Holley Accessory Drive System
Part Number 20-137

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**Introduction:**

Holley's accessory drive systems offer clean, economical brackets and accessories for LS engines. These accessory drives look truly at home on any LS engine as if they came from the factory this way.

Holley's complete accessory drive systems come with virtually everything needed for installation, from the accessories to the pulleys and even the belt.

The first step is to determine which belt alignment you want to proceed with. This is determined by the crank pulley and often, but not always, the water pump. If clearance to the radiator is an issue, the compact STANDARD spacing common on the Corvette may be preferred. Otherwise, it is most cost effective to retain the existing crank pulley/water pump and space the bracket and other accessories to match. **An application specific installation kit (part # 21-1, 21-2, or 21-3) is REQUIRED for this accessory drive system.**
Crank Pulley Belt Alignment Determination:

See the below chart for reference dimensions.

Overview of Parts Required (but NOT included with 20-137 accessory drive system):

<table>
<thead>
<tr>
<th>Belt Alignment Group</th>
<th>LS Application (Alignment Specific)</th>
<th>Holley Installation Kit (Alignment Specific)</th>
<th>Crank Pulley (Reference Dimension)</th>
<th>Water Pump (Alignment Specific)</th>
<th>GM #</th>
</tr>
</thead>
<tbody>
<tr>
<td>Standard</td>
<td>Corvette / CTS-V / G8</td>
<td>21-1</td>
<td>1.5”</td>
<td>37 MM</td>
<td>19256263, 89018052, or 12604630</td>
</tr>
<tr>
<td>Middle</td>
<td>F-body / GTO</td>
<td>21-2</td>
<td>2.25”</td>
<td>55 MM</td>
<td>19256263</td>
</tr>
<tr>
<td>Long</td>
<td>Camaro ('10-UP) / Truck (all)</td>
<td>21-3</td>
<td>3”</td>
<td>75 MM</td>
<td>19207665 or any truck WP</td>
</tr>
</tbody>
</table>
**Water Pump Determination:**

To determine which water pump type you have, refer to the following illustrations:

**LS1/LS2/LS6 Wide Pulley Water Pump**
Works with **STANDARD** and **MIDDLE** belt spacings

- GM P/N 19256263
- '97-'04 Corvette
- '04-'05 CTS-V
- '98-'02 Camaro/Firebird
- '04-'06 GTO

**Identifying feature:** Wide pulley allowing for both standard and middle belt spacings

This round boss may not be present on this water pump

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**LS2 Specific Water Pump**
Works with **STANDARD** belt spacing

- GM P/N 89018052
- '05-'07 Corvette
- '06-'07 CTS-V

**Identifying features:** Narrow pulley and passenger's side outlet

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**TYPE 1**

**TYPE 2**
LS3 Corvette/G8 water pump
Works with STANDARD belt spacing
GM P/N 12604630
'08-UP Corvette
'08-'09 G8

Bracket Bolt Access
Either the water pump will need to be installed after the bracket or the area in red will need to be removed for bracket/spacer access. Remove the material so the boss shape is similar to that of the boss on water pump TYPE 1, 2, or 5. Otherwise, the bolt will not pass by the boss.

Belt Interference
1/8" may need to be removed from these bosses if this water pump is used.

Identifying feature:
Driver's side outlet

LS3/L99 Camaro water pump
Works with LONG belt spacing
GM P/N 19207665
'10-UP Camaro

Identifying feature:
Long tensioner Bosses

TYPE 3

TYPE 4
TRUCK water pump
Works with LONG belt spacing

GM P/N (Numerous)
All truck LS based engines

Identifying feature:
Upward pointing inlet

TYPE 5
Parts List:

This accessory drive system requires application specific installation kit part # 21-1, 21-2, or 21-3

Parts included with 20-137 accessory drive system (see list supplied with installation kit for additional parts):

<table>
<thead>
<tr>
<th>PICTURE</th>
<th>QTY</th>
<th>DESCRIPTION</th>
<th>APPLICATION</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>1</td>
<td>Alternator (P/N 197-301)</td>
<td>Driver’s Side Bracket</td>
</tr>
<tr>
<td></td>
<td>1</td>
<td>P/S Pump (P/N 198-100)</td>
<td>Driver’s Side Bracket</td>
</tr>
<tr>
<td></td>
<td>1</td>
<td>SD508 A/C Compressor (P/N 199-101)</td>
<td>Passenger’s Side Bracket</td>
</tr>
<tr>
<td></td>
<td>1</td>
<td>Belt Tensioner with Bolt (P/N 97-151)</td>
<td>Passenger’s Side Bracket</td>
</tr>
<tr>
<td></td>
<td>2</td>
<td>Smooth Idler Pulley (P/N 97-150)</td>
<td>Driver’s &amp; Passenger’s Side Brackets</td>
</tr>
<tr>
<td></td>
<td>1</td>
<td>Ribbed Idler Pulley, 68mm</td>
<td>Passenger’s Side Bracket</td>
</tr>
<tr>
<td></td>
<td>1</td>
<td>Pigtail (P/N 197-400)</td>
<td>Alternator</td>
</tr>
<tr>
<td></td>
<td>1</td>
<td>Ribbed Pulley (P/N 97-152)</td>
<td>P/S Pump</td>
</tr>
<tr>
<td></td>
<td>1</td>
<td>Belt, 6 Rib Serpentine</td>
<td>Driver’s &amp; Passenger’s Side Brackets</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>---</td>
<td>---</td>
<td>---</td>
<td></td>
</tr>
<tr>
<td>1</td>
<td>Driver’s Side Bracket Assembly</td>
<td>Alternator &amp; Power Steering Pump</td>
<td></td>
</tr>
<tr>
<td>1</td>
<td>Passenger’s Side Bracket Assembly</td>
<td>A/C Compressor &amp; Tensioner</td>
<td></td>
</tr>
<tr>
<td>1</td>
<td>Power Steering Pump Plate Bracket</td>
<td>Front Support of Power Steering Pump</td>
<td></td>
</tr>
<tr>
<td>1</td>
<td>Step Spacer</td>
<td>Driver’s Side Idler Pulley</td>
<td></td>
</tr>
<tr>
<td>1</td>
<td>Socket Head Cap Bolt, M10 x 1.5 x 30</td>
<td>Spacer to Passenger’s Side Head</td>
<td></td>
</tr>
<tr>
<td>2</td>
<td>Socket Head Cap Bolt, M10 x 1.5 x 80</td>
<td>Alternator Bolts</td>
<td></td>
</tr>
<tr>
<td>2</td>
<td>Flange Head Bolt, M8 x 1.25 x 20</td>
<td>Power Steering Pump Bolts</td>
<td></td>
</tr>
<tr>
<td>2</td>
<td>Flange Head Bolt, M8 x 1.25 x 80</td>
<td>Power Steering Pump Bolts</td>
<td></td>
</tr>
<tr>
<td>3</td>
<td>Flange Head Bolt, M8 x 1.25 x 35</td>
<td>Passenger’s Side Bracket to Spacer</td>
<td></td>
</tr>
<tr>
<td>2</td>
<td>Flange Head Bolt, M10 x 1.5 x 35</td>
<td>Tensioner Assembly to Passenger’s Side Bracket</td>
<td></td>
</tr>
<tr>
<td>1</td>
<td>Flange Head Bolt, M10 x 1.5 x 35</td>
<td>Idler Pulley to Passenger’s Side Bracket</td>
<td></td>
</tr>
<tr>
<td>1</td>
<td>Flange Head Bolt, M10 x 1.5 x 45</td>
<td>Idler Pulley to Driver’s Side Bracket</td>
<td></td>
</tr>
<tr>
<td>3</td>
<td>Flange Head Bolt, M8 x 1.25 x 125</td>
<td>A/C Compressor Bolts</td>
<td></td>
</tr>
<tr>
<td>3</td>
<td>M10 to M8 Sleeve</td>
<td>A/C Compressor Front Mounting Ears</td>
<td></td>
</tr>
<tr>
<td>3</td>
<td>M8 Steel Spacer</td>
<td>Bracket to Rear A/C Compressor Ears</td>
<td></td>
</tr>
<tr>
<td>3</td>
<td>M8 Flange Bushing</td>
<td>Rear A/C Compressor Ears</td>
<td></td>
</tr>
<tr>
<td>3</td>
<td>Locking Nut, M8 x 1.25</td>
<td>Rear A/C Compressor Bolts</td>
<td></td>
</tr>
</tbody>
</table>
Assembly Instructions

Driver’s Side Bracket Installation:

NOTE: Torque M8 bolts to 18 ft./lbs. and M10 bolts to 36 ft./lbs.
Power Steering Pump Installation:

NOTE: Torque M8 bolts to 18 ft./lbs. and M10 bolts to 36 ft./lbs.
Idler Pulley Installation (position options):

NOTE: Torque M8 bolts to 18 ft./lbs. and M10 bolts to 36 ft./lbs.

Two idler pulley location options are offered. The belt length difference is 1/2" between the two. This is to help with belt fitment. Start in position A.

B Shorter belt

(START HERE) A Longer belt

NOTE: Torque M8 bolts to 18 ft./lbs. and M10 bolts to 36 ft./lbs.
Power Steering Pump Pulleys:

There are several pulleys that will fit the pump, but some do not have the correct belt alignment for this application. See applicable service manual for pulley installation procedures.

Small Diameter Pulley:

Power steering pulleys may interfere with the suspension A-arm in certain swap applications. Choosing a smaller pulley in these situations can give additional clearance.

<table>
<thead>
<tr>
<th>Belt Alignment Group</th>
<th>LS Application (Alignment Specific)</th>
<th>Balancer (25% under-drive)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Standard</td>
<td>Corvette/CTS-V/G8</td>
<td>PBU1117SS25</td>
</tr>
<tr>
<td>Middle</td>
<td>F-body/GTO</td>
<td>PBU1480SS25</td>
</tr>
<tr>
<td>Long</td>
<td>Camaro (*10-UP)/ Truck (all)</td>
<td>PBU1190SS25</td>
</tr>
</tbody>
</table>

WARNING! Smaller power steering pulleys, such as a 97-154 can rotate the pump beyond recommended RPMs. To correct this, a 25% under-dive balancer should be used if choosing a pump pulley smaller than 6” OD.

Helpful Hint: If any of these smaller pulleys are used, the supplied belt will not work and a shorter size will have to be purchased at an auto parts store.
**P/S Pulley & Alternator Installation:**

**NOTE:** Torque M8 bolts to 18 ft./lbs. and M10 bolts to 36 ft./lbs.

The P/S pulley must be installed using an installation tool that can be rented at most auto parts stores. Incorrect installation of this pulley may damage the P/S pump internals. When installed, the pulley bore face should be flush with the end of the pump shaft.

**Helpful hint:** Open faced pulley part 97-152 (included) can be installed onto pump before bracket assembly as bolts can be accessed through pulley windows.

**Helpful hint:** When wiring the alternator, install the included 197-400 plug into the alternator. Next connect the yellow wire to switched voltage that is “on” when the key is in the run position. If the vehicle has a “charge indicator light” the yellow wire can be connected to that circuit.
Passenger’s Side Bracket Installation:

If the EVAP solenoid is located on the front of the passenger’s side head, it will need to be relocated when using this A/C compressor bracket.

Parts pictured may vary slightly depending on the installation kit’s intended application.

NOTE: Torque M8 bolts to 18 ft./lbs. and M10 bolts to 36 ft./lbs.

This spacer is not supplied with the bracket, but is required for installation on all applications. This spacer is supplied in the installation kit 21-1, 21-2, and 21-3.

Align spacer cosmetically to the bracket before tightening the bolts.

NOTE: Torque M8 bolts to 18 ft./lbs. and M10 bolts to 36 ft./lbs.
Idler & Tensioner Installation:

NOTE: Torque M8 bolts to 18 ft./lbs. and M10 bolts to 36 ft./lbs.
A/C Compressor Installation:

- Steel M8 spacer
- Sleeve (adapts compressor ear from M10 to M8 hole)
- M8 x 125 flange head
- Assembly shown is times three (3) places.
- View is from under bracket, looking up.

NOTE: Torque M8 bolts to 18 ft./lbs.
**Belt Routing:**

**HELPFUL HINT:** When installing the belt, route around all the pulleys except the water pump pulley. While fully rotating the tensioner arm, slip the belt on the smooth water pump pulley last.

Use serpentine belt supplied if using ALL Holley accessories and supplemental parts.

**NOTE:** If you are NOT using all the Holley accessories supplied, or have changed the original crank or any accessory’s pulleys, you will have to measure to find the correct belt length.

To acquire this measurement, perform the following:
After all brackets and accessories are installed, route masking tape or string around the belt path. Leave the tensioner in the un-sprung position for this measurement. Mark or cut the tape/string to length and remove from the pulleys. Subtract 1 1/8” (28 mm) from the measured length to compensate for the un-sprung tensioner position. You will need to convert belt length to millimeters if measured in inches (inches X 25.4 = mm). Go to any auto parts store and ask for a 6PK0000 belt with the “0000” being the length in millimeters. For example, if you measured 2493 mm and then subtracted 28 mm, you would get 2465 mm, and the part number would be 6PK2465. Remember, if you miss on size, the driver’s side idler can be moved to decrease the required belt length by 1/2”.
**Power Steering Pump Reservoir Options:**

The Holley driver's side bracket works with reservoirs found on '97-up Corvettes. Other remote reservoirs can be custom fitted with this bracket as well. All the below reservoir parts are included in Holley kit # 198-200.