



63821 Ford Combination Vacuum Pump/Alternator Mount

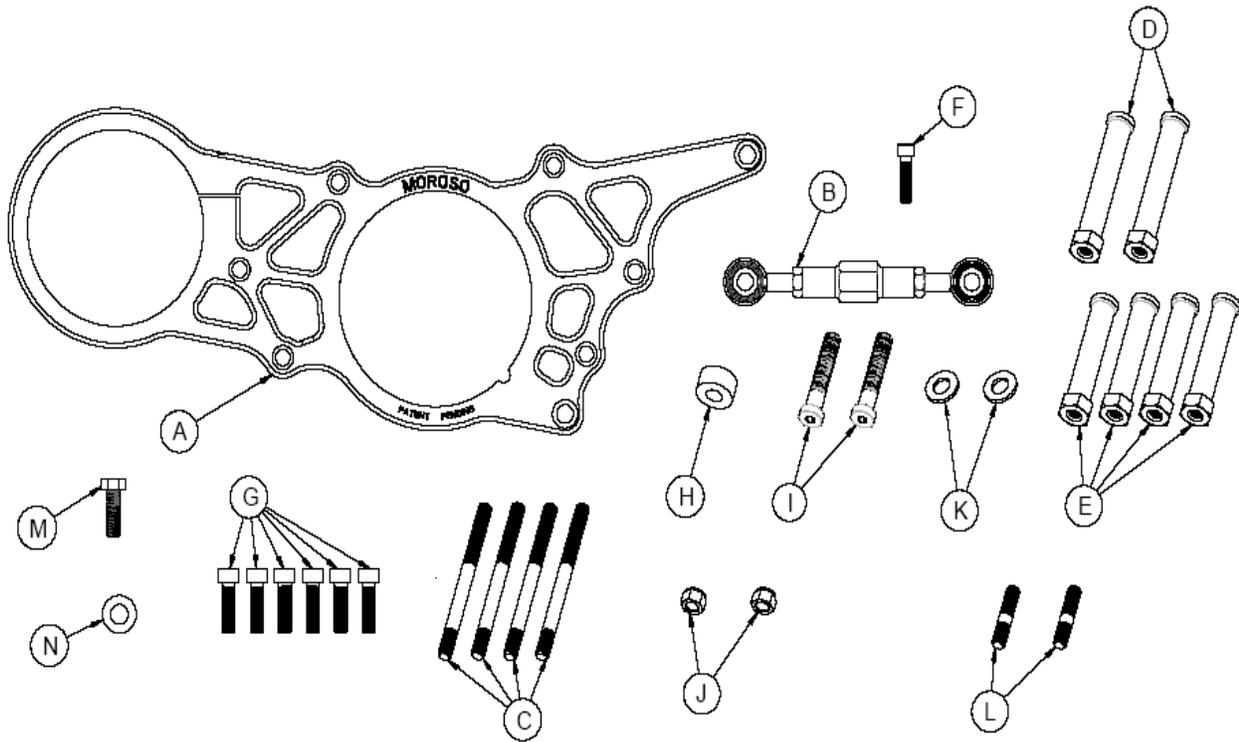
This kit is engineered to mount a Moroso enhanced style vacuum pump (22642) and a Nippon Denso 93MM alternator to a Ford small block engine equipped with a **Meziere** electric water pump. It will **not** work with other water pumps, vacuum pumps or larger alternators. Take a few moments to unpack the contents of the kit and familiarize yourself with its components, (refer to the Parts List illustration). Read the instructions through completely before attempting installation.

Mounting the Plate. The plate is attached to the engine using the water pump mounting bolt locations and two additional bolt locations in the timing cover above the pump. The water pump mounting bolts are to be replaced with the 4.000" long studs. Thread the studs through the timing cover and into the block with the shorter threads going in and the longer threads facing out. Thread the two shorter, 1.500" studs into the timing cover at the locations shown in the assembly illustration. A removable thread-locking compound can be used here. Once the studs are in place, install the adapter plate (part of the Meziere pump kit) and the pump. Use the four 3.000" aluminum threaded standoffs to mount the water pump and the two 3.500" standoffs above. The hex on the standoffs should face outward. Use a small amount of anti-seize compound on the aluminum threads and install all standoffs finger tight. Apply a small amount of anti-seize compound to the threads of the 5/16 socket cap screws and mount up the Vacuum Pump / Alternator plate to the six standoffs, hand tight. Tighten up all standoffs first, and then tighten the socket head cap screws to complete the mounting of the plate.

Mounting the Vacuum Pump. Insert the vacuum pump through the back of the plate. The pump should go into the plate with only a slight press and should rotate freely without the pinch clamp bolt. Install the vacuum pump pulley (Moroso part 64885 or 64887). Belt tensioning is accomplished by rotating the pump. Using the recommended 2 1/2" drive pulley, a 5" pump pulley, and a 4L330, (1/2" X 33"), V-belt, correct tension will occur with the inlet and outlet ports at 7:00 and 11:00 o'clock on the pump. Complete the installation by tightening up the 1/4-20 pinch-clamp cap screw. Use anti-seize compound on the threads.

Mounting the Alternator. Using one each of the two low-head 3/8 cap screws and lock nuts, hang the alternator from the large mounting foot to the uppermost hole in the bracket. Assemble the adjusting link and bolt it up to the lower mounting hole in the bracket, using the second low-head cap screw, lock nut and, aluminum spacer provided. The lower hole in the alternator is typically tapped for an 8MM bolt and we have provided a bolt and washer for this. We recommend, however, that the lower hole be drilled out and tapped for a 3/8-16 fastener for a better installation. Make certain that all vent holes in the alternator are masked to prevent chips from entering the housing during this procedure and make every effort to ensure proper alignment. Using a 4.000" V-belt drive pulley (Moroso part 23523) and the original alternator pulley, install a 4L295, (1/2" X 29 1/2") belt for a proper fit.

63821 PARTS LIST



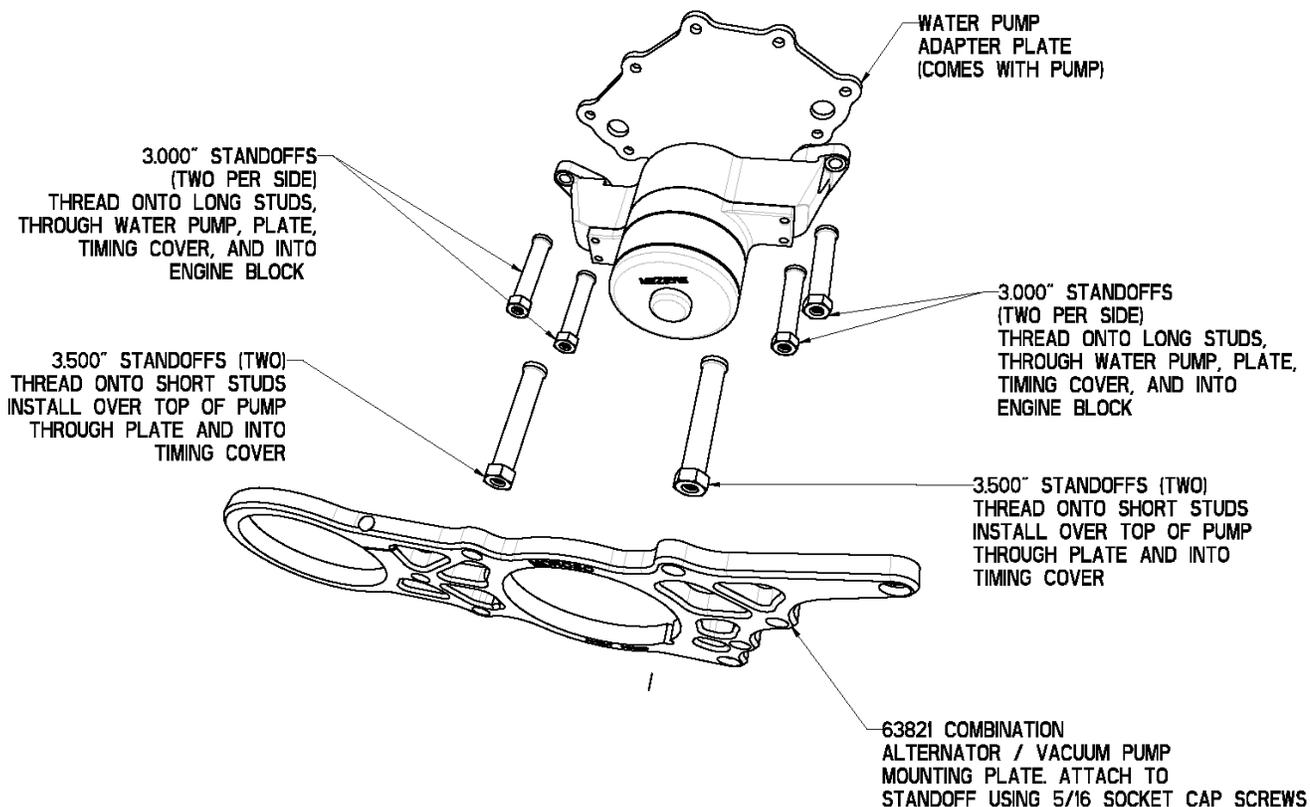
- A. VACUUM PUMP-ALTERNATOR MOUNTING PLATE
- B. ASSEMBLED HEIM LINK
- C. 5/16-18 X 4.000 MOUNTING STUDS (4)
- D. ALUMINUM THREADED STANDOFFS, 3.500" (2)
- E. ALUMINUM THREADED STANDOFFS, 3.000" (4)
- F. 1/4-20 X .750" SOCKET CAP SCREW
- G. 5/16-18 X 1.000 SOCKET CAP SCREWS (6)

- H. ALTERNATOR LINK SPACER
- I. 3/8-16 LOW HEAD CAP SCREWS (2)
- J. 3/8-16 NYLOCK NUTS (2)
- K. 3/8 FLAT WASHERS (2)
- L. 5/16-18 X 1.500 STUDS (2)
- M. 8MM BOLT
- N. 8MM WASHER

Notes

- Belt lengths were determined using industry standard "4L" or "A" cross-sections. Other belt sections will work. For example, a belt with a section width of .410 will fit the pulleys however the outer diameter will be less.
- The standoffs were machined with an 11/16" hex. This is the same size as a -6AN fitting wrench. Using aluminum fitting wrenches will help preserve the finish on the standoffs.
- Depending on the location of the water pump inlet, it may be necessary to use a reduced diameter fitting or a short length of straight pipe for clearance.
- The use of an anti-seize compound is recommended on all aluminum threads.

ASSEMBLY DIAGRAM



Related Moroso Components.

65853 SB Ford Drive Mandrel Kit
63846 SB Ford Drive Mandrel Kit
22842 Vacuum Pump, 4-vane
22644 Vacuum Pump, 4-vane-unplated
22840 Vacuum Pump, 3-vane
64885 Vacuum Pump Pulley
64887 Vacuum Pump Pulley, Offset
64886 Vacuum Pump Pulley, 28 tooth Gilmer
64888 Vacuum Pump Pulley, 36 tooth Gilmer
23540 Vacuum Pump Pulley, Radius Tooth

**For Technical Assistance, Call Moroso's Tech Line at
(203) 458-0542, 458-0546 8:30am – 5:00pm Eastern Time**

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