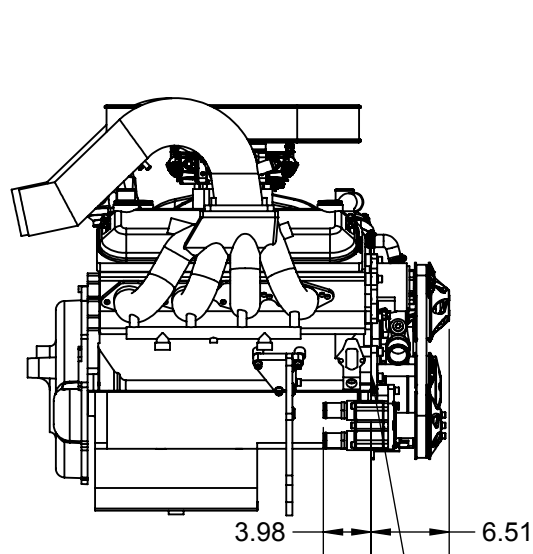
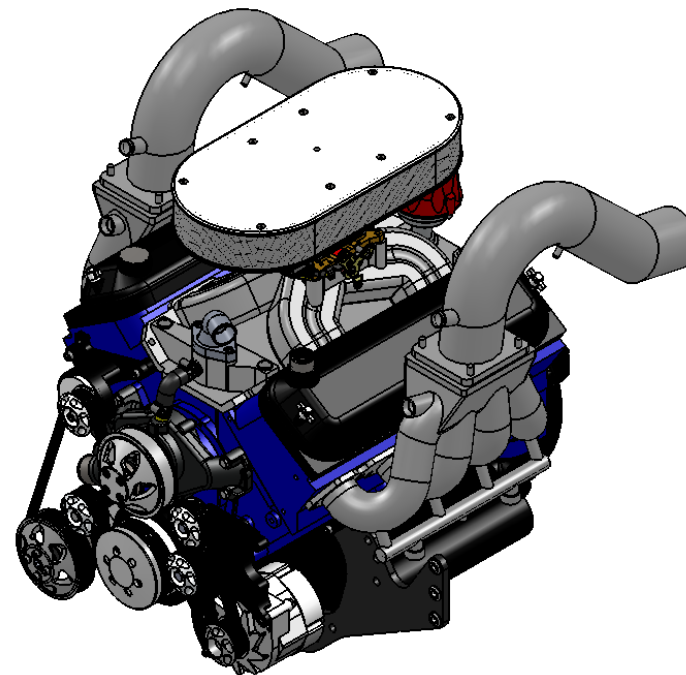


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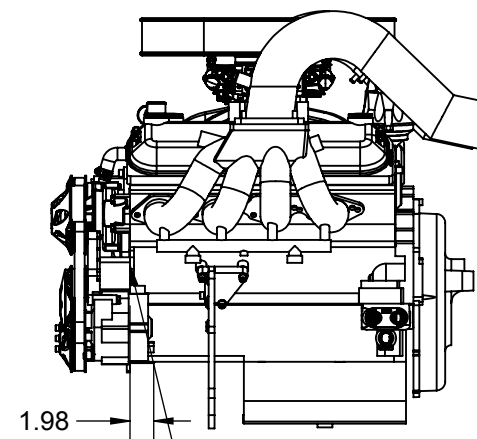
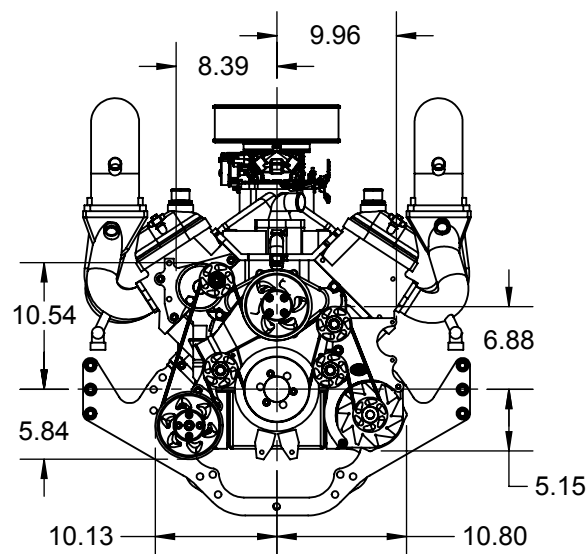
PART NO.
625-8300

TITLE: 1 STG CIRC PUMP SERPENTINE
DRIVE KIT NON POWER STEERING

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ENGINE BLOCK FACE



ENGINE BLOCK FACE

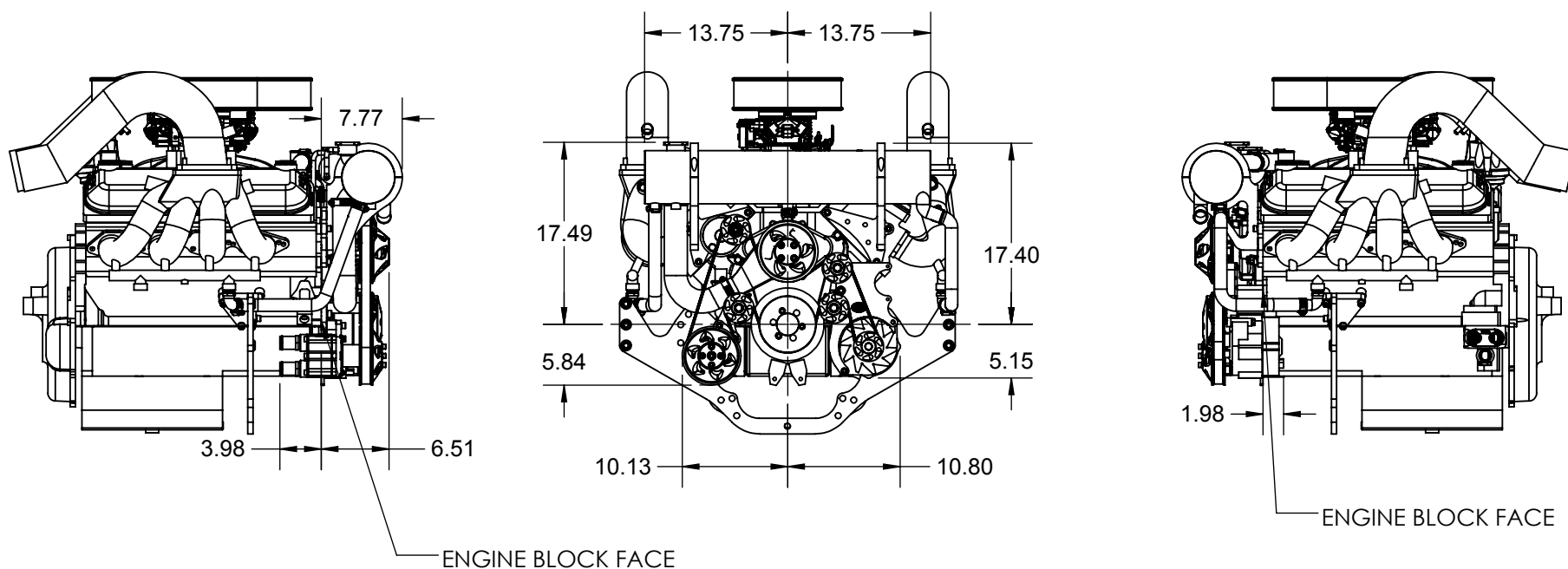
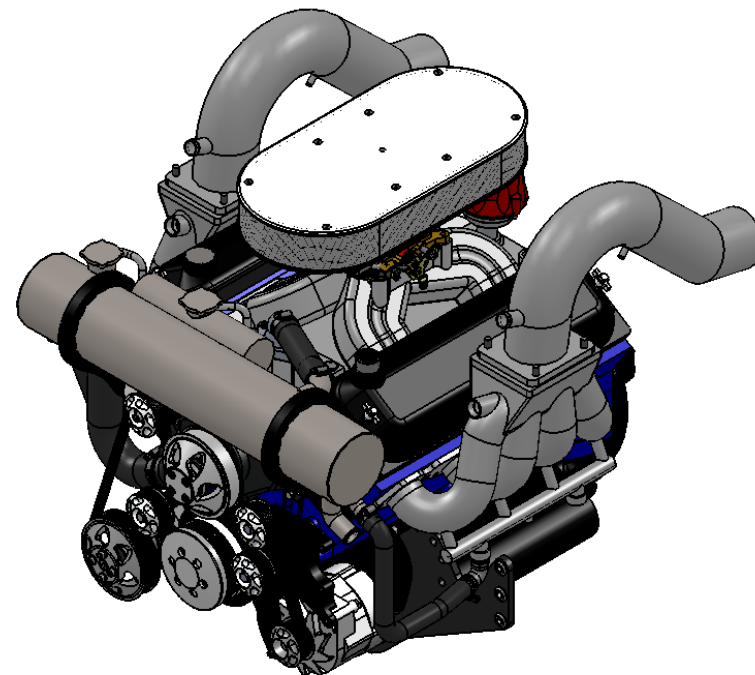
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PART NO.
625-8301

TITLE: 1 STG CIRC PUMP SERPENTINE DIVE KIT
w/HEAT EXCHANGER NON POWER STEERING

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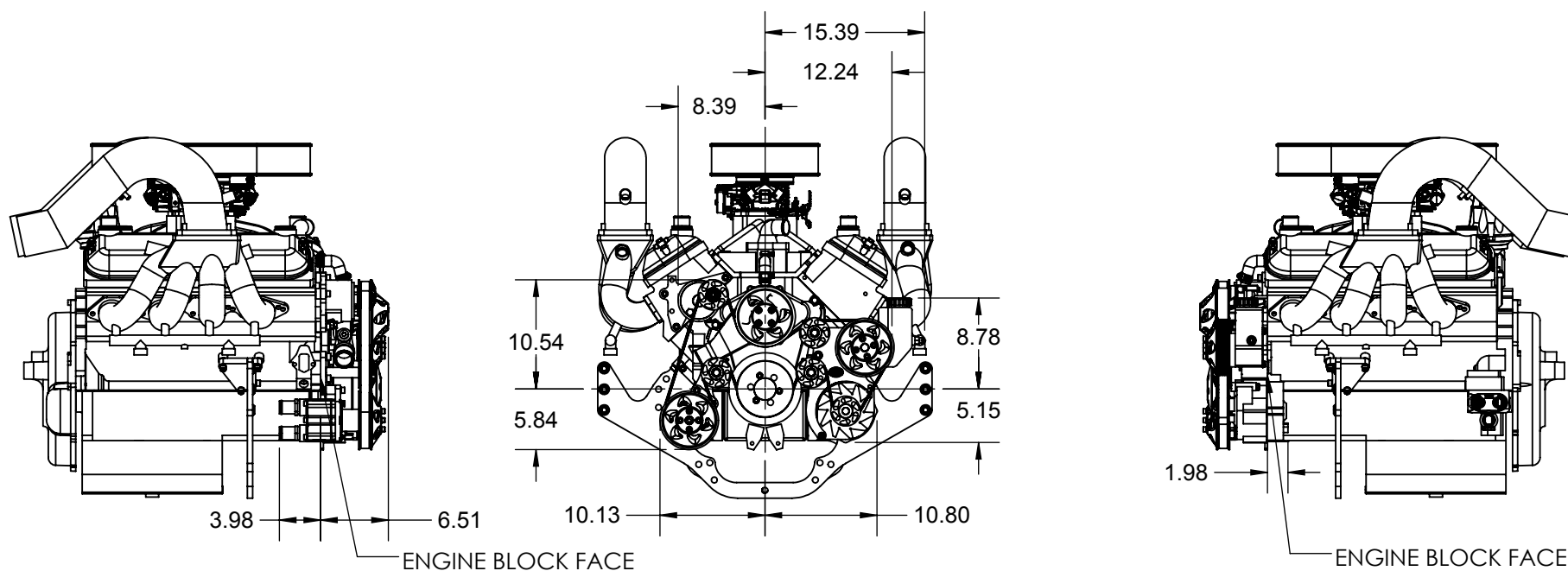
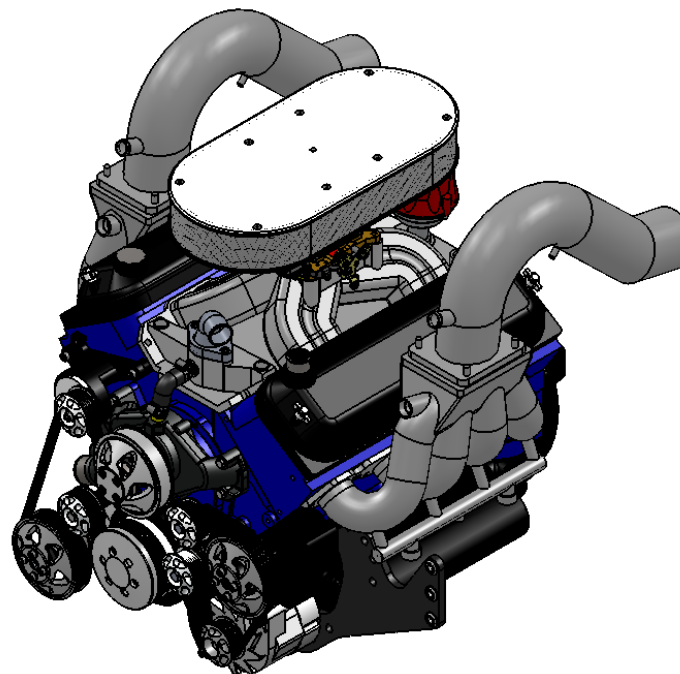
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PART NO.
625-8302

TITLE: 1 STG CIRC PUMP SERPENTINE DRIVE
KIT w/ POWER STEERING

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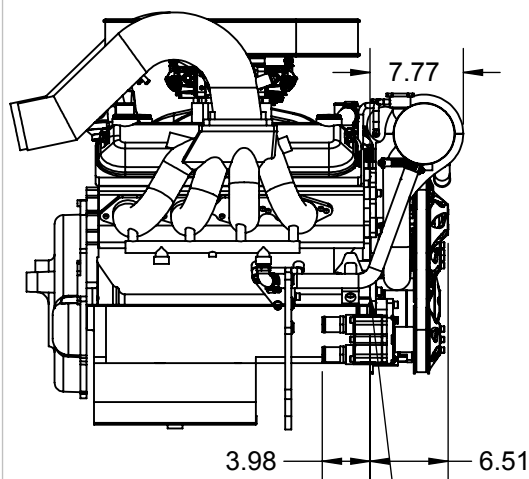
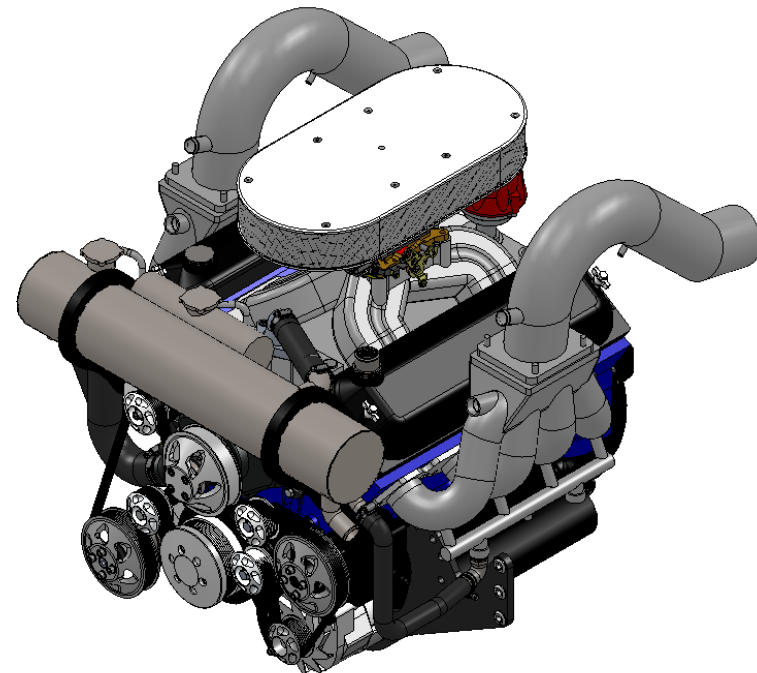
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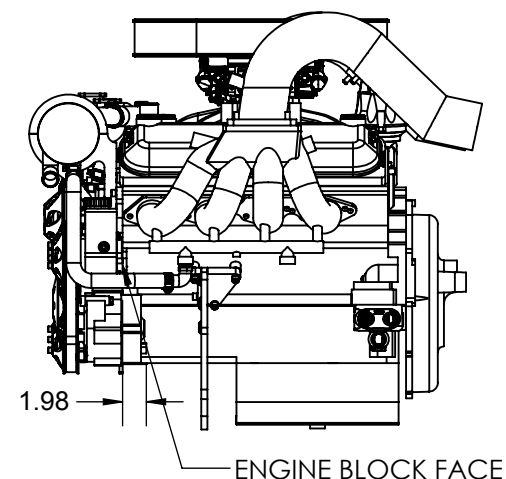
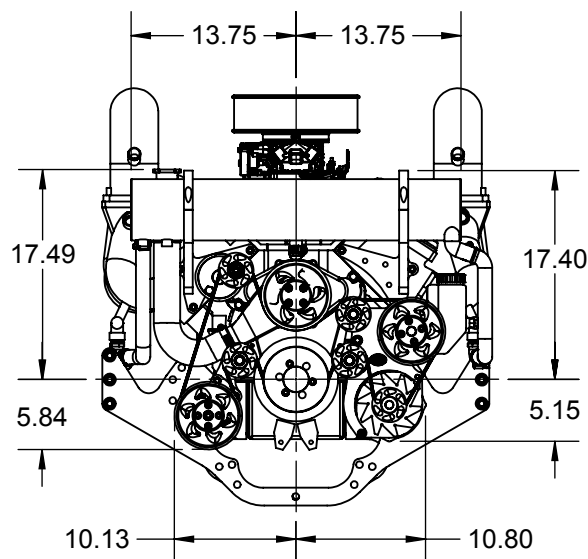
PART NO.
625-8303

TITLE: 1 STG CIRC PUMP SERPENTINE DRIVE KIT w/
POWER STEERING & HEAT EXCHANGER

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ENGINE BLOCK FACE



ENGINE BLOCK FACE

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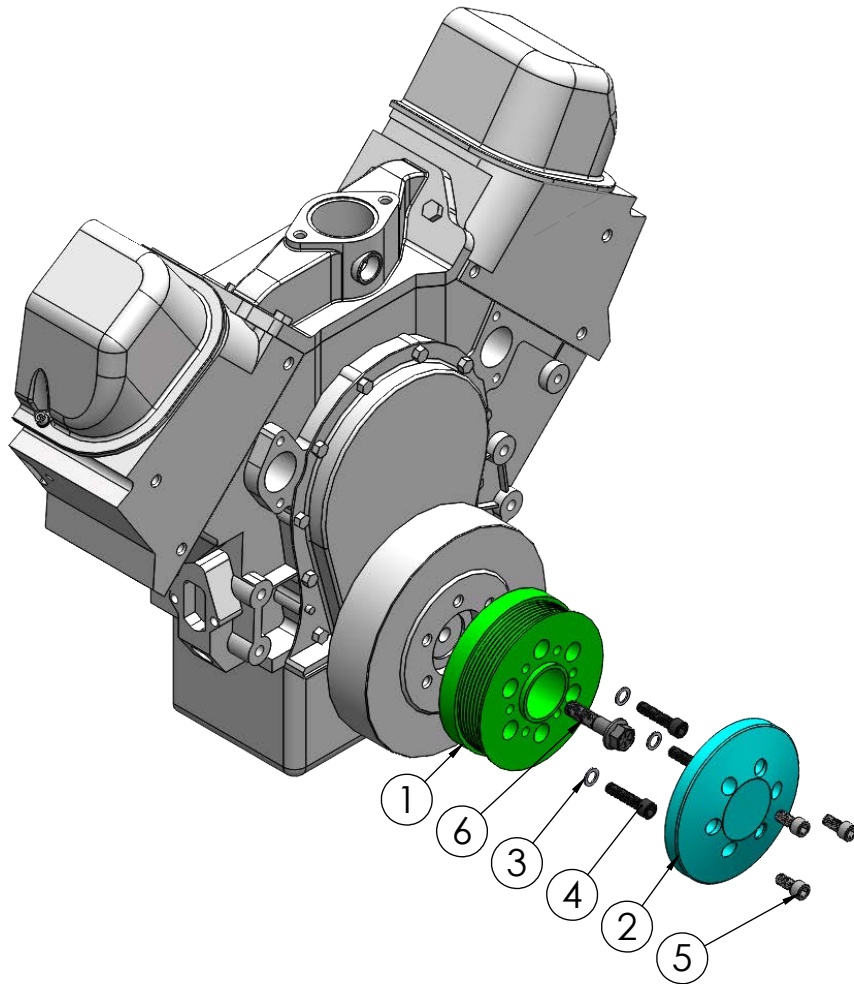
PART NO.

625-830X

TITLE:

BBC CIRCULATION PUMP SERPENTINE
DRIVE KIT - STEP 1

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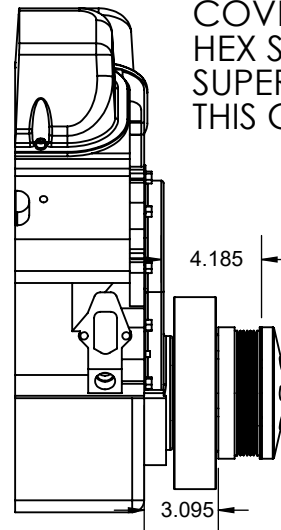


| ITEM NO. | PART NUMBER | DESCRIPTION | QTY. |
|----------|--------------|--------------------------------|------|
| 1 | 625-8176 | PULLEY, CRANK - SERPENTINE | 1 |
| 2 | 625-8177 | COVER, SERPENTINE CRANK PULLEY | 1 |
| 3 | 90037AN-STSS | WASHER, 3/8 AN | 3 |
| 4 | 90037C150SH8 | BOLT, SHCS, 3/8-16x1.50 | 3 |
| 5 | 90037F075SHS | BOLT, 3/8-24x.75 | 3 |
| 6 | 90050F200HH8 | BOLT, CRANK | 1 |

ASSEMBLY IS USED FOR 625-8300 THROUGH
625-8309 DRIVE KITS.

INSTALLATION INSTRUCTIONS:

- 1) MAKE SURE FACE OF DAMPER IS 3.095 FROM FRONT OF ENGINE BLOCK. CRANK PULLEY 1.800 WIDE. SUPERCHARGER PULLEY MOUNTING FACE IS 4.185 FROM BLOCK FACE.
- 2) APPLY LOCTITE TO #4 BOLTS. INSTALL INTO THE #1 CRANK PULLEY WITH #2 WASHERS. USING 5/16 HEX SOCKET TORQUE TO 35 FT. LBS..
- 3) APPLY LOCTITE TO #6. INSTALL INTO CENTER OF THE CRANK PULLEY. USING 3/4 SOCKET, TORQUE TO 55-60 FT. LBS..
- 4) APPLY LOCTITE TO #5 BOLTS. INSTALL #2 COVER, TO THE CRANK PULLEY. USING 5/16 HEX SOCKET TORQUE TO 30 FT. LBS.. FOR SUPERCHARGE APPLICATION, DO NOT INSTALL THIS COVER.



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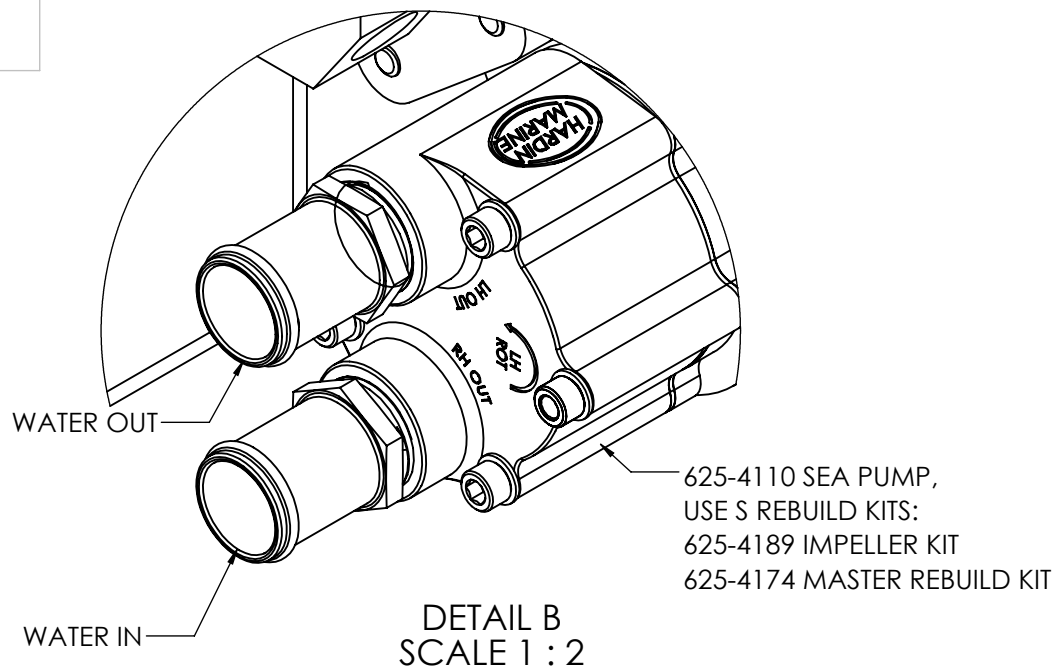
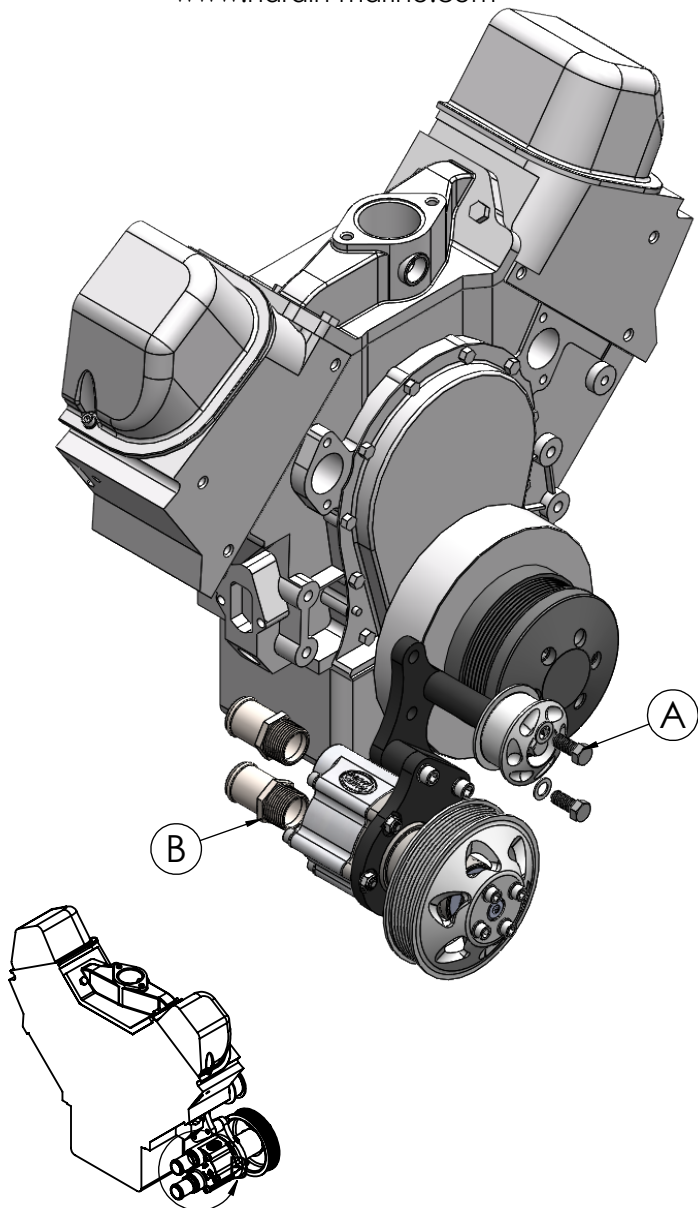
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PART NO.
625-830X

TITLE:
BBC CIRCULATION PUMP SERPENTINE
DRIVE KIT - 1 STG PUMP - STEP -2

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ASSEMBLY IS USED FOR 625-8300, 625-8301, 625-8302 & 625-8303.

INSTALLATION INSTRUCTION:

- 1) APPLY LOCTITE TO THE 7/16 BOLTS, FIGA.
- 2) MOUNT TO ENGINE BLOCK. USING 5/8 SOCKET, TORQUE TO 40/45 FT. LBS..
- 3) FIG. B, SHOWS OPTIONAL 540-222151 1"NPT x 1-1/4 HOSE BARB FITTINGS. NOT INCLUDED.
- 4) DETAIL A SHOWS THE BACK OF THE SEA PUMP. FOR STANDARD ROTATION ENGINE, PORT RH OUT IS THE WATER COMING IN TO THE SEA PUMP. PORT LH OUT IS THE WATER EXITING THE SEA PUMP.

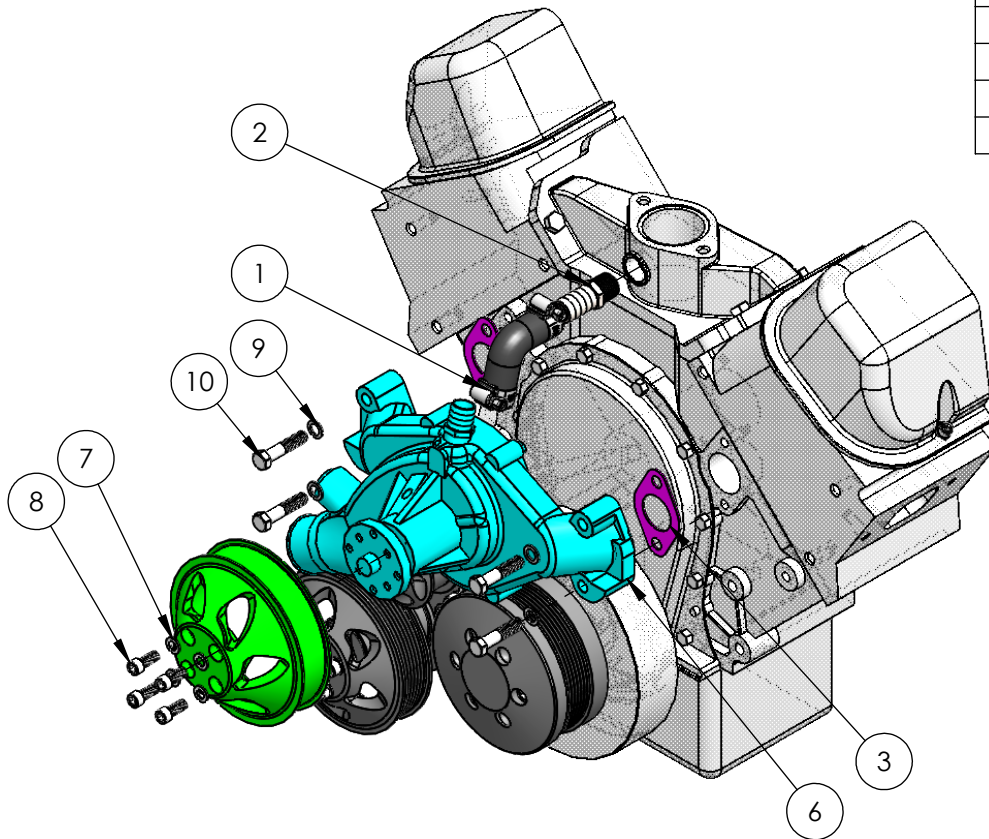
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PART NO.
625-830X

TITLE: BBC CIRCULATION PUMP SERPENTINE
DRIVE KIT - STEP 3

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| ITEM NO. | PART NUMBER | DESCRIPTION | QTY. |
|----------|--------------|----------------------------|------|
| 1 | 100-720-6312 | HOSE CLAMP | 2 |
| 2 | 540-222107 | FITTING, 1/2NPT x 3/4 BARB | 1 |
| 3 | 620-05112K | GASKET, BBC WATER INLET | 2 |
| 4 | 625-4059 | PULLEY, CIRCULATION PUMP | 1 |
| 5 | 625-4581 | HOSE, JUMP | 1 |
| 6 | 700-15301 | BBC CIRCULATION PUMP | 1 |
| 7 | 90031AN-STSS | WASHER, 5/16 AN | 4 |
| 8 | 90031F075SHS | BOLT, SHCS, 5/16-18x3/4 | 4 |
| 9 | 90037AN-STSS | WASHER, 3/8 AN | 7 |
| 10 | 90037C175HHS | BOLT, HHCS 3/8-16x1-3/4 | 4 |

ASSEMBLY IS USED FOR 625-8300 THROUGH
625-8309 DRIVE KITS.

INSTALLATION INSTRUCTIONS:

1) APPLY GASKET TACH SEALANT TO THE
CIRCULATING PUMP GASKETS, #3.
6) APPLY LOCTITE TO THE #10 BOLTS.
INSTALL #9 WASHERS. USING 9/16 SOCKET
INSTALL THE CIRCULATING PUMP. TORQUE
BOLTS TO 35 FT. LBS..
7) APPLY LOCITE TO THE #8 BOLTS. INSTALL
WITH #7 WASHERS. INSTALL #4
CIRCULATING PUMP PULLEY. USING 1/4
ALLEN SOCKET, TORQUE TO 25 FT. LBS..
8) APPLY LIQUID TEFLON SEALANT TO #2
FITTING. USING 7/8 WRENCH TO INSTALL
INTO THE INTAKE MANIFOLD UNDER THE
THERMOSTAT.
9) #5 BYPASS HOSE IS EXTRA LONG TO
PROVIDE CONNECTION TO VARIOUS
INTAKE MANIFOLDS. HOSE WILL NEED TO BE
CUT TO SIZE. INSTALL WITH #1 HOSE
CLAMPS.

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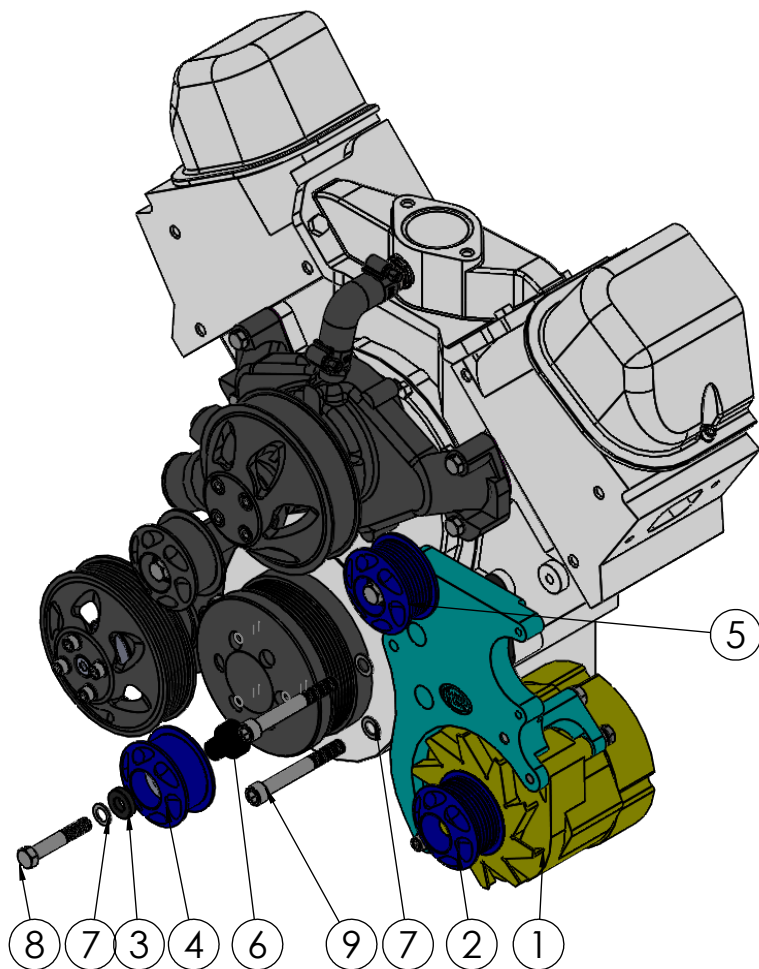
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PART NO.

625-830X

TITLE: **BBC CIRCULATION PUMP
SERPENTINE DRIVE KIT - STEP 4**

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| ITEM NO. | PART NUMBER | DESCRIPTION | QTY. |
|----------|--------------|--------------------------------|------|
| 1 | 620-3147M-NC | 94 AMP CHROME ALTERNATOR | 1 |
| 2 | 625-3130 | PULLEY, ALTERNATOR | 1 |
| 3 | 625-4039 | SPACER, 1" x7/16x.240 | 2 |
| 4 | 625-4364 | PULLEY, SMOOTH IDLER | 1 |
| 5 | 625-4365 | PULLEY, RIBBED IDLER | 1 |
| 6 | 625-8322 | SPACER, IDLER - CIRC DRIVE KIT | 2 |
| 7 | 90043AN-STSS | WASHER , 7/16AN | 4 |
| 8 | 90043C250HHS | BOLT, HHCS, 7/16-14x2.50 | 2 |
| 9 | 90043C350SHS | BOLT, SHCS, 7/16-14x3.50 | 2 |
| 60 | 625-4002 | HUB, SEA PUMP | 1 |

ASSEMBLY IS USED IN 625-8300, 625-8301, 625-8304, & 625-8305 DRIVE KITS.

INSTALLATION INSTRUCTIONS:

- 1) THIS ACCESSORY BRACKET COMES PRE ASSEMBLED.
- 2) REMOVE #8 BOLT, #7 WASHER & #3 SPACER THAT HOLDS THE #4 SMOOTH IDLER & # 8 SPACER TO THE BRACKET.
- 3) APPLY LOCTITE TO #9 BOLTS. INSTALL BOLTS WITH #7 WASHERS INTO LOWER PORT SIDE HOLES NEXT TO THE TIMING COVER. USING 3/8 ALLEN SOCKET, TORQUE TO 40 FT. LBS..
- 4) APPLY LOCTITE TO THE IDLER BOLT. RE-INSTALL THE IDLER PULLEY. USING 5/8 SOCKET, TORQUE TO 40 FT. LBS.
- 5) FOR ALTERNATOR WIRING AND POWER STEERING PLUMBING, SEE 625-8337 INSTRUCTIONS.

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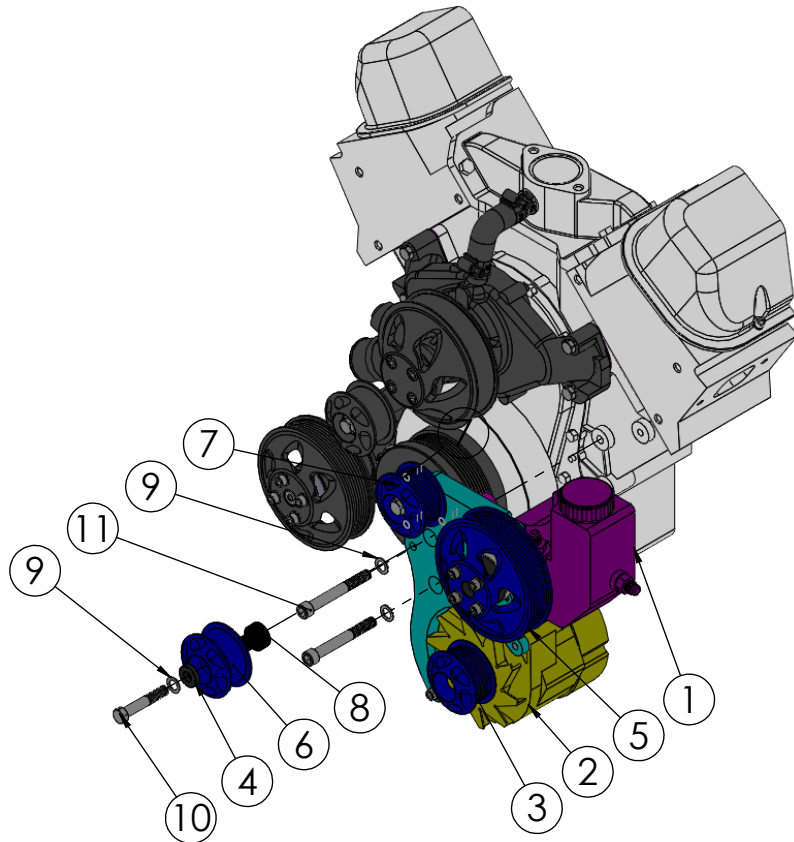
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PART NO.
625-830X

TITLE: BBC CIRCULATION PUMP SERPENTINE
DRIVE KIT w/ POWER STEERING - STEP

4

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| ITEM NO. | PART NUMBER | DESCRIPTION | QTY. |
|----------|--------------|--------------------------|------|
| 1 | 135-802226 | PUMP, POWER STEERING | 1 |
| 2 | 620-3147M-NC | 94 AMP CHROME ALTERNATOR | 1 |
| 3 | 625-3130 | PULLEY, ALTERNATOR | 1 |
| 4 | 625-4039 | SPACER | 2 |
| 5 | 625-4055 | PULLEY, SEA PUMP | 1 |
| 6 | 625-4364 | PULLEY, SMOOTH IDLER | 1 |
| 7 | 625-4365 | PULLEY, RIBBED IDLER | 1 |
| 8 | 625-8322 | SPACER, IDLER PULLEY | 2 |
| 9 | 90043AN-STSS | WASHER , 7/16AN | 4 |
| 10 | 90043C250HHS | BOLT, HHCS, 7/16-14x2.50 | 2 |
| 11 | 90043C350SHS | BOLT, SHCS, 7/16-14x3.50 | 2 |
| 68 | 625-4002 | HUB, SEA PUMP | 1 |

ASSEMBLY IS USED IN 625-8302, 625-8303, 625-8306, 625-8307, 625-8308 & 625-8309 DRIVE KITS.

INSTALLATION INSTRUCTIONS:

- 1) THIS ACCESSORY BRACKET COMES PRE ASSEMBLED.
- 2) REMOVE #10 BOLT, #9 WASHER & #4 SPACER THAT HOLDS THE # 6 SMOOTH IDLER & # 8 SPACER TO THE BRACKET.
- 3) APPLY LOCTITE TO #11 BOLTS. INSTALL BOLTS WITH #9 WASHERS INTO LOWER PORT SIDE HOLES NEXT TO THE TIMING COVER. USING 3/8 ALLEN SOCKET, TORQUE TO 40 FT. LBS..
- 4) APPLY LOCTITE TO THE IDLER BOLT. RE-INSTALL THE IDLER PULLEY. USING 5/8 SOCKET, TORQUE TO 40 FT. LBS.
- 5) FOR ALTERNATOR WIRING AND POWER STEERING PLUMBING, SEE 625-8338-1 INSTRUCTIONS.

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PART NO.

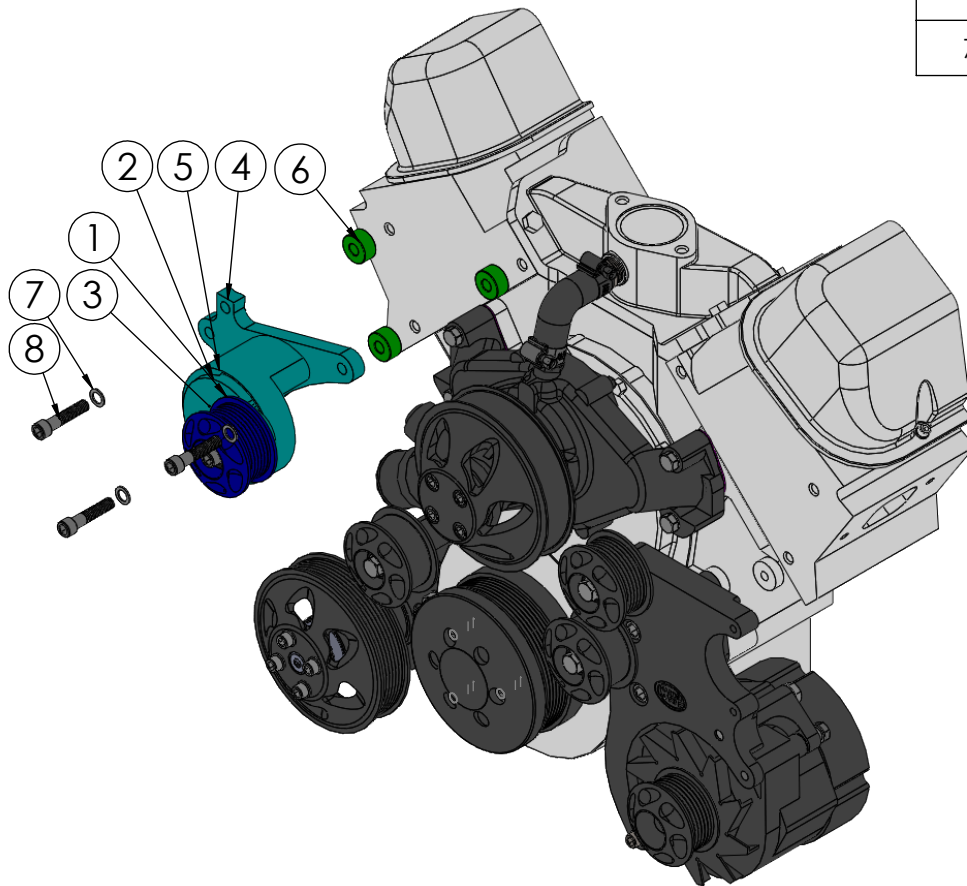
625-830X

TITLE:

BBC CIRCULATION PUMP SERPENTINE DRIVE KIT - STEP 5

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| ITEM NO. | PART NUMBER | DESCRIPTION | QTY. |
|----------|--------------|---|------|
| 1 | 625-4364 | PULLEY, RIBBED IDLER | 1 |
| 2 | 625-4442 | ARM, TENSIONER - GEN 3 | 1 |
| 3 | 625-4444 | PIN, HARDIN TENSIONER | 1 |
| 4 | 625-4551 | BASE, HEAT EXCHANGER MOUNT- STRB | 1 |
| 5 | 625-8323 | BODY, TENSIONER - CIRC SERPENTINE DRIVE KIT | 1 |
| 6 | 755-5118 | SPACER | 3 |
| 7 | 90037AN-STSS | WASHER, 3/8 AN | 3 |
| 8 | 90037C175SHS | BOLT,SHCS, 3/8-16 x 1-3/4 | 3 |
| 73 | 625-4002 | HUB, SEA PUMP | 1 |



ASSEMBLY IS USED FOR 625-8300 THROUGH
625-830\9 DRIVE KITS.

INSTALLATION INSTRUCTIONS:

- 1) THE TENSIONER ASSEMBLY COMES PRE ASSEMBLED. IF TENSIONER IS BEING USED WITH 625-8301, 625-8303, 625-8305, 625-8307 & 625-8309 HEAT EXCHANGER KITS, 625-4655 BRACKETS WILL BE INSTALLED.
- 2) APPLY LOCTITE TO THE SUPPLIED #8 BOLTS. INSTALL BOLTS WITH #7 WASHERS INTO THE #4 TENSIONER BRACKET.
- 3) #6 SPACERS ARE INSTALLED BETWEEN THE TENSIONER BRACKET AND CYLINDER HEAD.
- 4) SLIDES BOLTS THRU THE SPACERS AND THREAD INTO THE CYLINDER HEAD, FIG C. USING 5/16 ALLEN SOCKET,TORQUE BOLTS TO 30 FT. LBS..

TITLE:

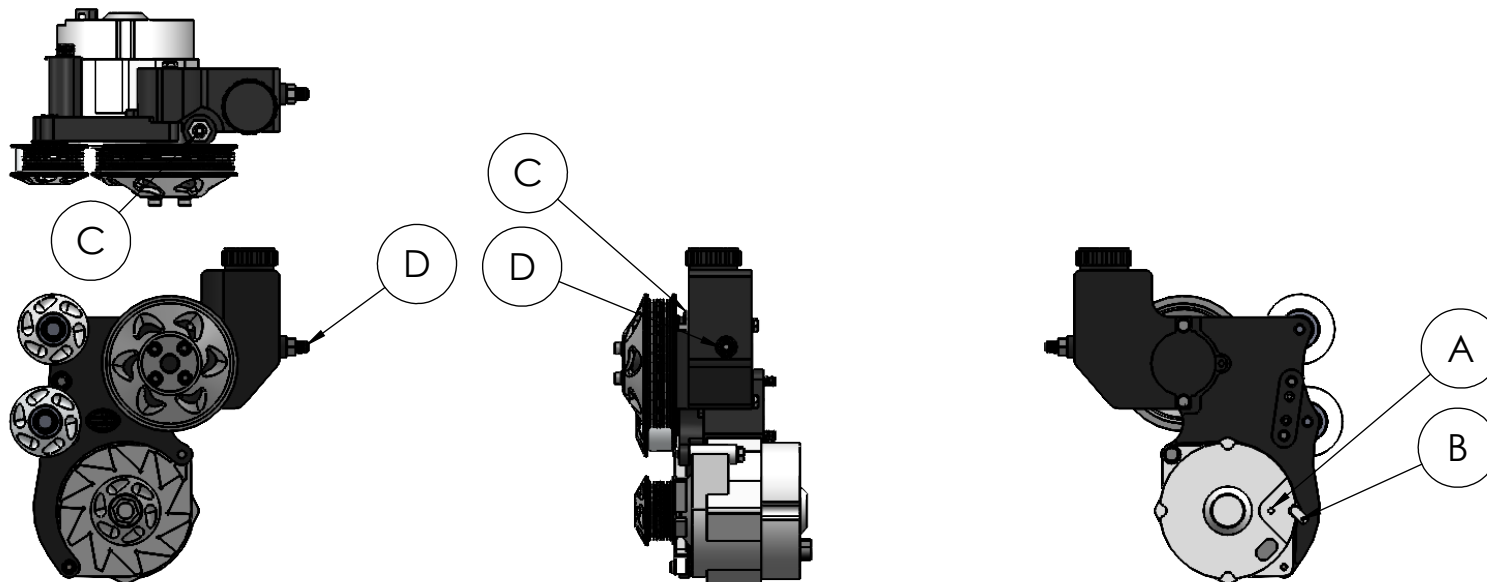
POWER STEERING & ALTERNATOR

ALTERNATOR WIRING INSTRUCTIONS FOR 625-8300, 625-8301, 625-8302 & 625-8303 DRIVE KITS:

- 1) RUN A 10 GAUGE WIRE FROM THE CHARGING POST ON THE BACK OF THE ALTERNATOR, FIG A, TO THE STARTER STUD WERE THE BATTERY CABLE ATTACHES TO.
- 2) RUN A 12 GAUGE GROUND WIRE FROM THE GROUND TAB ON THE BACK OF THE ALTERNATOR, FIG B, TO THE ENGINE BLOCK.

POWER STEERING PUMP HOSE CONNECTIONS AND BLEEDING INSTRUCTIONS FOR 625-8302 & 625-8303 DRIVE KITS:

- 1) HIGH PRESSURE OUT -6 JIC, SEE FIG. C. LOW PRESSURE RETURN -6 JIC, SEE FIG. D.
- 2) FILL RESERVOIR 3/4 FULL WITH GM POWER STEERING FLUID. VERY IMPORTANT TO KEEP RESERVOIR HALF FULL DURING BLEEDING PROCESS.
- 3) START ENGINE. WHILE IDLING CHECK FOR LEAKS.
- 4) BEGIN TO CYCLE THE STEERING WHEEL FROM SIDE TO SIDE UNTIL YOU START TO FEEL A HARD LOCK OUT. REPEAT THIS PROCESS UNTIL A DELIBERATE STOP OCCURS IN BOTH DIRECTIONS.
- 5) TO CHECK IF THE SYSTEM IS BLED PROPERLY. WITH THE ENGINE TURNED OFF AND THE STERNDRIVE STRAIGHT AHEAD. GO BEHIND THE BOAT AND MANUALLY TRY TO TURN THE STERNDRIVE BACK AND FORTH. IF THE DRIVE MOVES, THERE IS STILL AIR IN THE SYSTEM. REPEAT PROCESS.



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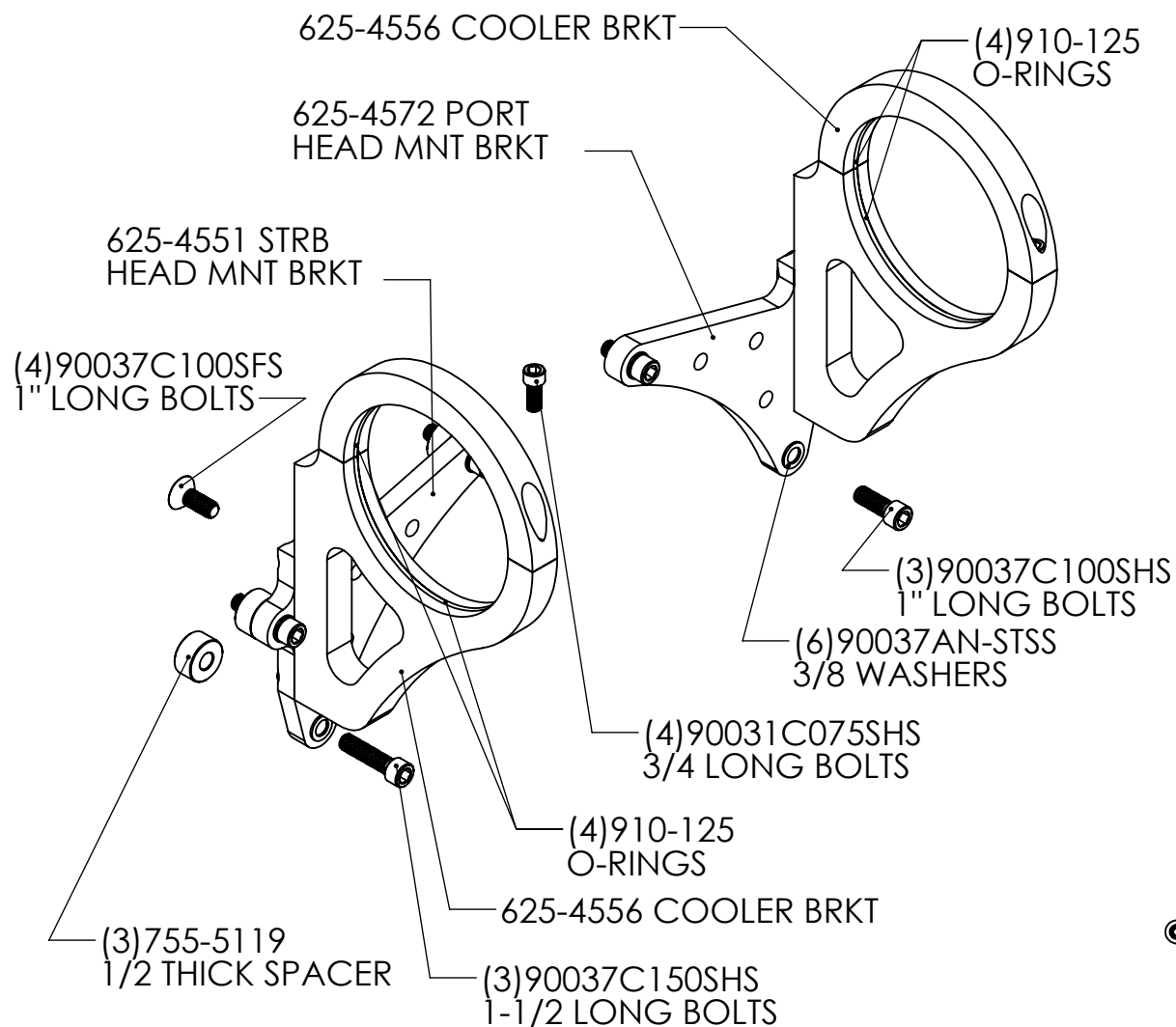
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PART NO.

625-4544

TITLE:

HEAT EXCHANGER MOUNTING BRACKETS



MOUNTING INSTRUCTIONS:

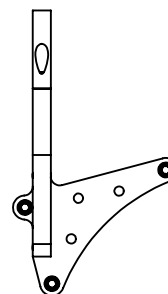
1) ATTACH 625-4556 OIL COOLER BRACKETS TO HEAD MOUNT BRACKETS. APPLY LOCTITE TO THE (4) 90037C100SFS BOLTS & INSERT THROUGH THE COUNTERSUNK SIDE OF THE BRACKET. TORQUE TO 30 FT. LBS..

2) THE PORT SIDE BRACKET ASSEMBLY MOUNTS DIRECTLY ON THE HEAD. APPLY LOCTITE TO THE (3) 90037C100SHS BOLTS WITH WASHERS, TORQUE TO 30 FT. LBS..

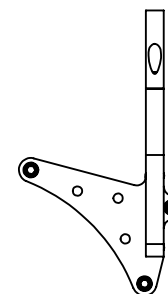
3) THE STARBOARD SIDE BRACKET IS SPACED OFF THE HEAD BY THE (3) 755-5119 SPACERS. APPLY LOCTITE TO THE (3) 90037C150SHS BOLTS WITH WASHERS, TORQUE TO 30 FT. LBS..

4) MAKE SURE THE 900-125 ORINGS ARE INSTALLED IN THE BRACKETS.

5) AFTER INSTALLING THE HEAT EXCHANGER, APPLY LOCTITE TO (4) 90031C075SHS BOLTS AND TORQUE TO 20 FT. LBS..



STARBOARD
HEAD



PORT
SIDE

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PART NO.
625-4570

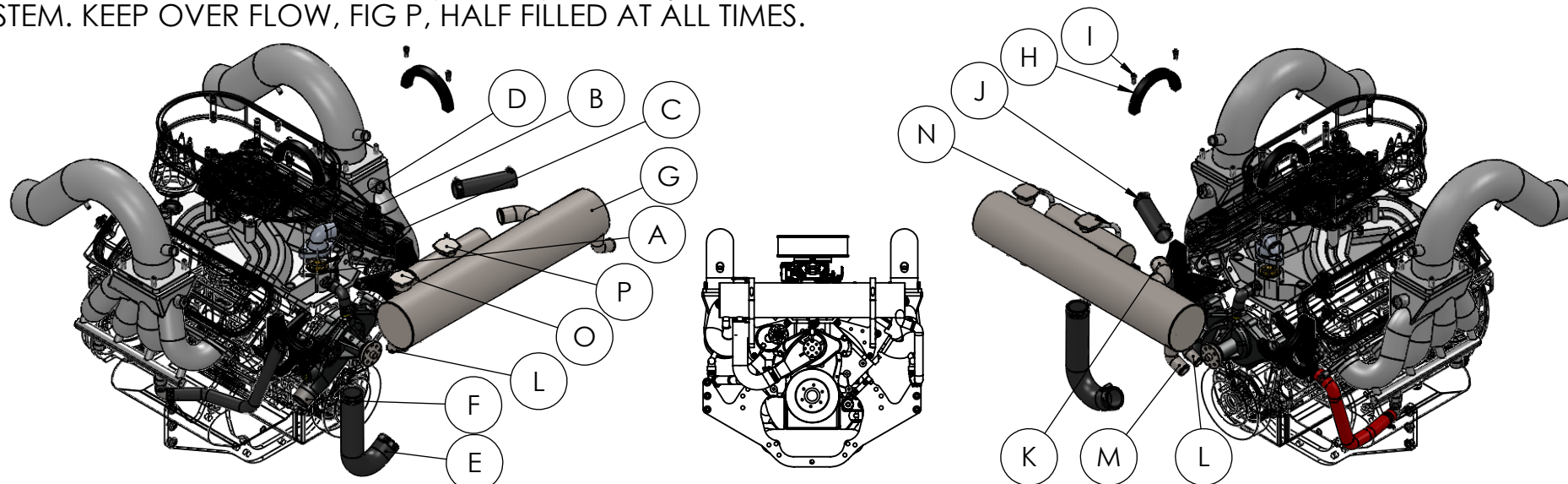
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TITLE: CIRC PUMP SERPENTINE DRIVE
KIT HEAT EXCHANGER

ASSEMBLY IS USED FOR 625-8301 & 625-8303 DRIVE KIT.

INSTALLATION INSTRUCTIONS:

- 1) FOLLOW 625-4544 BRACKET MOUNTING INSTRUCTIONS TO MOUNT HEAT EXCHANGER BRACKETS.
- 2) INSTALL 540-160106 140 DEGREES THERMOSTAT, FIG. A, INTO THE COUNTERBORE IN THE INTAKE MANIFOLD.
- 2) INSTALL 625-4555 THERMOSTAT HOUSING, FIG.B , TO THE INTAKE MANIFOLD. APPLY GREASE TO THE THERMOSTAT HOUSING O-RING, FIG. C. APPLY LOCTITE TO THE (2)3/8-16x3/4 BOLTS, FIG. D. SLIDE BOLTS THROUGH THE HOUSING AND THREAD TO INTAKE MANIFOLD. DO NOT TORQUE THE BOLTS YET.
- 3) INSTALL 625-4544 HOSE, FIG. E, TO THE CIRCULATING PUMP, FIG. F. LOOSELY INSTALL HOSE CLAMPS.
- 4) INSTALL 625-4550 HEAT EXCHANGER, FIG. G, INTO THE BRACKET CRADLES.
- 5) INSTALL UPPER BRACKET CLAMP, FIG. H. APPLY LOCTITE TO THE 5/16-18 BOLTS, FIG. I. LOOSELY THREAD INTO THE LOWER BRACKETS.
- 6) INSTALL 625-4573 HOSE, FIG. J AND CLAMPS BETWEEN THE HEAT EXCHANGER CONNECTOR, FIG. K AND 625-4555 THERMOSTAT HOUSING.
- 7) TORQUE UPPER BRACKET CLAMP, FIG. H, TO 20 FT. LBS..
- 8) TORQUE THERMOSTAT HOUSING BOLTS, FIG.D, TO 30 FT. LBS..
- 9) CONNECT HOSE FROM EXHAUST TO THE THE 1" BARB CONNECTIONS, FIG. L.
- 10) CONNECT 1-1/4 WATER INLET HOSE TO THE PORT SIDE HEAT EXCHANGER BARB, FIG.M.
- 11) CONNECT 625-4578, FIG.N, DRAIN HOSE TO OVER FLOW TANK NIPPLE.
- 12) HEAT EXCHANGER MAIN FILL, FIG. O, WITH 50/50 PROPYLENE GYLCOL ANTIFREEZE. RUN ENGINE TO BURP SYSTEM. KEEP OVER FLOW, FIG P, HALF FILLED AT ALL TIMES.



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PART NO.

625-2319

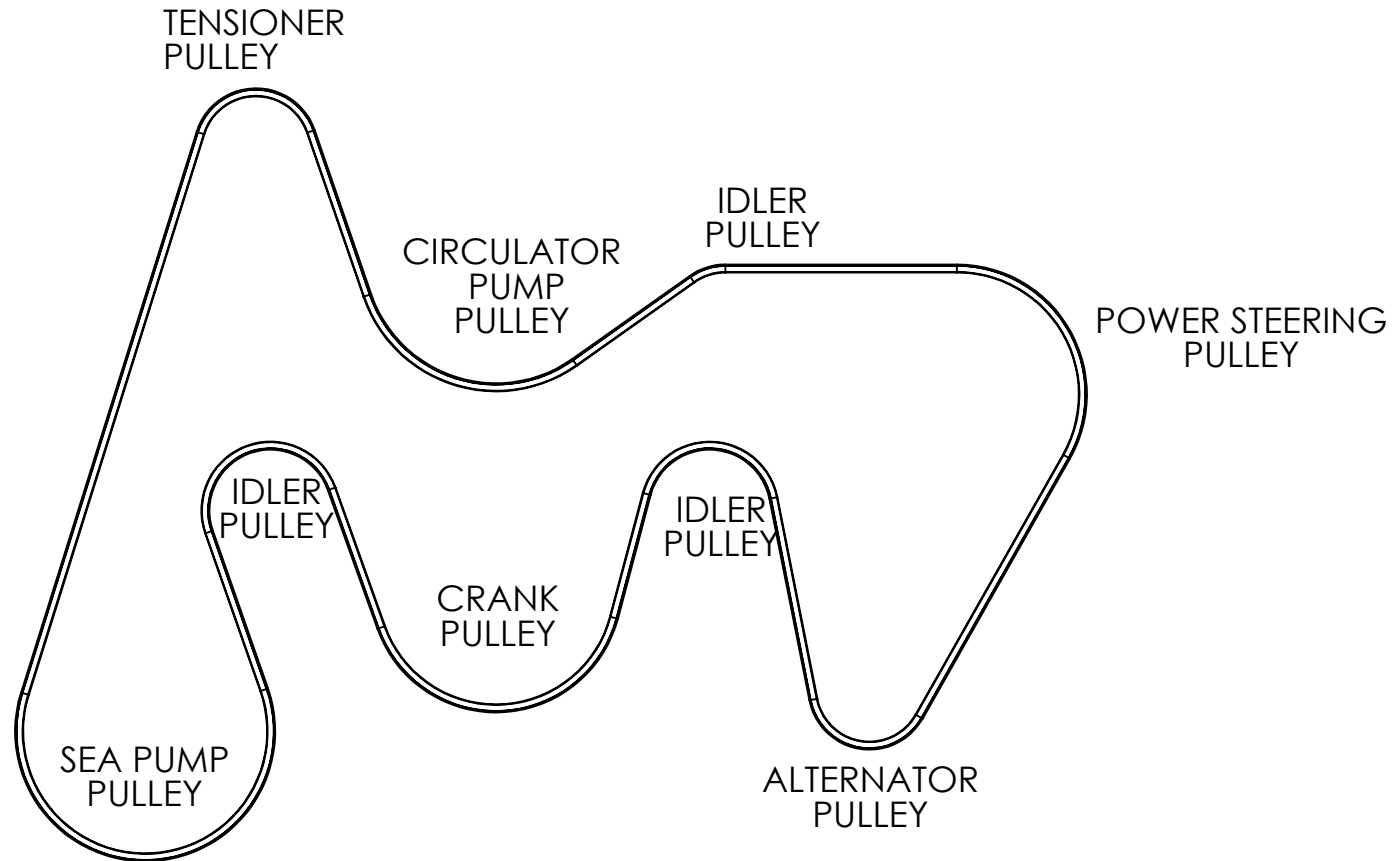
USED IN KITS:

625-8302
625-8303
625-8306
625-8307
625-8308
625-8309

TITLE:

BELT, CIRC PUMP KIT w POWER STEERING

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PART NO.

625-2322

USED IN KITS:

625-8301

625-8302

625-8304

625-8305

TITLE:

BELT, CIRC PUMP KIT NON POWER
STEERING

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