760.
- A reverse rotation water pump off of a 1988-1999 454 engine. This is considered a “long” pump, and is 7 5/16” from block to fan mounting surface. At your parts store, ask for a pump for a “1994 C2500 with a 7.4L engine”. Part numbers are GM 12527717 and others, Gates 44030, and Dayco DP1011.
- A big-block crankshaft pulley, GM part number 10085753, or a small-block crank pulley, GM part number 10085754, and a Kwik adapter, part number 10259-01.
- Gates belt number K060966 or equivalent 6-rib 97 1/8” belt. This assumes the use of the 1994 truck brackets listed above and the belt routed inside the idler as shown below. The idler pulley can be omitted if desired. If the idler is not used, a 96” belt should be used. **Note:** A tall deck engine will need a belt that is about 1” longer. K060980 is suggested for tall deck engines.
- A new thermostat housing may be needed to allow the upper radiator hose to clear the alternator. A housing off a 1955 to 1965 Chevy V8 will aim the hose straight toward the front of the vehicle, or one that swivels may be needed. Upper radiator hose will probably need to change, but your vehicle's stock lower hose *may* work.
- Note: Retain the hardware and fasteners from the donor engine that goes with the accessories.

Notes on mounting the plates

Plates attach to the three accessory holes on each head and to the two pairs of holes on either side of the timing chain cover on the block. Long bolts go through the brackets and plates and thread into the outermost holes on both cylinder heads. See diagrams and pictures on the following pages. Install all fasteners loosely until all are in place, then tighten 3/8” bolts to 25 ft-lbs and tighten 7/16” bolts to 40 ft-lbs. **Note:** Orientation of the lower engine block plates can be confusing. Note that the bolts that attach the plates to the block are 7/16”, and are spaced 2 1/4” apart on the driver side and spaced 2 3/32” apart on the passenger side. “Dog bone” shaped part goes on passenger side. See diagram.



Install all plates, leaving all bolts loose

After this step, the engine will look like this:



Install both GM brackets and tighten all fasteners

Tighten 3/8" bolts to 25 ft-lbs, tighten 7/16" bolts to 40 ft-lbs.

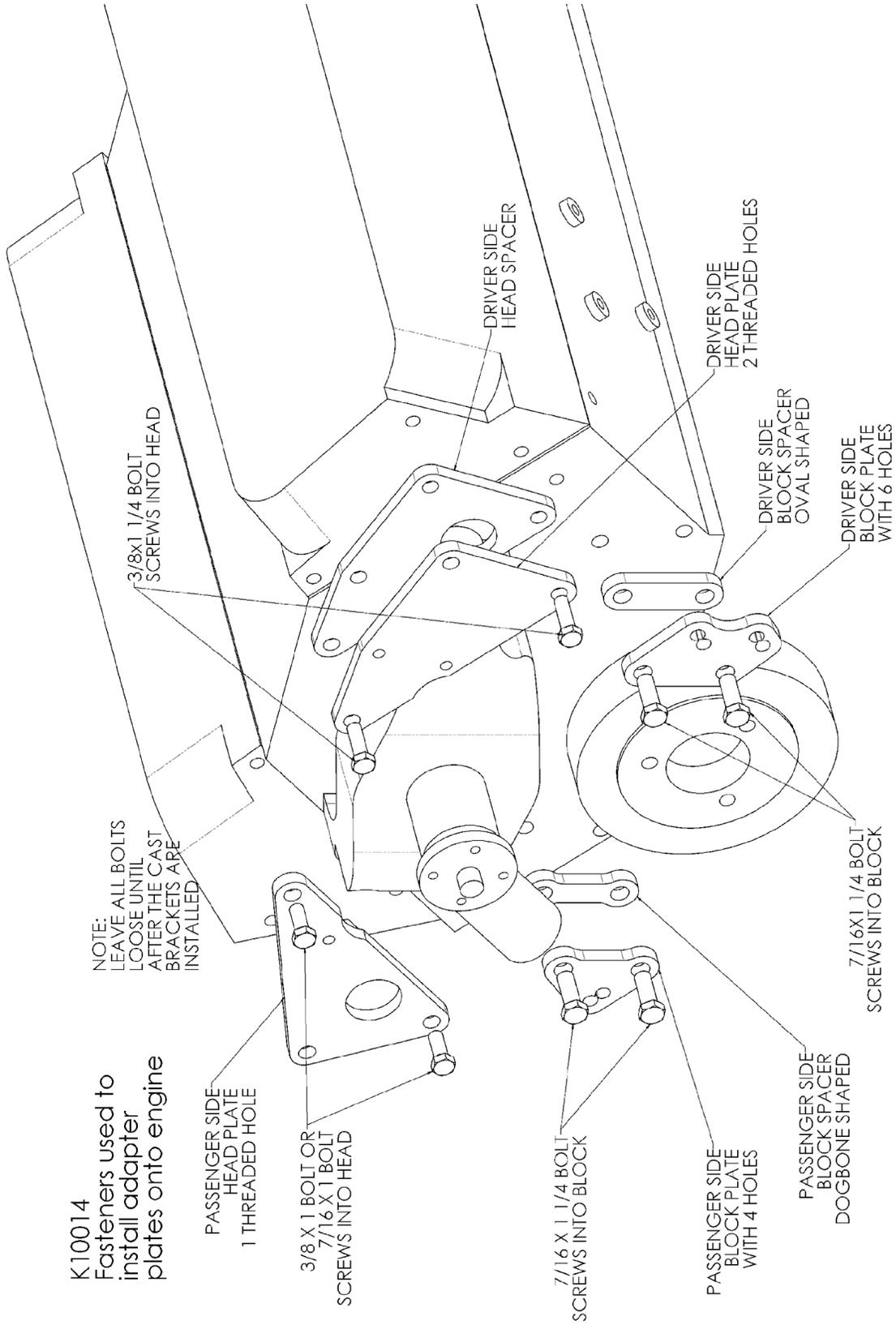
Note: The driver's side head plate lower bolt is difficult to get to with the power steering pump installed.



Bracket casting numbers 10118751 and 10118701



Casting 10129515



K10014
Fasteners used for
installing cast GM
brackets onto engine
(Brackets not shown)

NOTE:
AFTER BRACKETS AND ALL BOLTS
ARE INSTALLED, TIGHTEN 3/8"
BOLTS TO 25 FT-LBS AND TIGHTEN
7/16" BOLTS TO 40 FT-LBS.

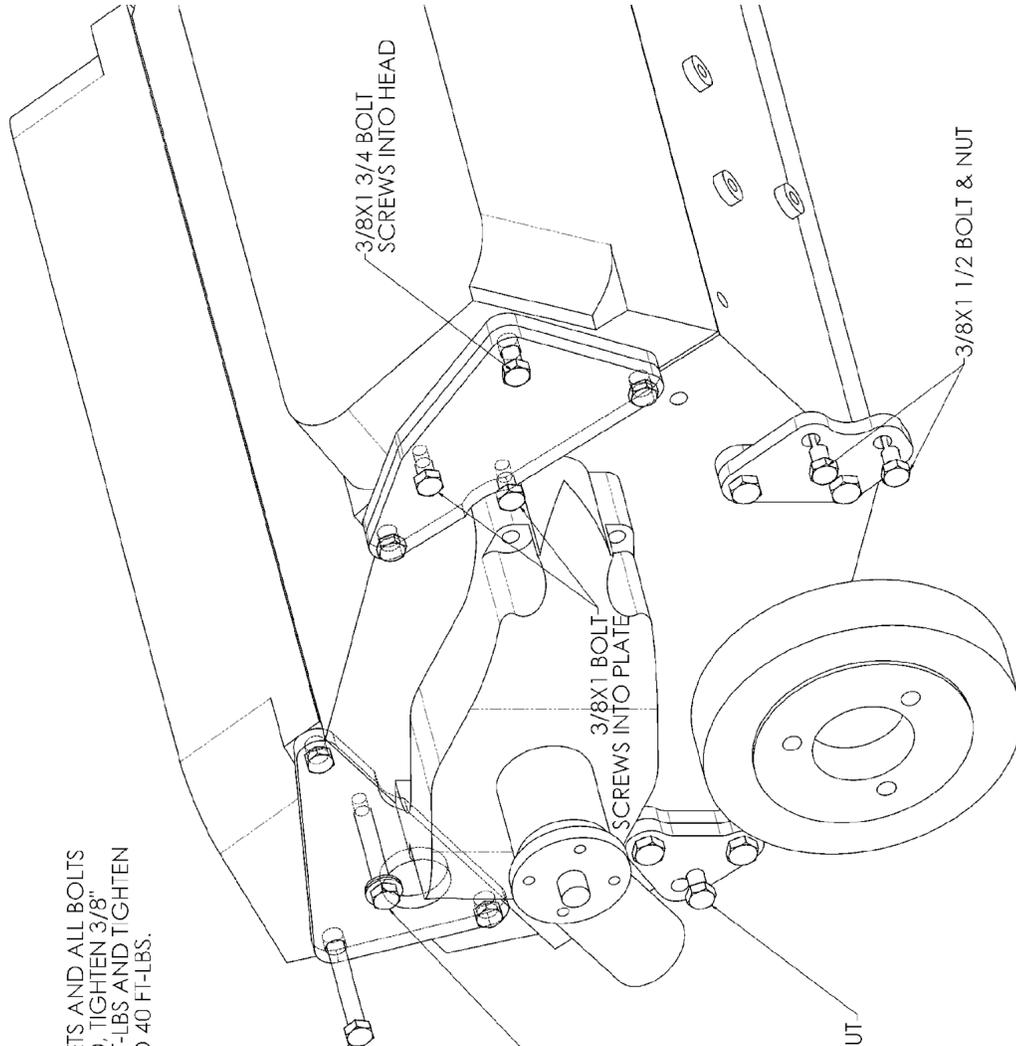
**USING CAST BRACKET 10118751
(NO AIR PUMP):**
3/8 X 3 1/2 BOLT OR 7/16 X 3 1/2 BOLT.
SCREWS INTO HEAD.

**USING CAST BRACKET 10129515
(WITH AIR PUMP):**
3/8 X 1-3/4 OR 7/16 X 1-3/4 BOLT.
SCREWS INTO HEAD.

**USING CAST BRACKET 10118751
(NO AIR PUMP):**
3/8 X 3 BOLT PLUS 2 WASHERS UNDER BOLT HEAD.
SCREWS INTO HEAD.

**USING CAST BRACKET 10129515
(WITH AIR PUMP):**
3/8 X 1-3/4 BOLT WITH NO WASHERS.
SCREWS INTO HEAD.

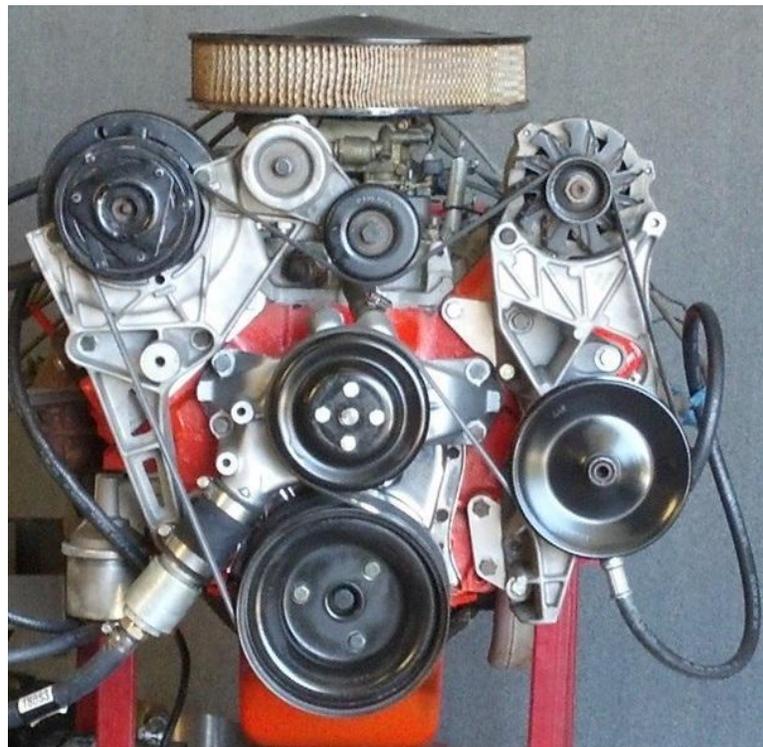
3/8 X 1 1/2 BOLT & NUT



Installation completed with serpentine belt attached



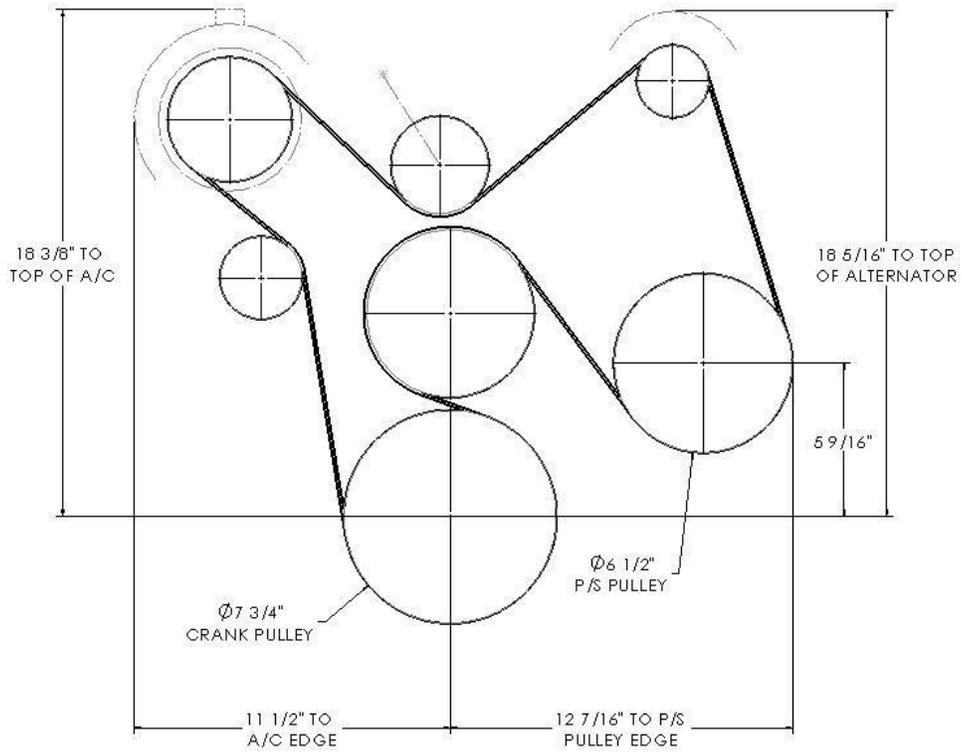
With idler pulley – Gates K060966 belt, 97 1/8" (standard deck)



No idler pulley – Gates K060955 belt, 96 1/8" (standard deck)



Standard deck engine dimensions (tall deck 1/4" higher):



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