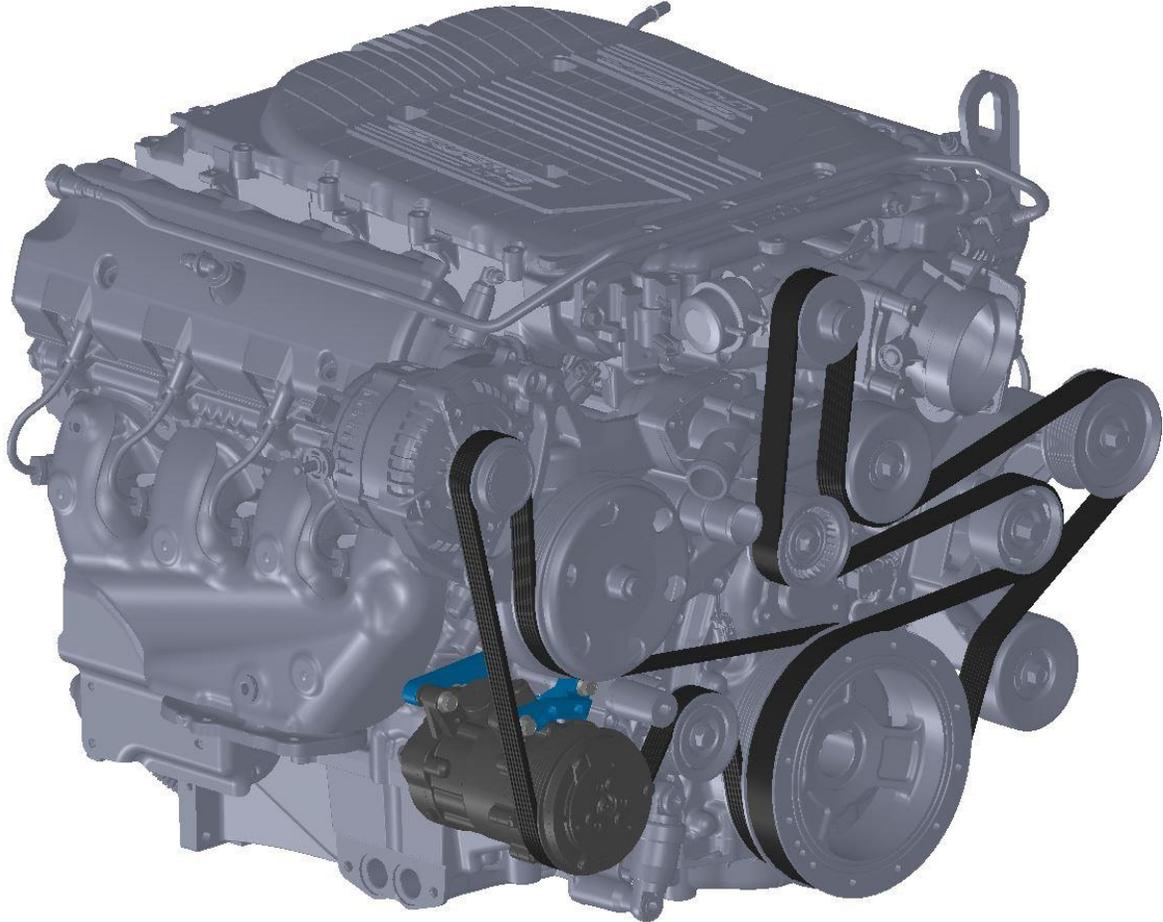




**GM GEN 5 LT4/LT1 DRY SUMP LOW MOUNT AC COMPRESSOR BRACKET
KIT NUMBERS: 20-210, 20-210B, 20-211, & 20-211B**



NOTE: *Please read all instructions before proceeding with the installation of your new **GM GEN 5 LT4/LT1 DRY SUMP LOW MOUNT AC COMPRESSOR BRACKET**. If these instructions are not fully understood an installation should not be attempted. In this case please contact Holley's tech service department or a qualified mechanic.*

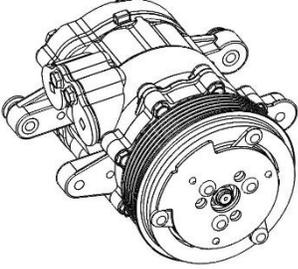
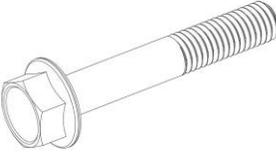
This kit requires the following GM parts to be installed on bare crate engine:

- 12639512 A/C Tensioner Bracket
- 12668977 Belt Tensioner
- 22868687 Alternator
- 12651112 Water Pump/Generator/Compressor Belt

20-210 & 20-210B Kits

(For use with **DRY** sump LT1 & LT4 engines.) **WILL NOT** fit Detroit Speed Sub-frames

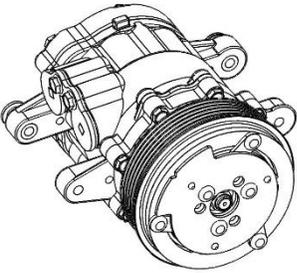
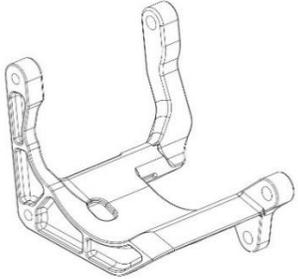
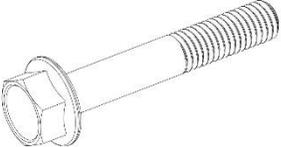
PARTS LIST:

PICTURE	QTY	DESCRIPTION	APPLICATION
	<p>THIS KIT IS DESIGNED FOR A SD7 TYPE A/C COMPRESSOR (compressor not included) Holley P/N 199-102</p>		
	1	Low Mount A/C Compressor Bracket	LT1 & LT4 Dry Sump Engine
	1	FLANGE HEAD BOLT M8 x 1.25 x 100mm	Bracket to Engine Upper Bolt
	1	FLANGE HEAD BOLT M8 x 1.25 x 50mm	Bracket to Engine Lower Bolt
	2	FLANGE HEAD BOLT M8 x 1.25 x 40mm	Bracket to Rear A/C Compressor Ears
	2	FLANGE HEAD BOLT M8 x 1.25 x 30mm	Bracket to Front A/C Compressor Ears
	1	Ground Strap	Properly Ground A/C Compressor to Engine

20-211 & 20-211B Kits

(For use with **DRY** sump LT1 & LT4 engines with Detroit Speed Sub-frames)

PARTS LIST:

PICTURE	QTY	DESCRIPTION	APPLICATION
		<p>THIS KIT IS DESIGNED FOR A SD7 TYPE A/C COMPRESSOR (compressor not included) Holley part # 199-102</p>	
	1	Low Mount A/C Compressor Bracket DETROIT SPEED SUBFRAME SPECIFIC	LT1 & LT4 Dry Sump Engine with DSE Sub-frame
	1	FLANGE HEAD BOLT M8 x 1.25 x 100mm	Bracket to Engine Upper Bolt
	1	FLANGE HEAD BOLT M8 x 1.25 x 50mm	Bracket to Engine Lower Bolt
	1	FLANGE HEAD BOLT M8 x 1.25 x 40mm	Bracket to Rear A/C Compressor Ears
	2	FLANGE HEAD BOLT M8 x 1.25 x 30mm	Bracket to Front A/C Compressor Ears
	1	Ground Strap	Properly Ground A/C Compressor to Engine

INSTALLATION:

- Orient Sanden SD7 A/C compressor as shown in **Figure 1** into the Holley bracket. (Refrigerant ports should point toward the alternator when installed on the engine.) Insert (2) M8 x 1.25 x 40mm flange bolts into the rear compressor ears and thread into tapped holes in the bracket. Leave bolts loose until all bolts are started.

The DSE sub-frame compatible versions (20-211 & 20-211B) do not have the lower rear mounting ear, see **Figure 2. This is for frame clearance issues and therefore only 1 rear flange bolt is included in the kit. Trimming of the lower rear mounting ear on the A/C compressor body may be necessary.*

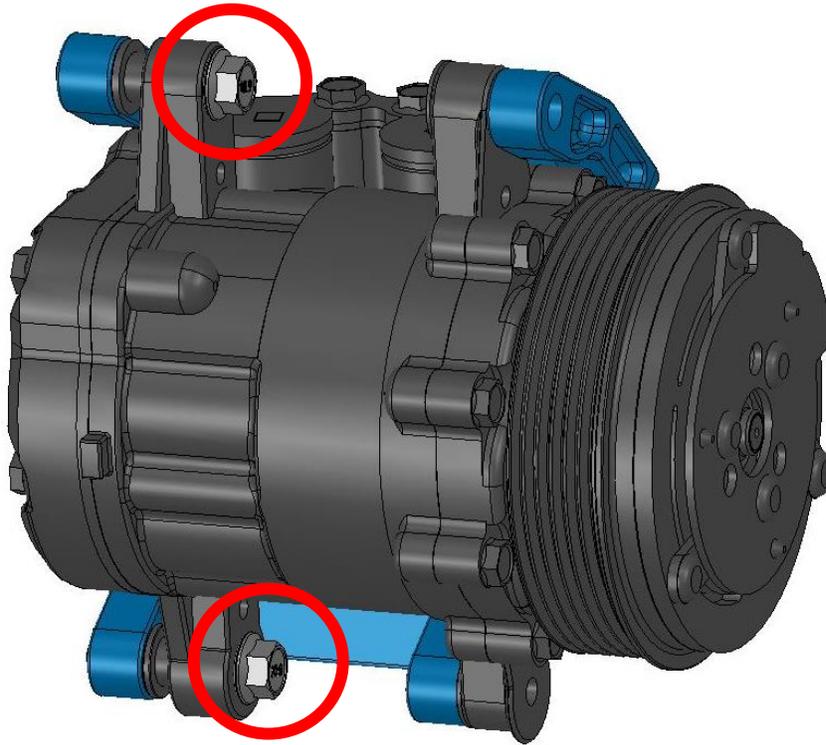


Figure 1: Note that both flange bolts face rearward.

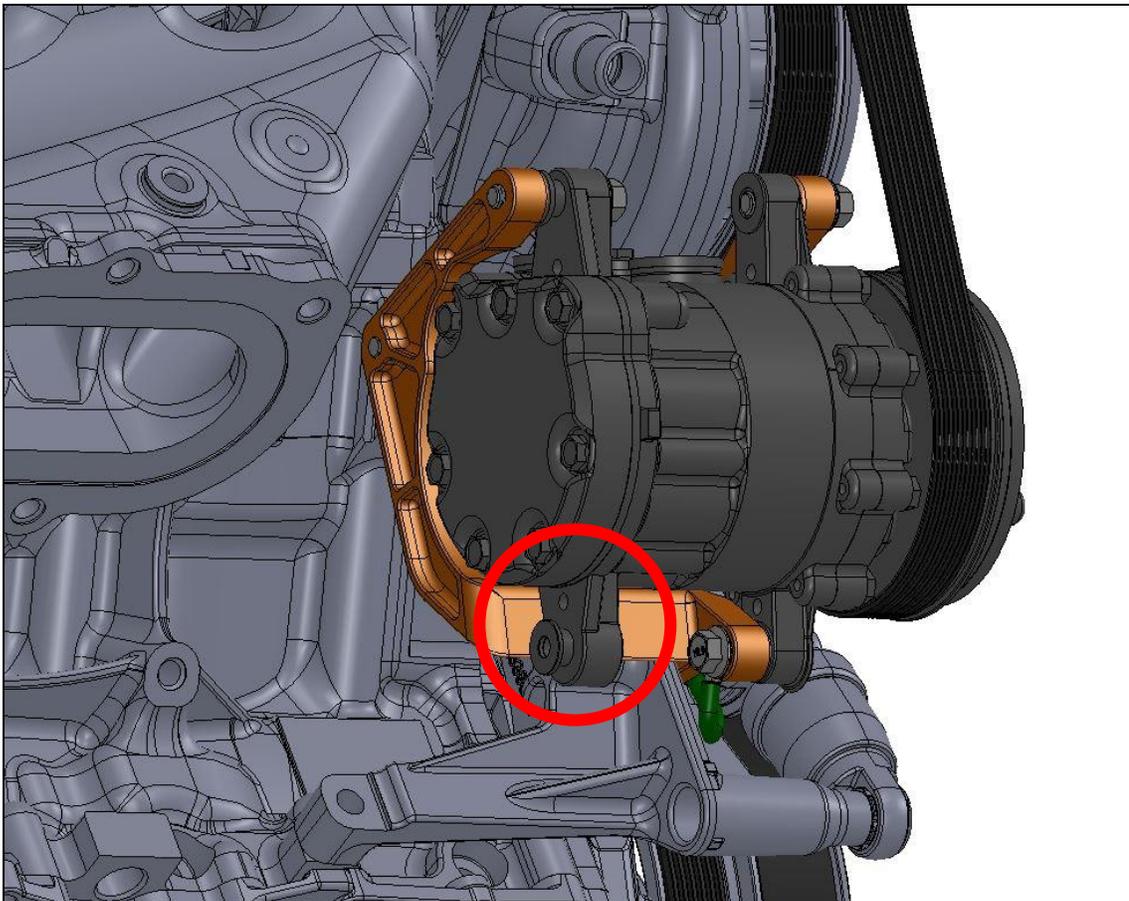


Figure 2: The DSE sub-frame version does not have the lower rear mounting ear for frame clearance. The corresponding mounting ear on the A/C compressor body may have to be trimmed away in certain applications.

2. Insert (x2) M8 x 1.25 x 30mm flange bolts into the front mounting ears on the bracket. The upper bolt will face rearward, go through the bracket, and thread into the compressor body. The lower bolt will face forward again going through the bracket and threading into the compressor body. See **Figure 3**. After all (x4) compressor bolts are hand tight, they can all be torqued to 18 ft-lbs.

WARNING: The A/C compressor is grounded through the compressor housing. The bracket is anodized aluminum and is electrically insulated. The included ground strap is intended to ground the lower front compressor bolt to the lower bracket mounting bolt, thus completing the path to ground. If using this included ground strap now is the time to connect it to the front lower compressor bolt as shown in **Figure 3**. If another grounding path is desired a minimum of 10 gauge wire must be used and it must be securely grounded or damage to the compressor could result.

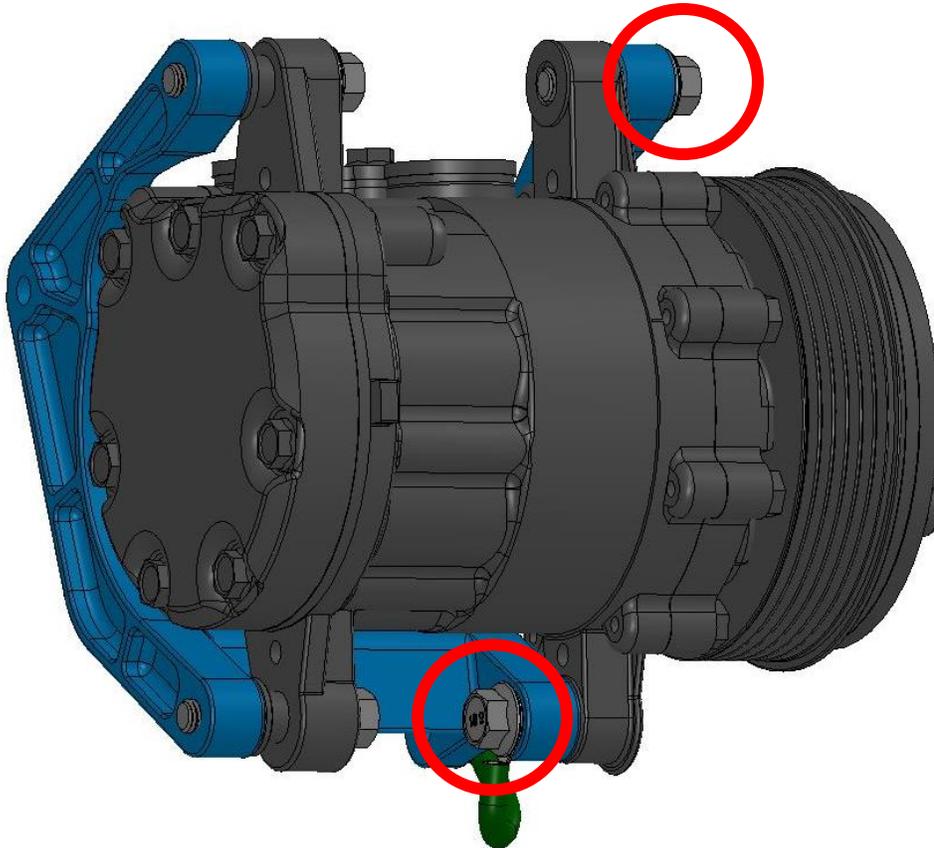


Figure 3: Front upper bolt faces rearward and front lower bolt faces forward. The grounding strap is installed between forward lower mounting ear and flange bolt as shown. **Torque all (x4) bolts to 18 ft-lbs.**

3. Install compressor/bracket assembly onto engine as shown in **Figure 4**. Insert M8 x 1.25 x 100mm flange bolt into upper mounting location. This bolt goes through the A/C bracket, tensioner bracket (GM P/N 12639512), and engine block. Hand tighten upper bolt. Insert M8 x 1.25 x 50mm flange bolt into lower mounting location on tensioner bracket (GM P/N 12639512). (This is the location for the other end of the ground strap. Install ring terminal as shown in **Figure 5**.) **Torque both bolts to 18 ft-lbs.**

(Helpful Hint: On factory A/C equipped engines, there may be a stud installed in the lower accessory mounting location. This can be reused or replaced with included 50mm long lower flange bolt.)

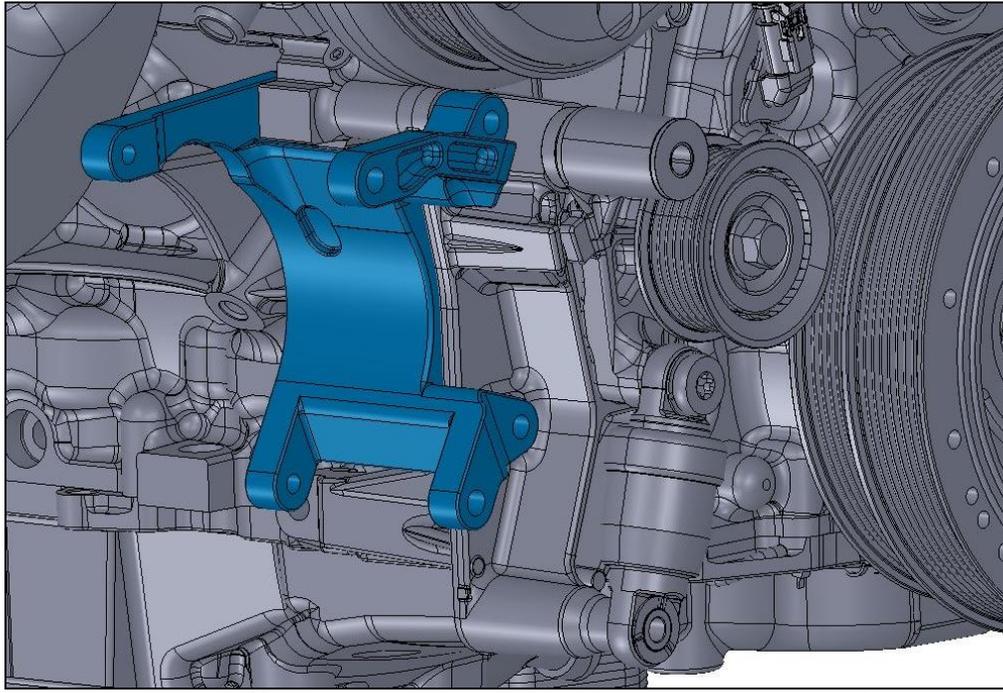


Figure 4: Previously installed A/C compressor and bolts are hidden for clarity of mounting location of the bracket to tensioner.

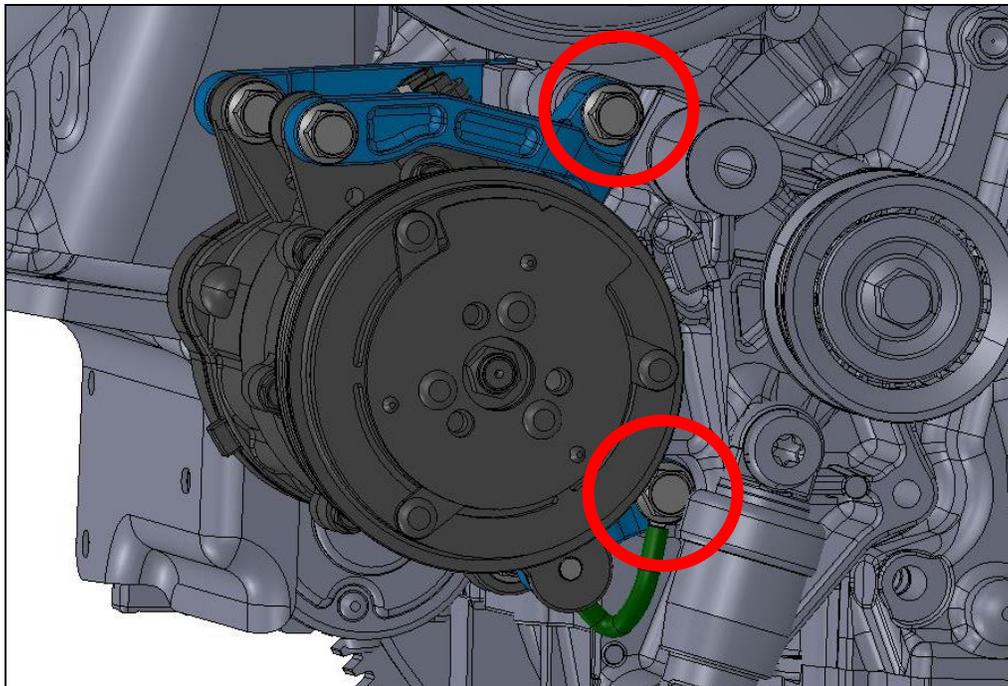


Figure 5: Upper bolt is an M8 x 1.25 x 100mm and lower bolt is M8 x 1.25 x 50mm. Ground strap is attached to lower mounting bolt as shown. Factory stud in lower mounting location if present can be reused or replaced with included flange bolt. **Torque both bolts to 18 ft-lbs.**

4. Install serpentine belt (GM P/N 12651112), routing it as shown in **Figure 6**. It is easiest to route the belt around all the accessories except the alternator. Apply a clockwise force to the bolt that holds the tensioner pulley on with a 15mm socket/wrench. When the appropriate amount of slack is achieved, slip the belt over the remaining alternator pulley and release the tensioner.

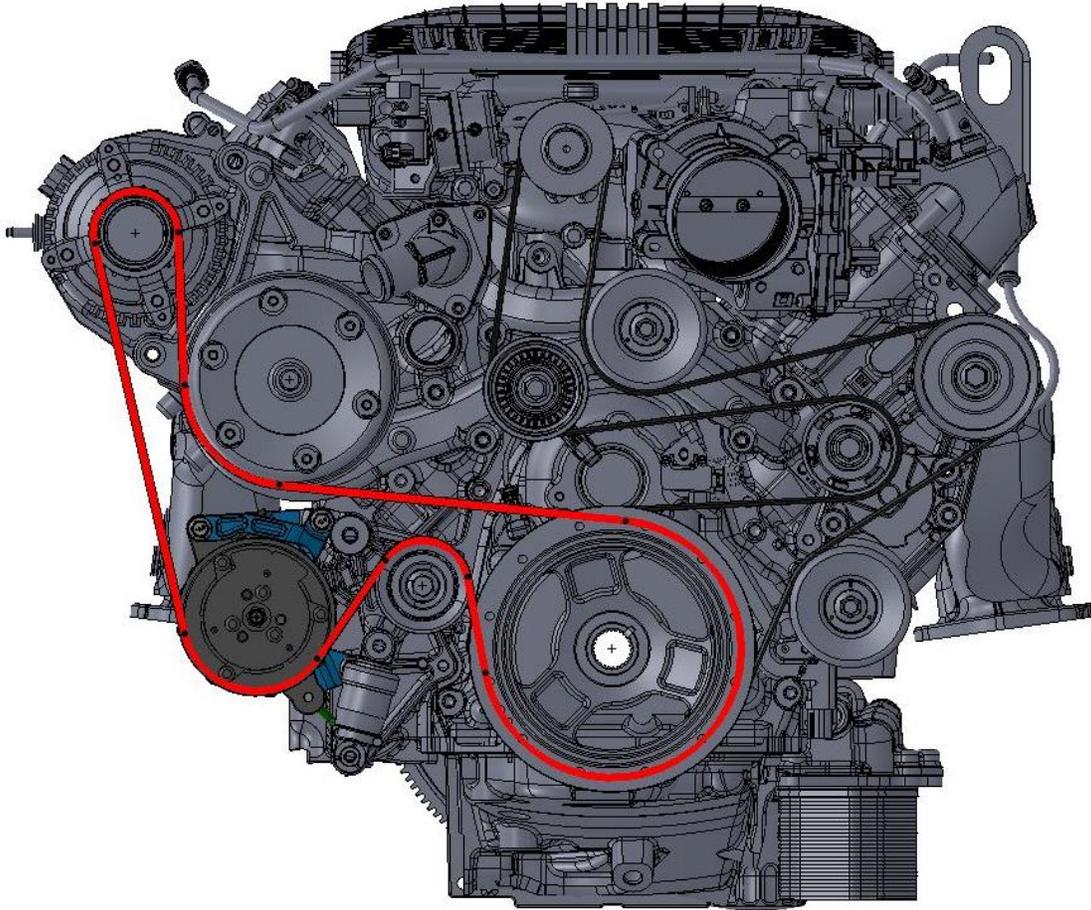
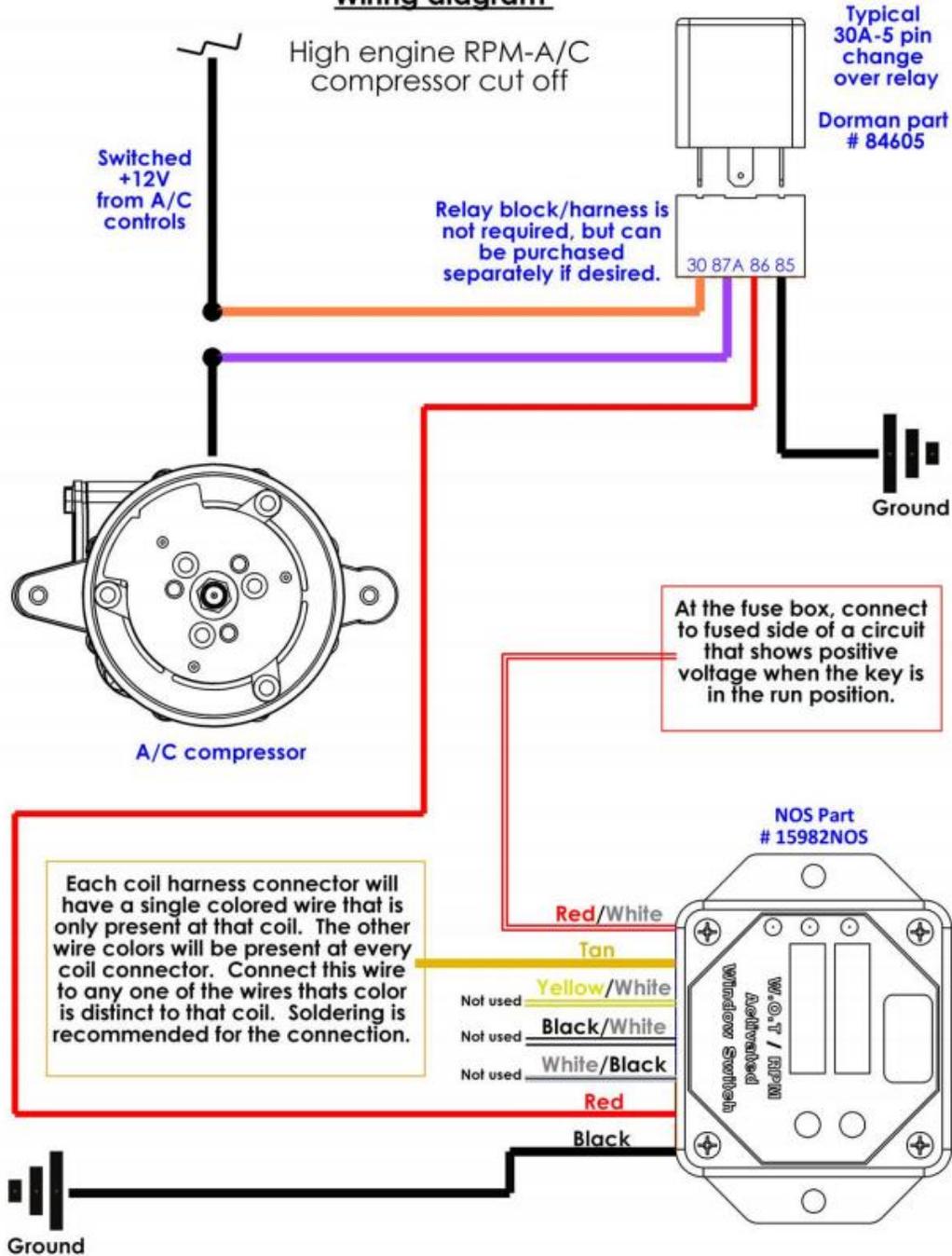


Figure 6: Belt Routing

WARNING: LT engines are capable of high RPMs that can damage A/C compressor's complex moving internal parts. A tach or TPS monitoring RPM switch, such as NOS part # 15982NOS (for wiring information, see diagram below), should be configured to deactivate the compressor clutch when the engine is above 4000 RPM.

Wiring diagram



After reviewing the components needed for your specific application, parts can be sourced and the Holley kits can be installed. See the included assembly instructions for installation procedures.

Holley Technical Support: 1-866-464-6553