

NOTE: FLAG ITEMS ▶  
REFER TO INSTRUCTION DRAWINGS

ITEM NO.	PART NUMBER	DESCRIPTION	
1	MFG21031	LS1/LS2 12v Alternator Relocation RH	1
2	MFC1819-LS2VE	Power Steering Reservoir Bracket - LS2/3 VE - VF	1
3	UBH16 - 300 x 500N	90° 16 x 300 x 500 Universal Hose Bend - Fuel & Oil	1
4	MFC651	Spacer 10 x 20 x 51 L P/ST	2
5	6PK2205	Drive Belt - Poly Rib (2205mm)	1
6	16-25-9W2	Hose Clamp - 16 to 25mm	2
7	BT-2270	BOLT - M10 X 1.5 X 80mm - H/T - Z/P	2
8	FW-2010	Flat Washer - M10 x 22 x 2mm	3
9	SW-2005	Spring Washer - M10 - S/S	2
10	MFC21007	VE Power Steering Pump Hose Barb	1
11	SHCS-2125	SHCS - M6 x 1 x 12mm - SS	1

**INSTRUCTION DRAWINGS**

**MFK50180-VZ-SHT-1**  
**MFK50180-VZ-SHT-2**

**1: MFG21031**

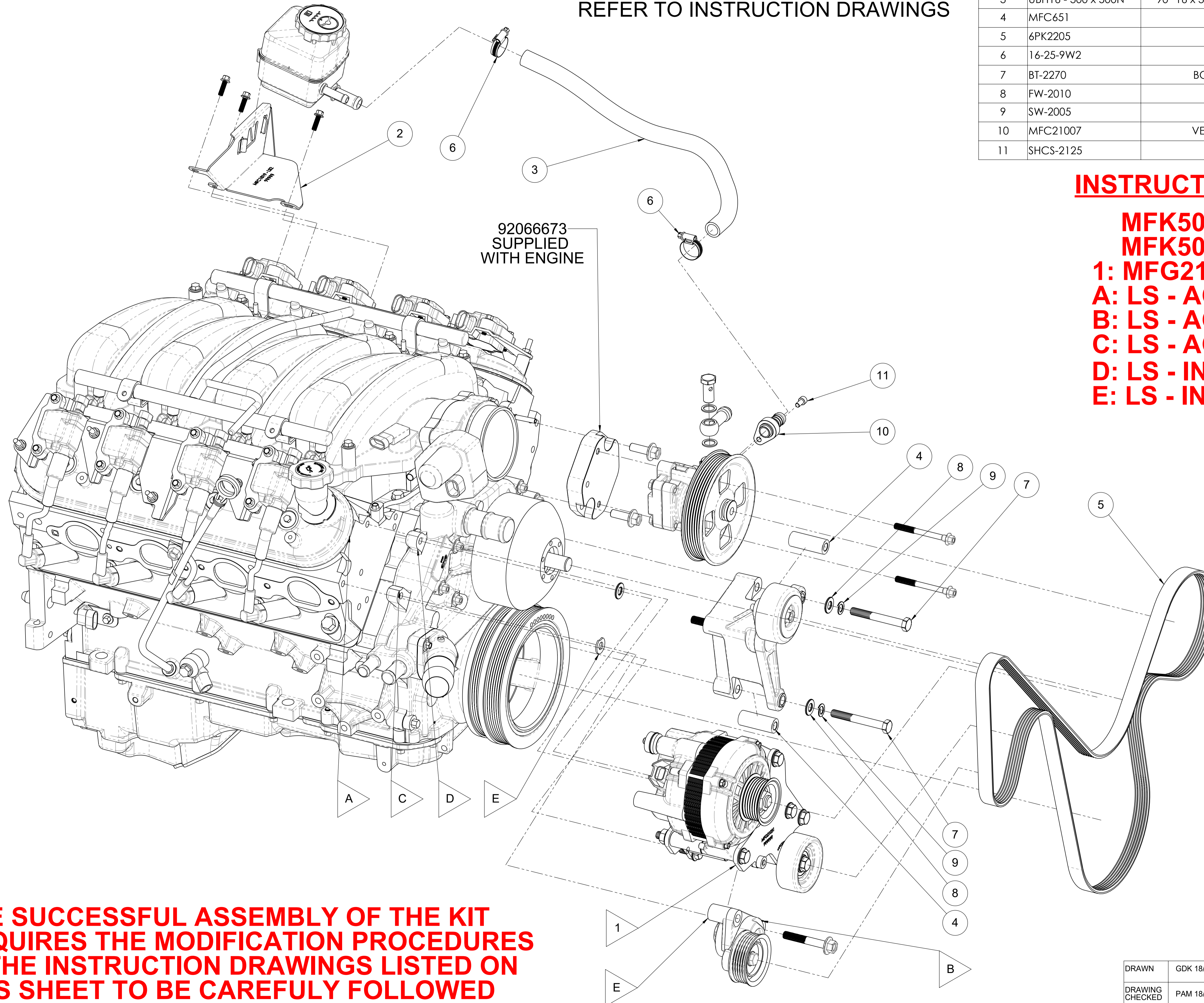
**A: LS - ACCMOD - 01**

**B: LS - ACCMOD - 10**

**C: LS - ACCMOD - 11**

**D: LS - INFO - 02**

**E: LS - INFO - 06**

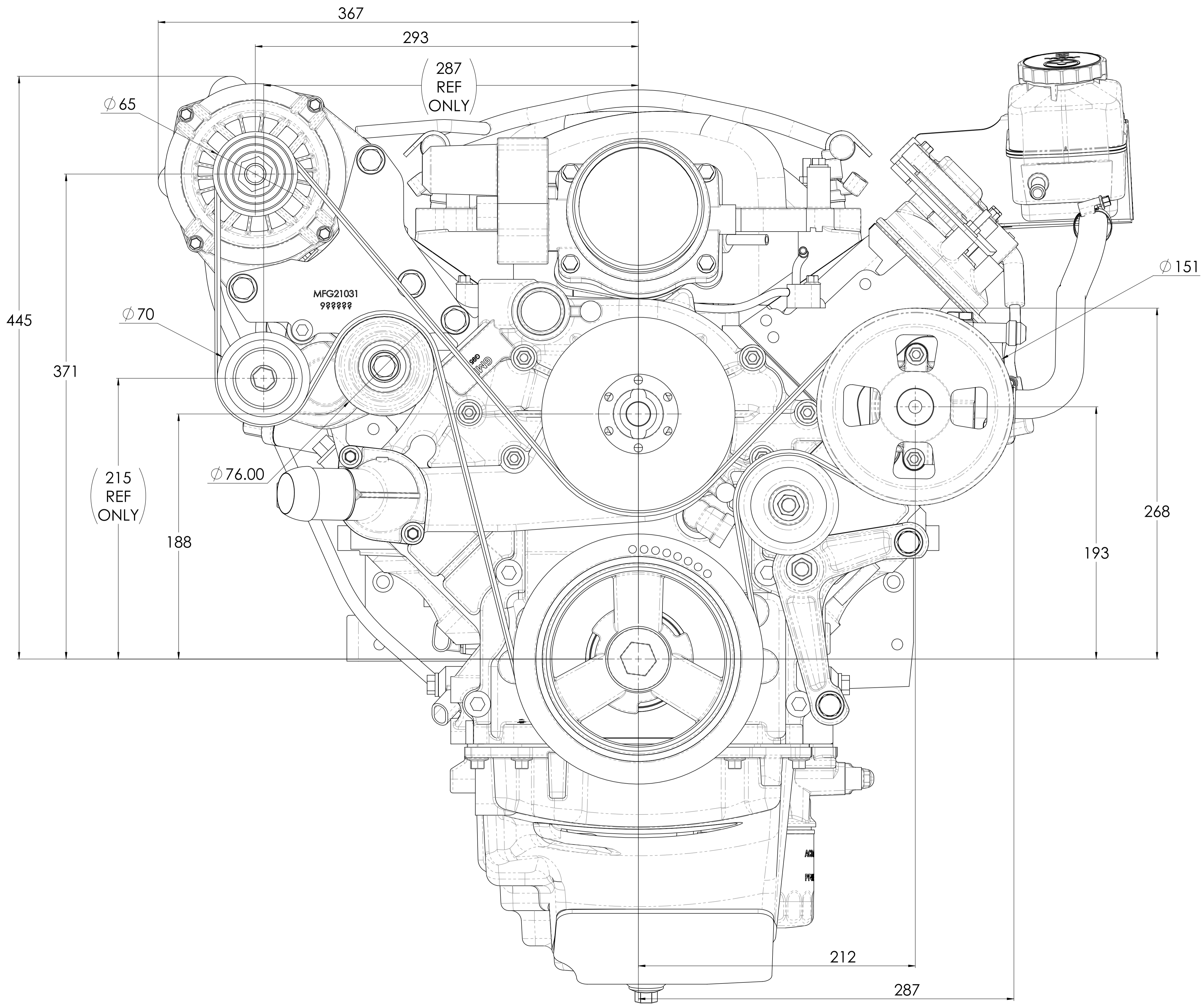


92066673  
SUPPLIED  
WITH ENGINE

**THE SUCCESSFUL ASSEMBLY OF THE KIT  
REQUIRES THE MODIFICATION PROCEDURES  
IN THE INSTRUCTION DRAWINGS LISTED ON  
THIS SHEET TO BE CAREFULLY FOLLOWED**

DRAWN	GDK 18/08/2021	TITLE:	Accessory Kit - RH 12v Alt
DRAWING CHECKED	PAM 18/08/2021	SCALE: 1:2.5	DRAWING/PART NUMBER
FINISHED WEIGHT: kg		DRAWING 1 of 2	MFK50185-VZ
			REV No. 0






 365-393 LOWER DANDENONG ROAD,  
 DINGLEY, VICTORIA, 3172  
 A.B.N. 28 153 842 829

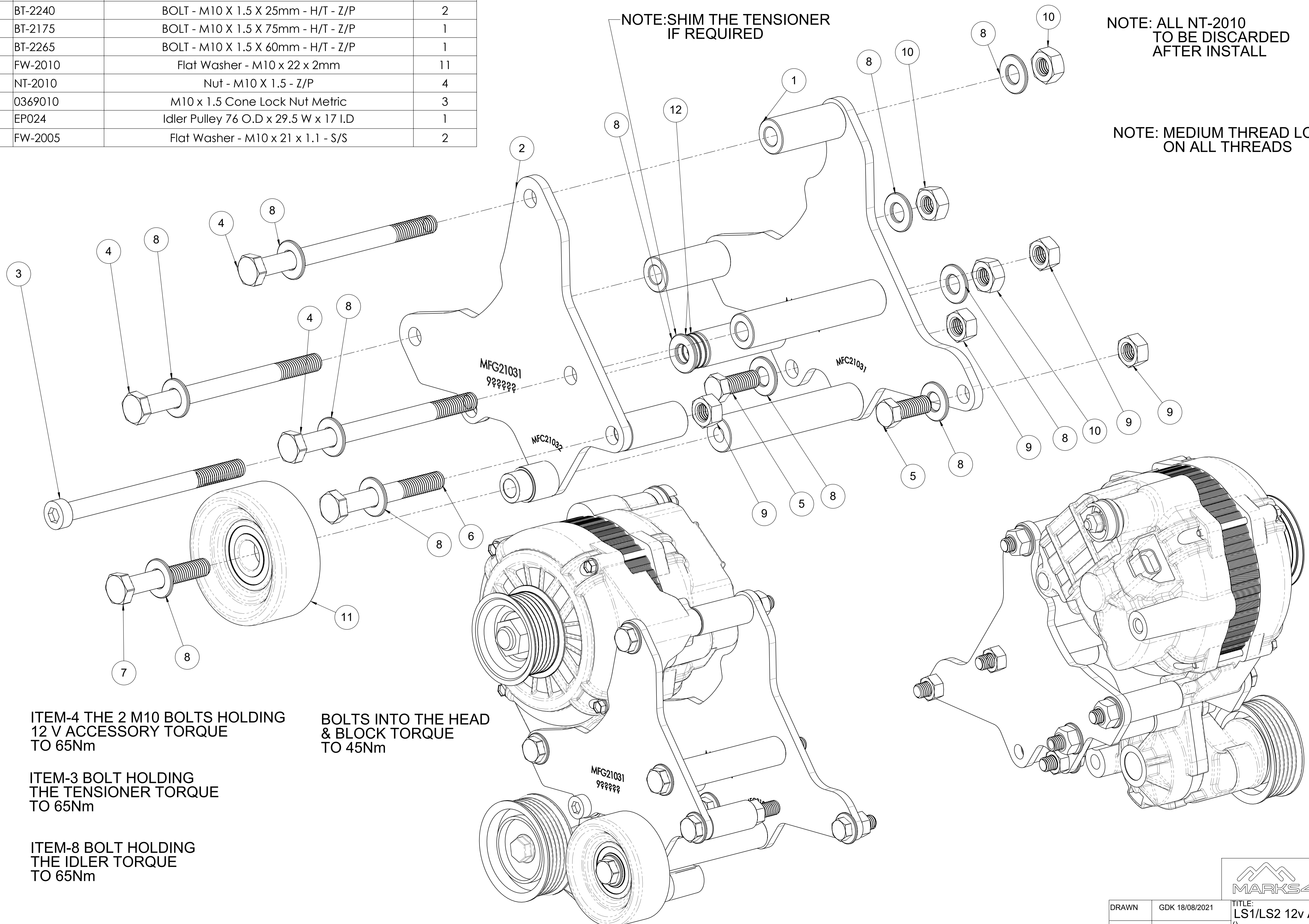
DRAWN	GDK 18/08/2021	TITLE:		
DRAWING CHECKED	PAM 18/08/2021	( )	Accessory Kit - RH 12v Alt	
FINISHED WEIGHT: kg		SCALE: 1:1.5	DRAWING/PART NUMBER	REV No.
		DRAWING 2 of 2	MFK50185-VZ	0

ITEM NO.	PART NUMBER	DESCRIPTION	QTY
1	MFC21031	LS1/LS2 12v Alternator Relocation Base Plate RH	1
2	MFC21032	LS1/LS2 12v Alternator Relocation Front Plate RH	1
3	MFC21030	SHCS M10 x 1.5 x 130 - Low Head	1
4	BT-2282	BOLT - M10 X 1.5 X 130mm - H/T - Z/P	3
5	BT-2240	BOLT - M10 X 1.5 X 25mm - H/T - Z/P	2
6	BT-2175	BOLT - M10 X 1.5 X 75mm - H/T - Z/P	1
7	BT-2265	BOLT - M10 X 1.5 X 60mm - H/T - Z/P	1
8	FW-2010	Flat Washer - M10 x 22 x 2mm	11
9	NT-2010	Nut - M10 X 1.5 - Z/P	4
10	0369010	M10 x 1.5 Cone Lock Nut Metric	3
11	EPO24	Idler Pulley 76 O.D x 29.5 W x 17 I.D	1
12	FW-2005	Flat Washer - M10 x 21 x 1.1 - S/S	2

NOTE: SHIM THE TENSIONER IF REQUIRED

NOTE: ALL NT-2010 TO BE DISCARDED AFTER INSTALL

NOTE: MEDIUM THREAD LOCK ON ALL THREADS



ITEM-4 THE 2 M10 BOLTS HOLDING 12 V ACCESSORY TORQUE TO 65Nm

BOLTS INTO THE HEAD & BLOCK TORQUE TO 45Nm

ITEM-3 BOLT HOLDING THE TENSIONER TORQUE TO 65Nm

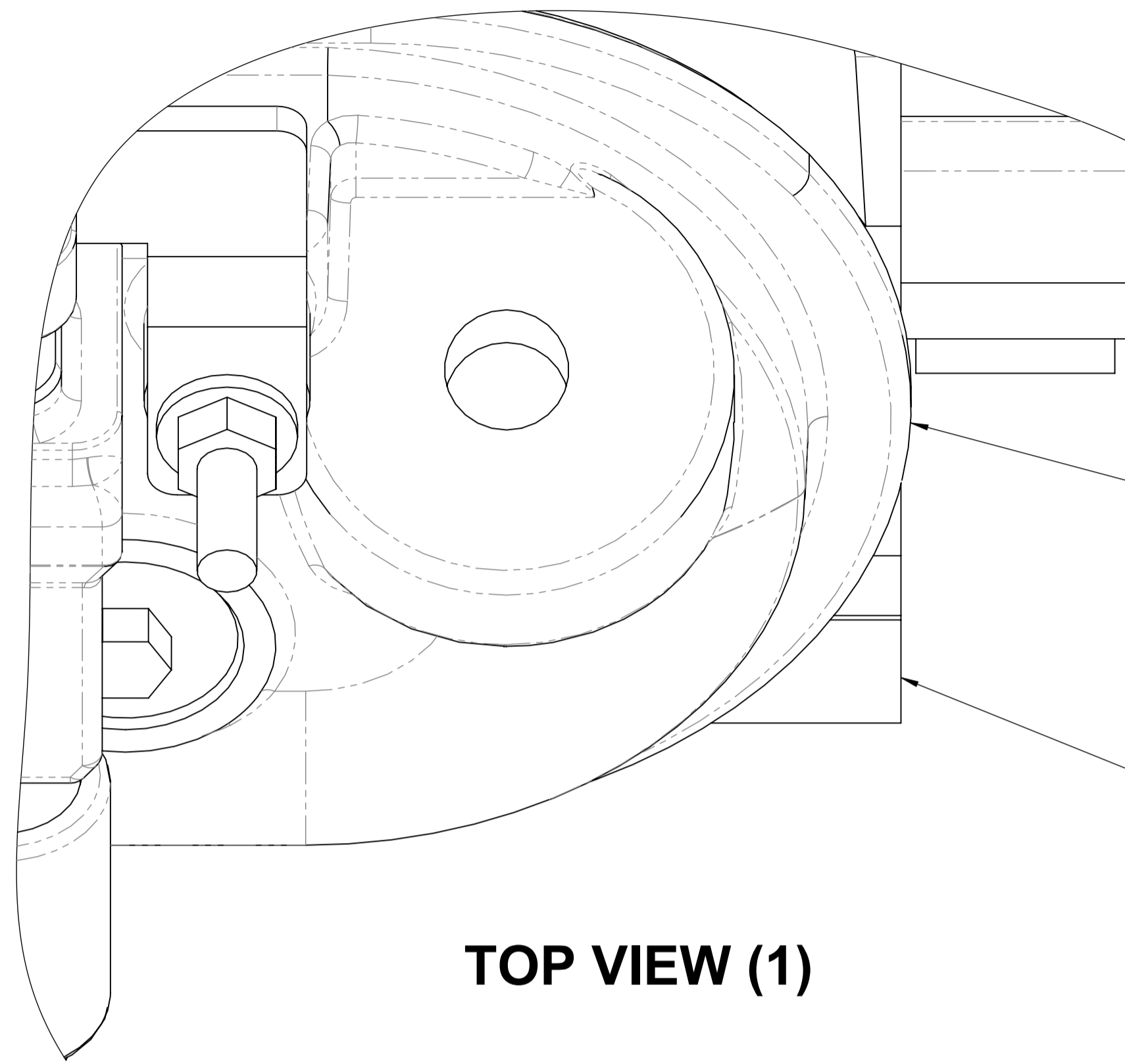
ITEM-8 BOLT HOLDING THE IDLER TORQUE TO 65Nm



DRAWN	GDK 18/08/2021	TITLE:	LS1/LS2 12v Alternator Relocation RH	
DRAWING CHECKED	PAM 18/08/2021	SCALE: 1:1	DRAWING/PART NUMBER	REV No.
FINISHED WEIGHT: kg		DRAWING 5 of 10	MFG21031	0

# LS - SERIES ROCKER COVER LIP MODIFICATION

## STANDARD ROCKER COVER



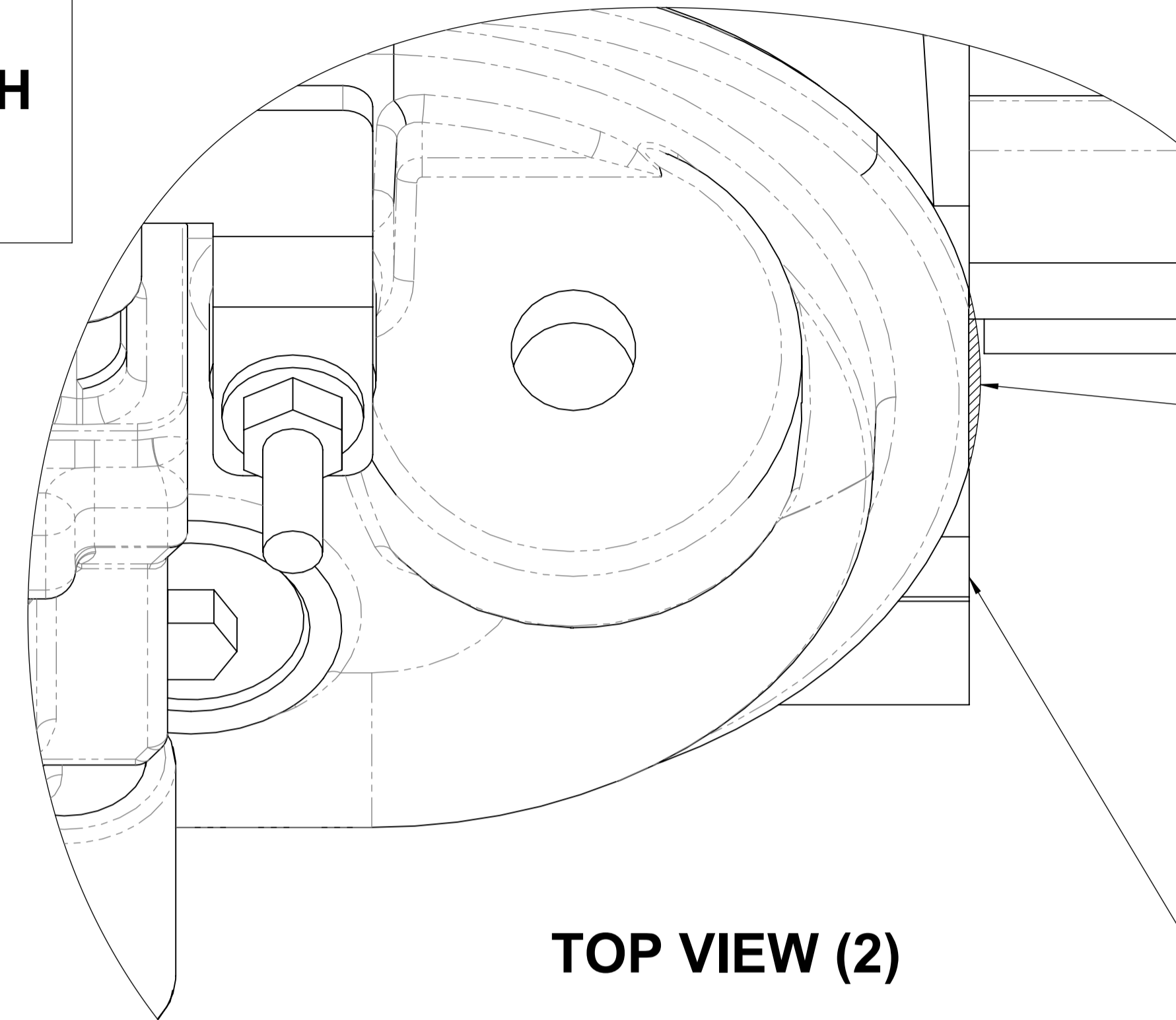
TOP VIEW (1)

THE LIP MODIFICATION SHOWS THE DRIVER SIDE CYLINDER HEAD FITTED WITH THE PASSENGER SIDE ROCKER COVER

PASSENGER SIDE ROCKER COVER LIP SITS ABOVE THE CYLINDER HEAD

DRIVER SIDE CYLINDER HEAD FACE SHOWN

## MODIFIED ROCKER COVER



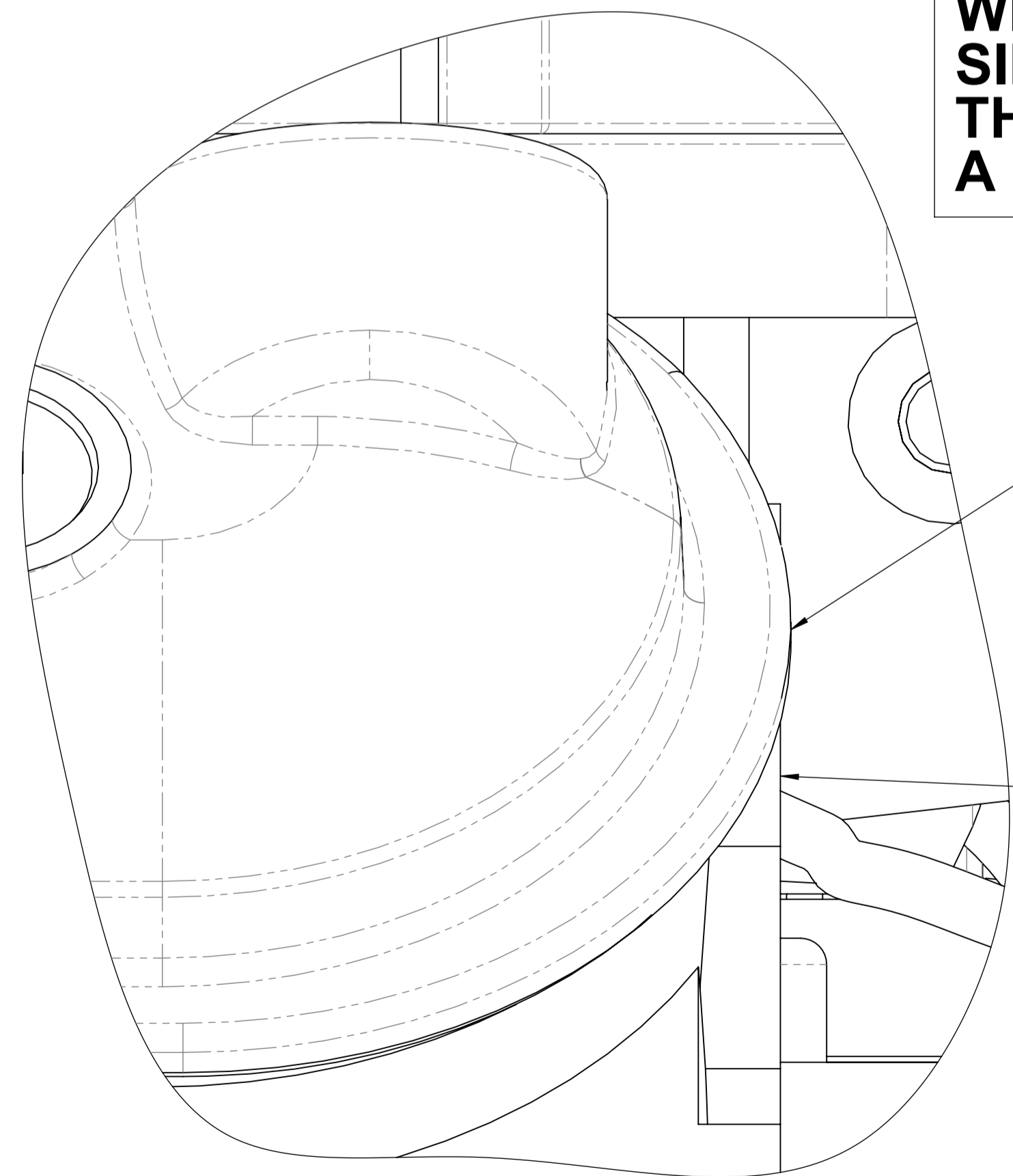
TOP VIEW (2)

DRIVER SIDE ROCKER COVER LIP REMOVE THE HATCHED AREA AS SHOWN

SHAVED ROCKER LIP SHOULD LOOK LIKE THE SIDE VIEW (2) BELOW

DRIVER SIDE CYLINDER HEAD FACE SHOWN

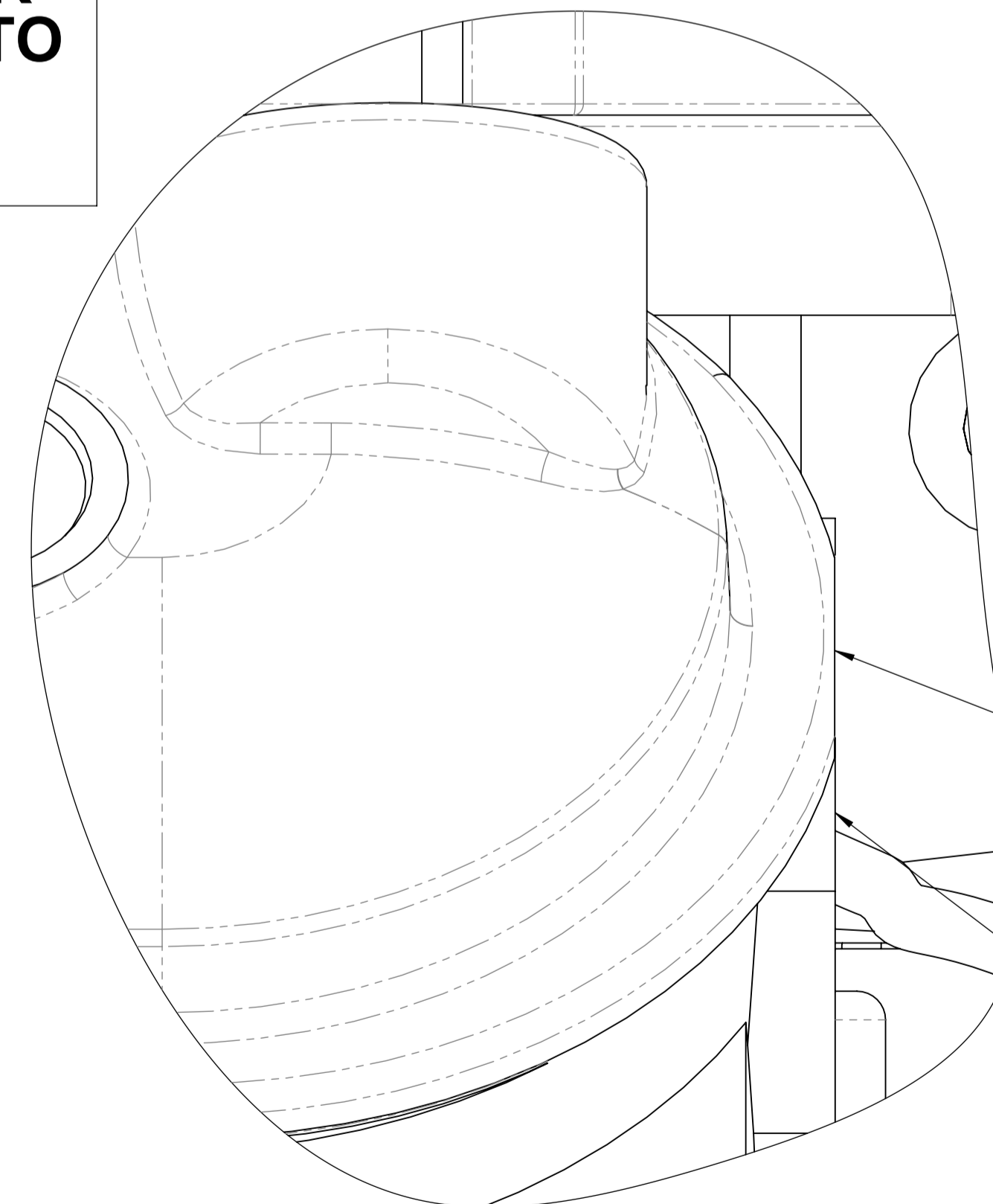
THE ROCKER COVER LIP MODIFICATION WILL ALSO BE REQUIRED FOR THE DRIVER SIDE ROCKER COVER WHEN IT IS FITTED TO THE PASSENGER SIDE CYLINDER HEAD IF A LH ACCESSORY KIT IS TO BE FITTED



SIDE VIEW (1)

PASSENGER SIDE ROCKER COVER LIP SITS ABOVE THE CYLINDER HEAD

DRIVER SIDE CYLINDER HEAD FACE SHOWN



SIDE VIEW (2)

THE LIP OVER HANG MUST BE SHAVED BACK TO THE CYLINDER HEAD FACE

CAUTION: DO NOT SHAVE PAST THE CYLINDER HEAD & ENCROACH INTO THE O RING GROOVE

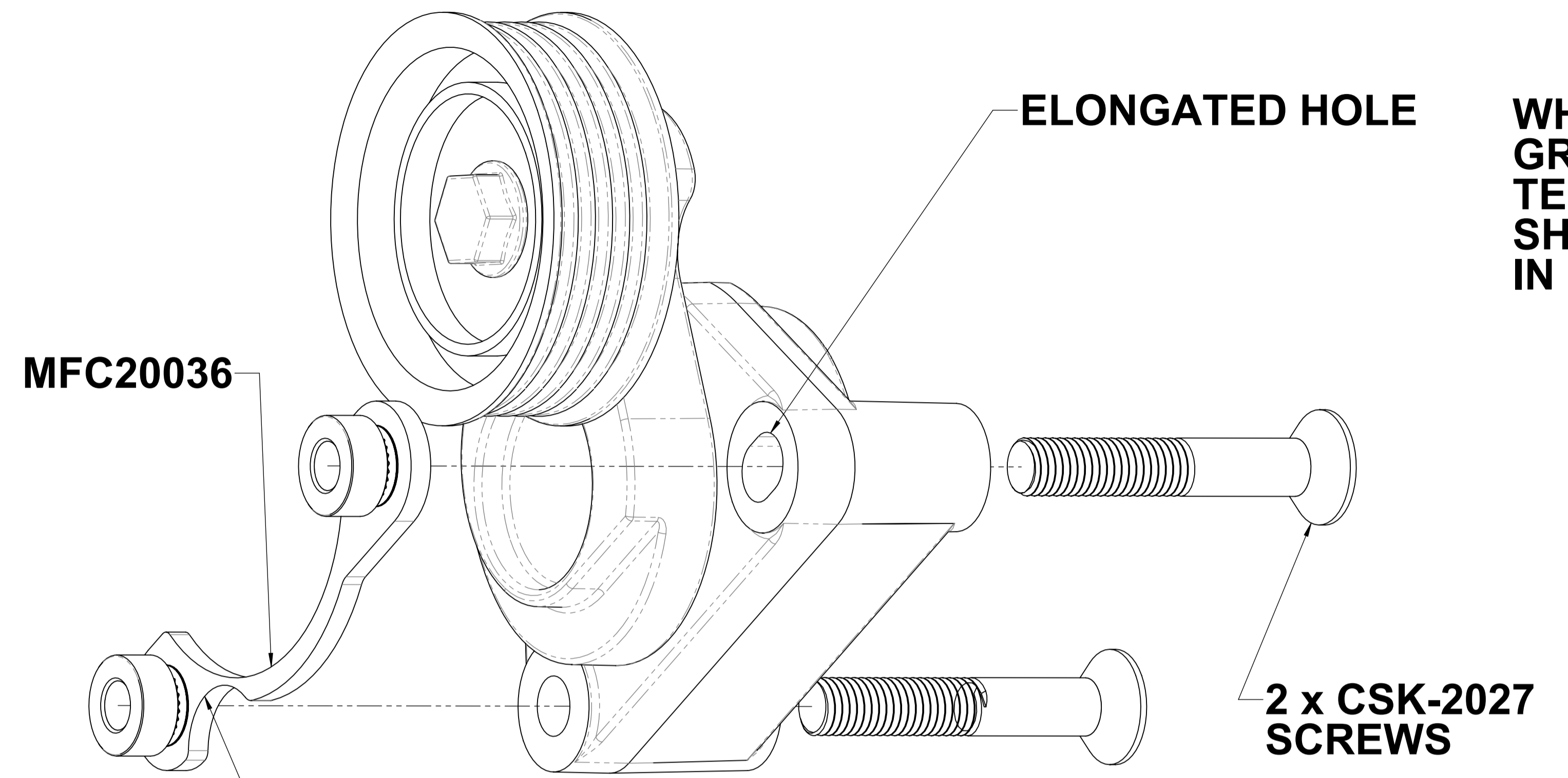
PASSENGER SIDE ROCKER COVER LIP SHAVED

DRIVER SIDE CYLINDER HEAD FACE SHOWN

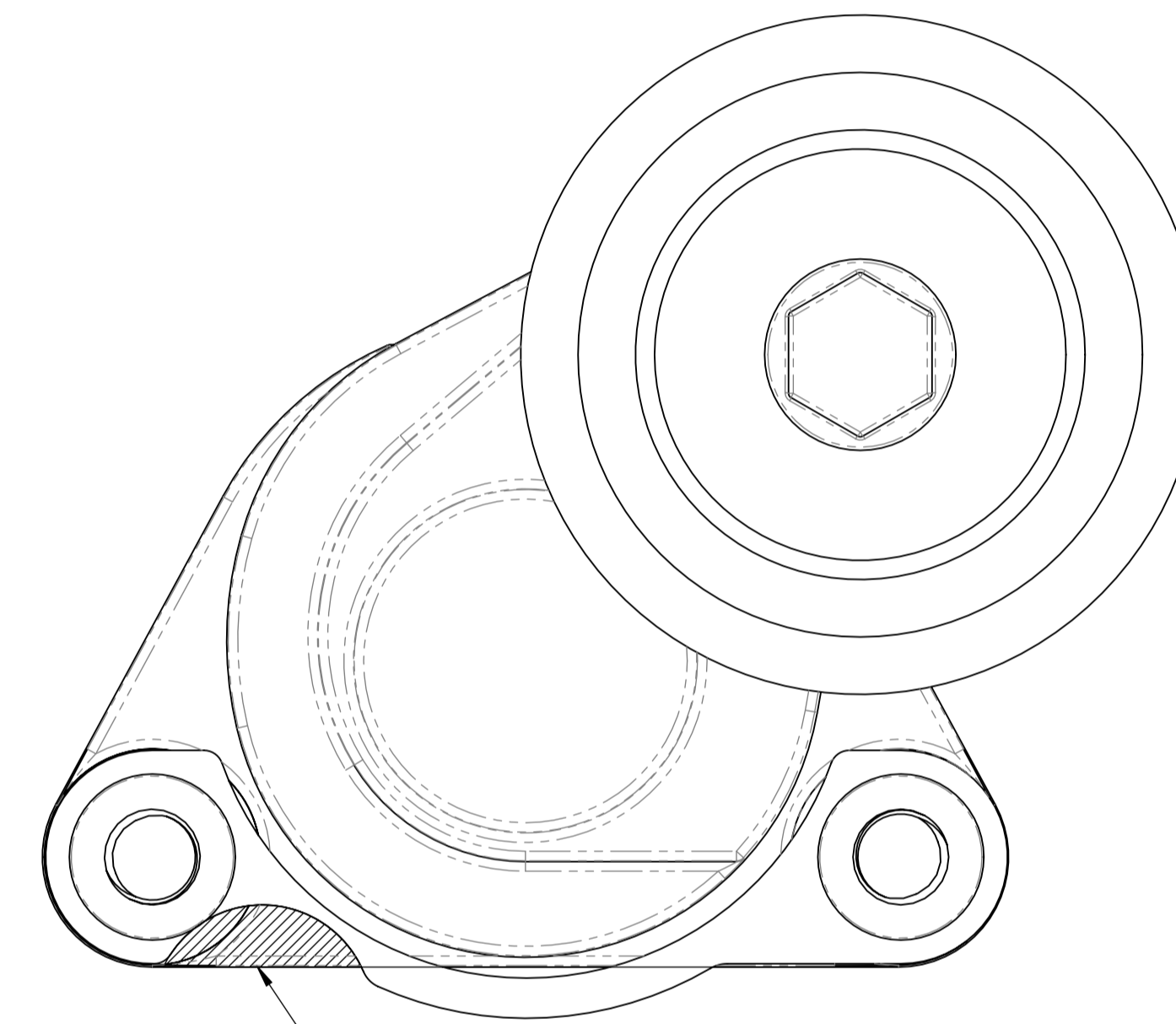


DRAWN	GDK 18/08/2021	TITLE:	LS - Series Rocker Cover Lip Modification	
DRAWING CHECKED	PAM 18/08/2021	( )	DRAWING/PART NUMBER	REV No.
FINISHED WEIGHT: kg		SCALE: 2:1	LS - ACCMOD - 01	0

# LS1 TENSIONER GRIND TEMPLATE

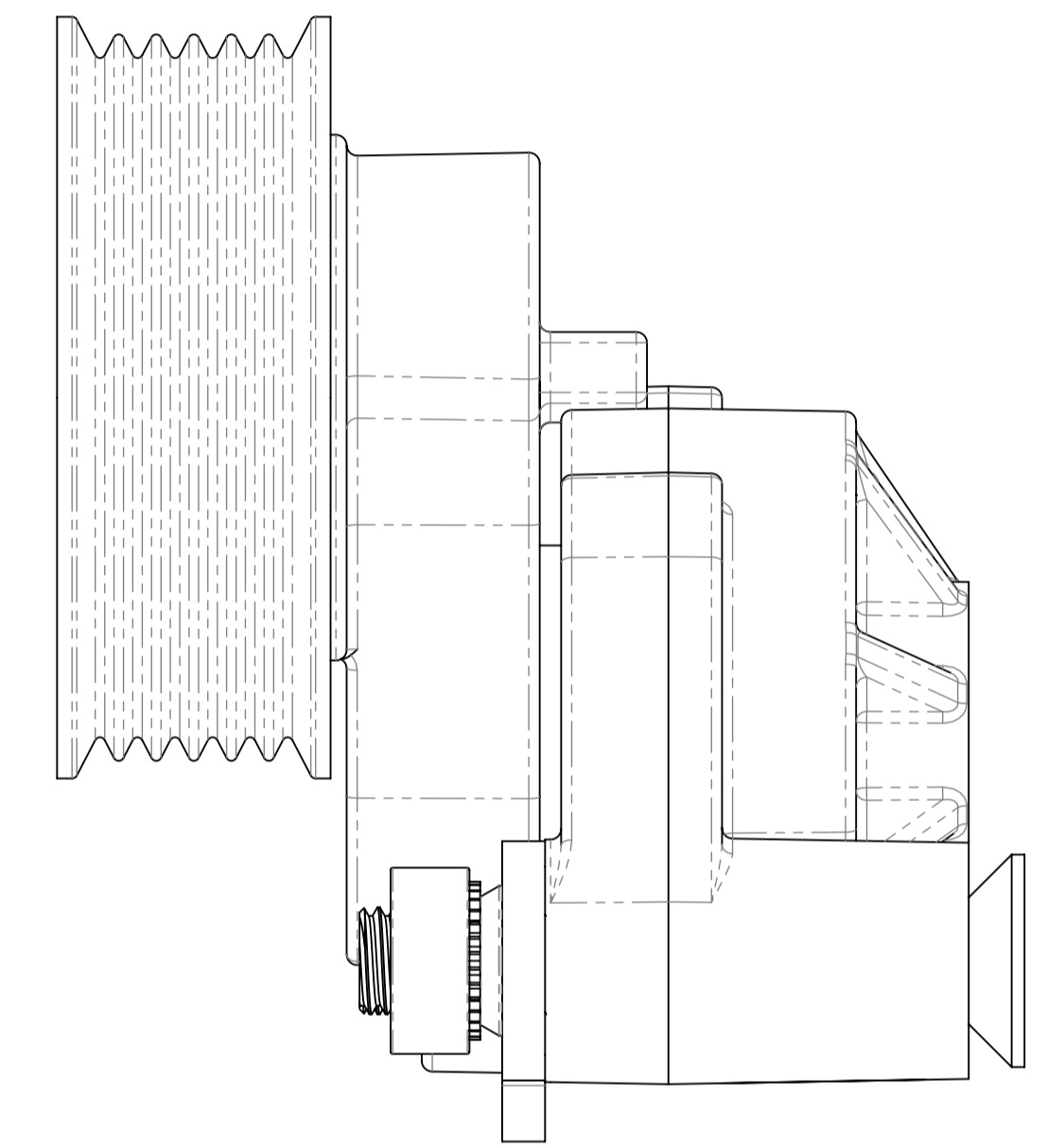


WHEN ASSEMBLING THE GRIND TEMPLATE TO THE TENSIONER, THE TEMPLATE SHOULD SIT AS SHOWN IN FRONT VIEW (1)



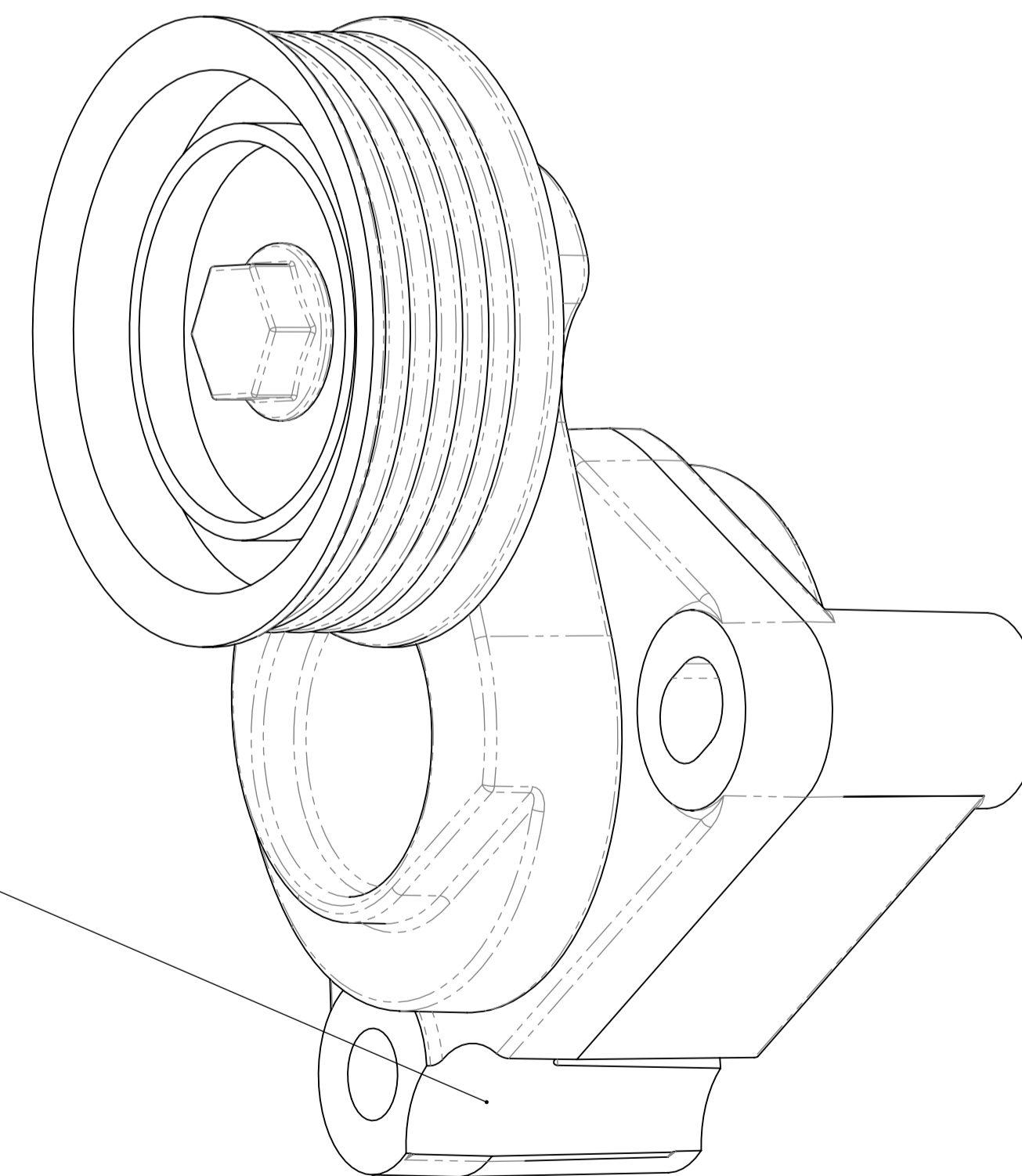
REMOVE THE HATCHED AREA AS SHOWN

FRONT VIEW (1)



SIDE VIEW (1)

WHEN THE HATCHED AREA HAS BEEN GROUND OUT THE CLEARANCE SHOULD APPEAR AS SHOWN



DRAWN	GDK 18/08/2021	TITLE:	LS1 Tensioner Grind Template	
DRAWING CHECKED	PAM 18/08/2021	SCALE: 1.5:1	DRAWING/PART NUMBER	REV No.
FINISHED WEIGHT: kg		DRAWING 1 of 1	LS - ACCMOD - 10	0

# LS1/2/3 WATER PUMP GRIND TEMPLATE

WHEN ASSEMBLING THE GRIND TEMPLATE TO THE WATER PUMP, THE TEMPLATE SHOULD SIT AS SHOWN IN FRONT VIEW (1)

HALF CIRCLE CUT OUT

MFC20037

2 x CSK-2010 SCREWS

REMOVE THE HATCHED AREA AS SHOWN

WHEN THE HATCHED AREA HAS BEEN GROUND OUT THE CLEARANCE SHOULD APPEAR AS SHOWN

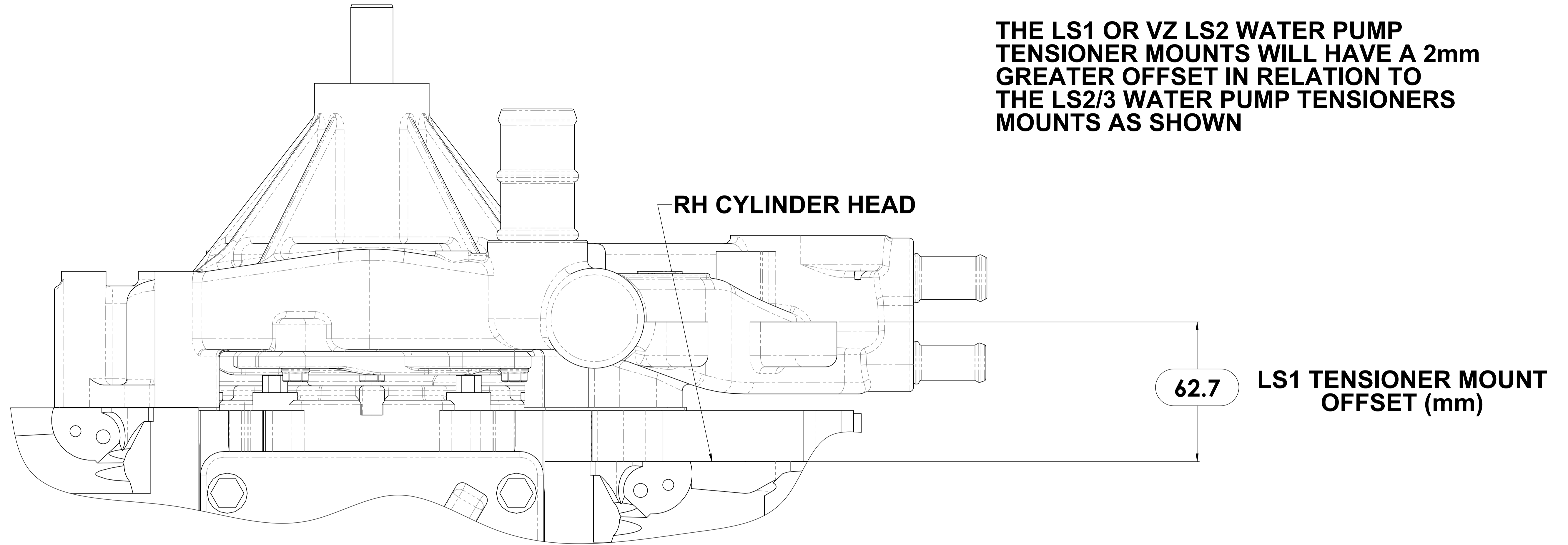
FRONT VIEW (1)



DRAWN	GDK 18/08/2021	TITLE:	LS1/2/3 Water Pump Grind Template	
DRAWING CHECKED	PAM 18/08/2021	SCALE: 1:1	DRAWING/PART NUMBER	REV No.
FINISHED WEIGHT: kg		DRAWING 1 of 1	LS - ACCMOD - 11	0

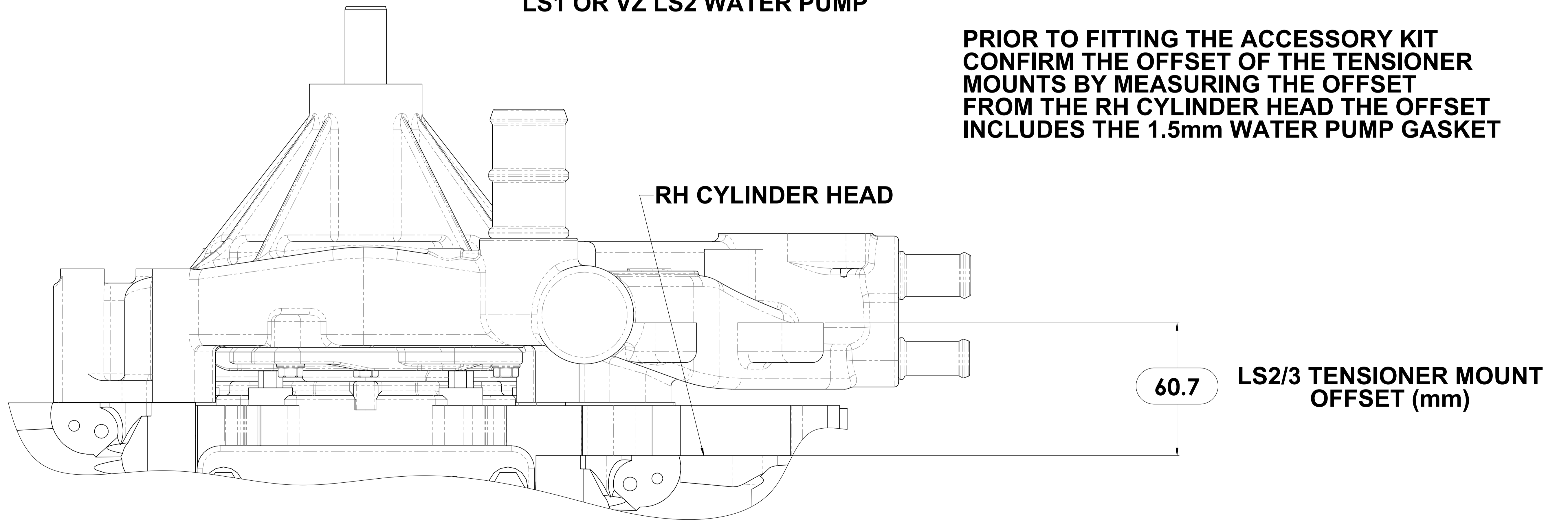
# LS WATER PUMP TENSIONER MOUNT OFFSETS

THE LS1 OR VZ LS2 WATER PUMP TENSIONER MOUNTS WILL HAVE A 2mm GREATER OFFSET IN RELATION TO THE LS2/3 WATER PUMP TENSIONERS MOUNTS AS SHOWN



LS1 OR VZ LS2 WATER PUMP

PRIOR TO FITTING THE ACCESSORY KIT CONFIRM THE OFFSET OF THE TENSIONER MOUNTS BY MEASURING THE OFFSET FROM THE RH CYLINDER HEAD THE OFFSET INCLUDES THE 1.5mm WATER PUMP GASKET



LS2/3 WATER PUMP



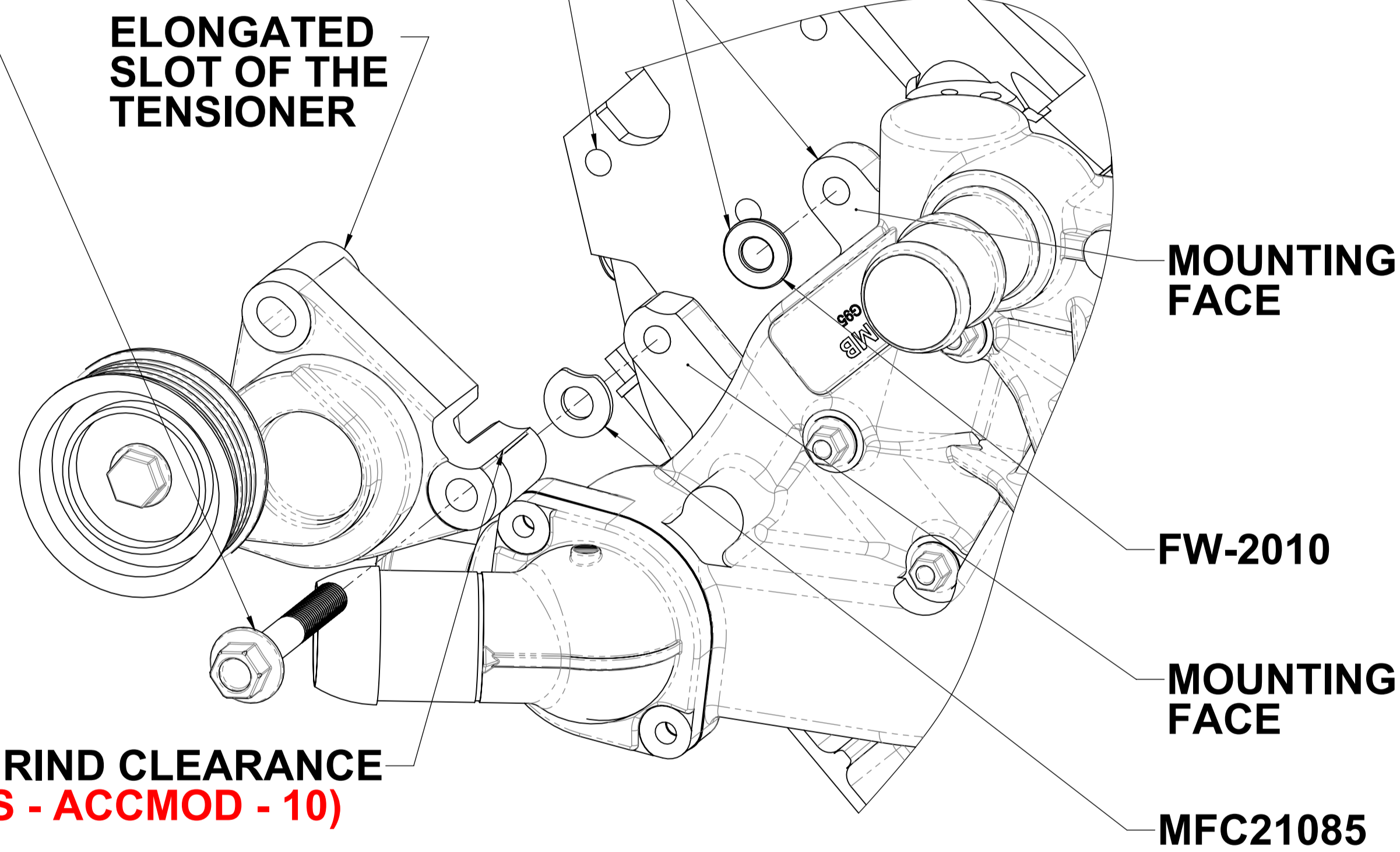
DRAWN	GDK 18/08/2021	TITLE	LS Water Pump Tensioner Mount Offsets	
DRAWING CHECKED	PAM 18/08/2021	SCALE: 1:1	DRAWING/PART NUMBER	REV No.
FINISHED WEIGHT: kg		DRAWING 1 of 1	LS - INFO - 02	0

# MARKS 4WD LS WATER PUMP

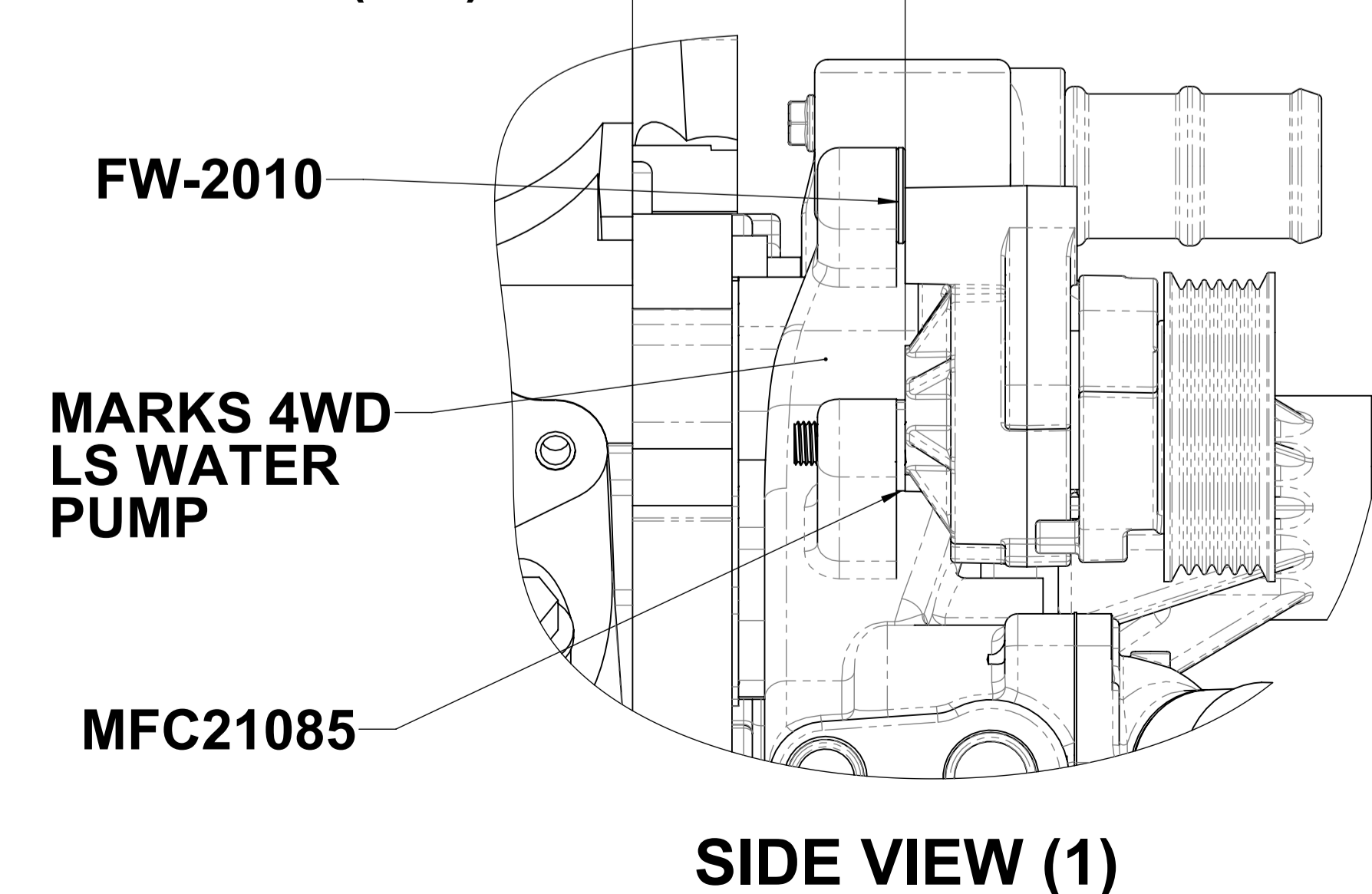
1:- THE GRIND CLEARANCE FOR THE LS1/ VZ LS2 TENSIONER & TENSIONER OFFSET MUST BE DONE PRIOR TO ASSEMBLING THE KIT

2:- ONCE THE GRIND CLEARANCE IS DONE MOUNT THE RH BASE PLATE OF THE KIT TO THE RH CYLINDER HEAD WITH THE SUPPLIED BOLTS

3:- MOUNT THE TENSIONER & MFC21085 SPACER (ORIENT AS SHOWN) TO THE MOUNTING FACE OF THE WATER PUMP USING AN OEM BOLT (M10x1.5x65) BEFORE ASSEMBLING THE KIT



1:- TENSIONER OFFSET 62.7 (LS - INFO - 02) IS IN (mm)



SIDE VIEW (1)

# LS1/ VZ LS2 TENSIONER ASSEMBLY FOR RH KIT

FOLLOW STEPS 1,2,3,4,5 IN THAT ORDER

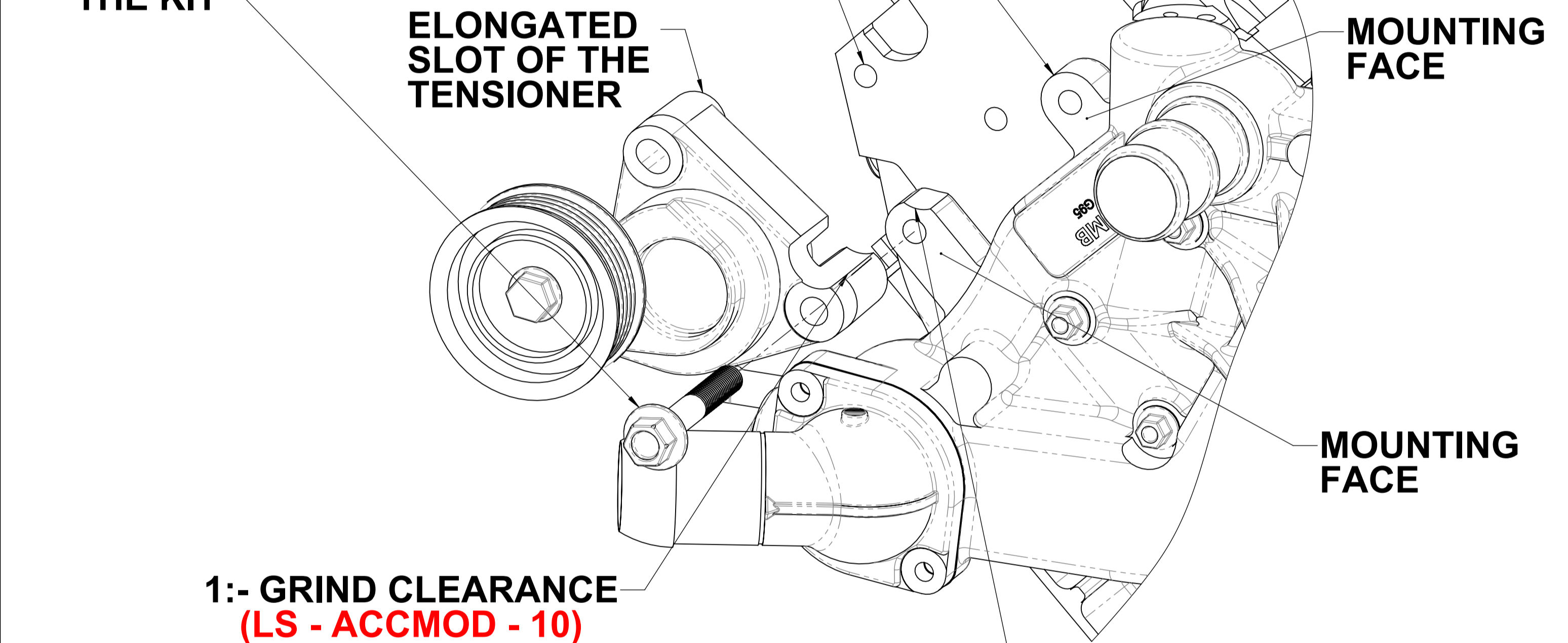
4:- THE ELONGATED SLOT OF THE TENSIONER WILL SIT DIRECTLY ONTO THE RH BASE PLATE SPACER OF THE KIT **(NO SHIM REQUIRED)**

5:- FW-2010 IS HELD CAPTIVE TO THE MOUNTING FACE OF THE WATER PUMP BY THE RH FRONT PLATE SPACER OF THE KIT WHEN ASSEMBLED

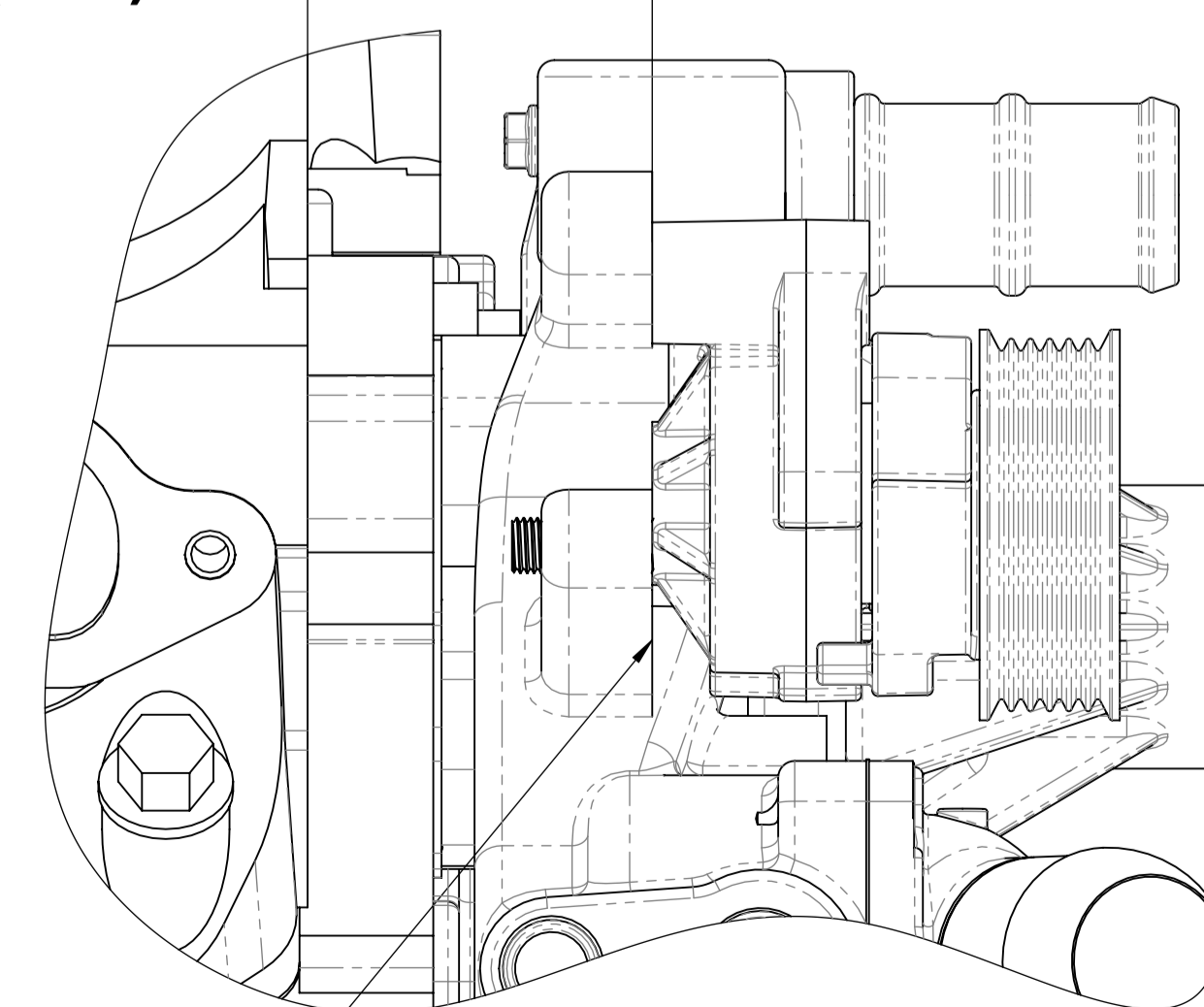
1:- THE GRIND CLEARANCE FOR THE WATER PUMP & LS1/ VZ LS2 TENSIONER & TENSIONER MOUNT OFFSET MUST BE DONE PRIOR TO ASSEMBLING THE KIT

2:- ONCE THE GRIND CLEARANCE IS DONE MOUNT THE RH BASE PLATE OF THE KIT TO THE RH CYLINDER HEAD WITH THE SUPPLIED BOLTS

3:- MOUNT THE TENSIONER (ORIENT AS SHOWN) DIRECTLY TO THE MOUNTING FACE OF THE WATER PUMP USING AN OEM BOLT (M10x1.5x65) BEFORE ASSEMBLING THE KIT



1:- TENSIONER OFFSET 62.7 (LS - INFO - 02) IS IN (mm)



LS1/ VZ LS2 WATER PUMP

SIDE VIEW (2)

# OEM LS1/VZ LS2 WATER PUMP

FOLLOW STEPS 1,2,3,4,5 IN THAT ORDER

4:- THE ELONGATED SLOT OF THE TENSIONER WILL SIT DIRECTLY ONTO THE RH BASE PLATE SPACER OF THE KIT **(NO SHIM REQUIRED)**

5:- THE RH FRONT PLATE SPACER OF THE KIT WILL SIT DIRECTLY ONTO THE MOUNTING FACE OF THE WATER PUMP WHEN ASSEMBLED

VERIFY THE CORRECT OEM OFFSET FOR THE LS1 WATER PUMP IS @ 62.7mm AS SHOWN IN SIDE VIEW (2)

THE SUPPLIED SPACERS MFC21085 & FW2010 ARE 2mm THICK & SIT DIRECTLY ON THE MOUNTING FACES OF THE MARKS 4WD LS WATER PUMP AND FIX THE CORRECT OFFSET @ 62.7mm AS SHOWN IN SIDE VIEW (1)



DRAWN	GDK 18/08/2021	TITLE	LS1/VZ LS2 Tensioner Assembly For RH Kit
DRAWING CHECKED	PAM 18/08/2021	SCALE: 0.75:1	DRAWING/PART NUMBER
FINISHED WEIGHT: kg		DRAWING 1 of 1	REV No. LS - INFO - 06 0