



# PERFORMANCE ASSEMBLY SOLUTIONS

OBSOLETE

Work Instruction

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<b>Operation:</b> 55C <b>Description:</b> Pushrod Assembly	<b>Prepared By:</b> Quality <b>Approved by:</b> Manufacturing
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<b>Title:</b> <b>Tubes, Pushrod, Rocker Bases &amp; Intake Assembly</b>	

## TUBE ASSEMBLY

1. Check to make certain that the large washers have been installed, or install the large washers from the Pushrod Tube Assemblies into the lifter blocks.
2. Lubricate both of the O-Rings with silicone and insert the inner or male tube face up into the head so that the female end is in the lifter block.
3. Install a pushrod cover clip onto the pushrod cover using the Pushrod Cover Installation tool.

## PUSHROD ASSEMBLY

4. For visibility of the pushrod IDs after installation, indicate their corresponding colors at the ends of the rods with paint-marker.
5.  Lubricate and install the pushrods in order: **GREEN**, **YELLOW**, **BLUE** and **PINK**, from front to rear, as shown in the illustration below.
6. NOTE: IN ORDER TO TORQUE THE ROCKER SHAFT SUPPORTS YOU MUST HAVE THE PISTON @ TDC SO THERE IS NO LOAD ON THE VALVE SPRING.



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## ROCKERBASE ASSEMBLY

4. Remove two (2) Rocker Assemblies from the shelf. Inspect for cosmetic defects.
5. Apply blue thread lock to, and install four (4) 5/16-18 x 2 3/4 inch socket head screws into the left side rocker shaft supports.
6. Apply blue thread lock to four (4) 5/16-18 x 2 inch socket head screws into the right side rocker shaft supports.
7. Using the Spline Socket, rotate the front piston to top dead center. (T.D.C.)
8. Install the Rocker Gaskets (Left PN# 01-258, and Right PN#01-257 on one each, left and right rocker assembly respectively.
9. Set the Rocker base on the respective cylinder head and ensure that the gaskets are properly aligned and tighten the four 5/16 fasteners on each rocker base.
10. Repeat steps 9-11 for the rear head.
11. Apply a thin coating of blue thread lock to ten (10) 1/4-20 x 7/8 inch socket head screws, install into the rocker base and torque to 8-12 ft lbs.



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