

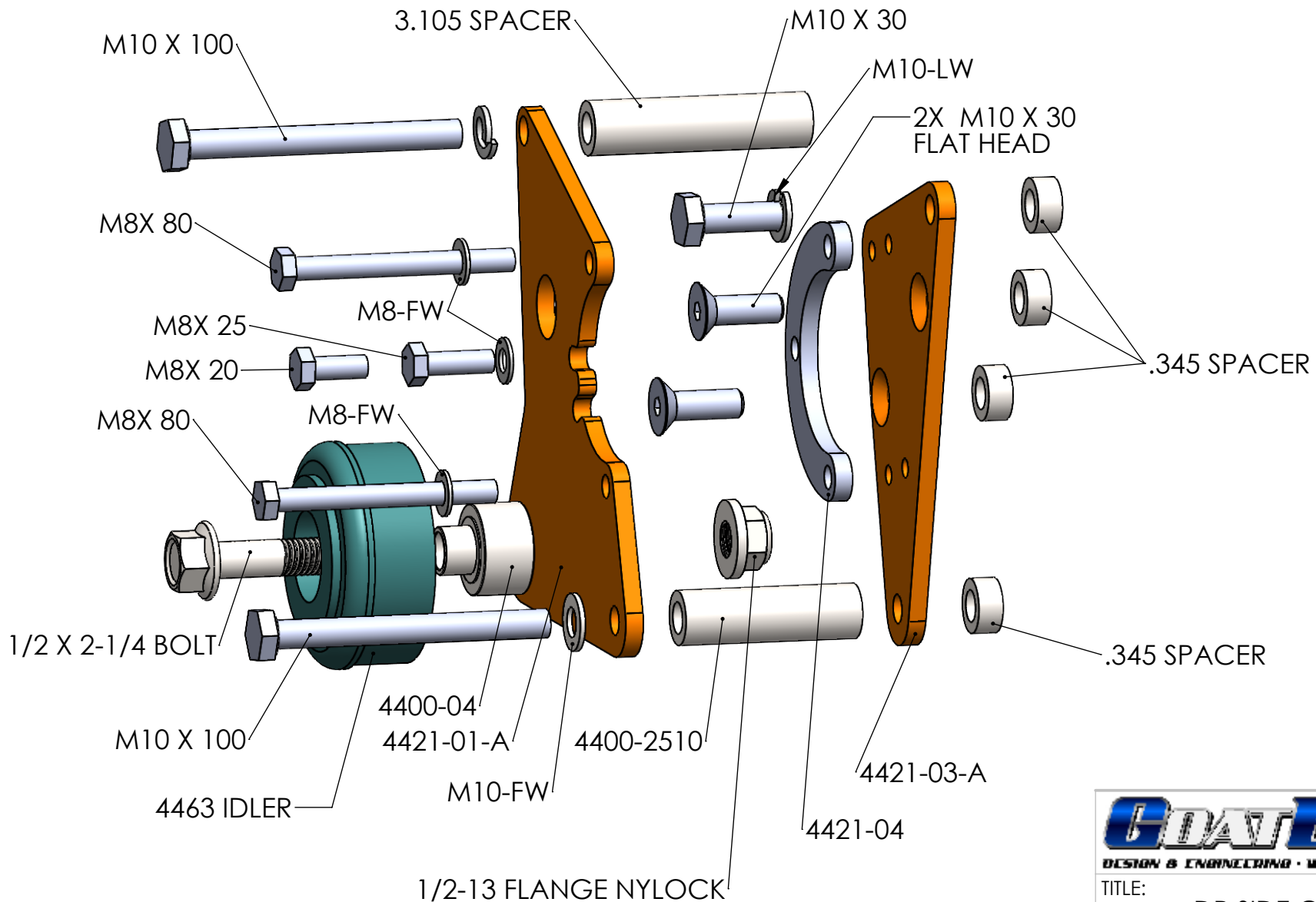


GOAT BUILT CBR/TC-PUMP RELOCATION BRACKET

Thank you for purchasing Goat Built components, before starting your installation, we recommend that you read through these instructions to familiarize yourself with the steps and parts so you can plan and prepare for your install accordingly.

A few notes about the 4422-F CBR/TC pump bracket:

- This bracket kit is intended for 99 -03 F-Body Camaro/Firebird pulley spacing including balancer, water pump, tensioner, and idler.
 - This kit fits a CBR or TC pump, this shim goes behind a CBR pump or in front of a TC pump
 - The aluminum LS1 blocks have a M10 hole tapped in the front of the block for the lower part of this bracket, if you have an iron block, you will need to drill and tap this hole.
1. Loosely install all the brackets, pump, and bolts before you fully tighten any of the bolts.
 2. Install the 4421-03 rear lower bracket to the head using the two M10 x 30 flat head allen head bolts and M10 x 30 bolt, lock washer with the three 1.095" spacers between the bracket and the head. Install the fourth .345 spacer with the M10 x 100 to hold it in place. Go ahead and tighten these bolts to 40 ft-lbs.
 3. Install the 4421-07 bracket to the head using the M10x100 bolt, lock washer and 3.105 spacer in the upper inner hole of the 4421-07 bracket. Install a M10 x 100 bolt with a 2.510 spacer in the lower outer hole of the 4421-07 thru the 4421-03 bracket, .345 spacer and into the block.
NOTE: The aluminum LS blocks have this M10 tapped hole on the front of the block, the iron truck blocks do not. If you are using a truck block you will have to drill and tap this M10 threaded hole.
 4. Install the pump using the 8mm bolts, use a flat washer under the bolt heads and blue Loctite on the threads. The 4421-06 shim normally goes behind a CBR pump or in front of a TC pump. Use the shorter M8 x 20 bolt if you are installing the shim on the back of the pump. Use the longer M8x25 bolt if you are installing the shim at the front of the pump. The pump has two clocking options. Use the M8 lock nuts on the back, but no washers, there is no room
 5. Torque the 10 MM bolts to 40 ft-lbs, 8 mm bolts to 15 ft-lbs
 6. Install the idler to the 4421-07 bracket using the 4400-04 spacer, 1/2" flange bolt and flange lock nut. Torque the idler nut to 70 ft-lbs



TITLE:
DR SIDE CBR/TC
PUMP BRACKET

SIZE	DWG. NO.
A	4422-F

SCALE: 1:1	WEIGHT:	SHEET 1 OF 3
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1

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	4421-07	LS ALT PS BRACKET, FRONT PLATE	1
2	4421-03-A	LS ALT PS BRACET, REAR PUMP PLATE	1
3	4421-04	LS ALT PS BRACKET, PUMP SHIM	1
4	M8X 80	M8 X 80 BOLT	2
5	M8X 25	M8 X 25 BOLT	1
6	M8X 20	M8 X 20 BOLT	1
7	M8-FW	M8-FLAT WASHER	3
8	M10 X 100	M10 X 100 BOLT	2
9	M10 X 30	M10 X 30 BOLT	1
10	M10 X 30 FH	M10 X 30 FLAT HEAD ALLEN BOLT	2
11	M10-FW	M10-FLAT WASHER	1
12	M10-LW	M10-LW	2
13	4400-0345	.345 SPACER	4
14	4400-2510	2.510 SPACER	1
15	4400-3105	3.105 SPACER	1
16	1-2 X 2-1-4 FB	1/2 X 2-1/4 IDLER FLANGE BOLT	1
17	1-2-13FLN	1/2-13 IDLER NUT	1
18	4400-04	IDLER SPACER, .73"	1
19	4463-IDLER	89007 IDLER PULLEY	1



TITLE:

DR SIDE CBR/TC
PUMP BRACKET

SIZE DWG. NO.

A

4422-F

SCALE: 1:1

WEIGHT:

SHEET 2 OF 3

M10 X 100 BOLT
M10 LOCK WASHER
3.105 SPACER
INTO HEAD

M8 X 80
FLAT WASHER

M10 X 30 BOLT
LOCK WASHER
.345 SPACER
INTO HEAD

M8 X 25 BOLT FOR
TC PUMP WITH SHIM
IN FRONT OF PUMP
OR
M8 X 20 BOLT FOR
CBR PUMP WITH SHIM
BEHIND PUMP

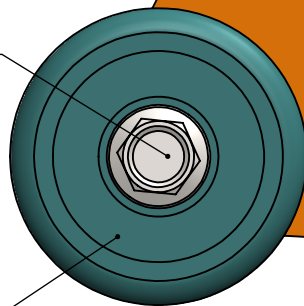
2X M10 X 30 FLAT HEAD BOLT
.345 SPACER
INTO HEAD

M8 X 80
FLAT WASHER

1/2 BOLT
IDLER SPACER
1/2 NYLOCK

M10 X 100 BOLT
M10 FLAT WASHER
2.510 SPACER
.345 SPACER
INTO BLOCK

DAYCO 89007
76 MM PULLEY



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TITLE:

DR SIDE CBR/TC
PUMP BRACKET

SIZE DWG. NO.

A

4422-F

SCALE: 1:1

WEIGHT:

SHEET 3 OF 3