



# PERFORMANCE ASSEMBLY SOLUTIONS

OBSOLETE

Work Instruction

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<b>Operation:</b> 55A <b>Description:</b> Rocker Cover Sub-Assembly	<b>Prepared By:</b> Quality <b>Approved by:</b> Manufacturing
<b>Revision Date:</b> 02/11/03 <b>Revision Level:</b> 07	<b>Issue Date:</b> 12/05/02 <b>Issued by:</b> Quality
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<b>Title: Rocker Base Sub-Assembly</b>	

## ROCKER BASE SUB-ASSEMBLY

(INSERT NEW VISUAL HERE SHOWING FORGED ONE-PIECE BASE ON SUBASSEMBLY FIXTURE)

1. Inspect all components for dents, scratches, dirt, oil, debris, etc. Inspect rocker arm ends to ensure there are no voids in casting and for roundness of the cupped pushrod end. Reject out-of-round parts. **NOTE: All rocker arms MUST be washed prior to installation.**
2. Place rocker base onto subassembly fixture as shown above.
3. Position Rocker Arms between supports—Push Rod end toward the right rocker shaft support. *\*NOTE: Push Rod ends face each other, and toward the right rocker shaft support.*
4. Lubricate and install two (2) Rocker Arm Shafts (PN01-199) into rocker arms with notched ends inside the right side Rocker Shaft Support. Engage with two 5/16-18 x 2 socket head cap screws (PN96-298).
5. Install two green-head assembly bolts into left side Rocker Shaft Support.
6. Check endplay between Rocker Shaft Supports and Rocker Arms. Endplay should be between .003” and .012”.
7. Remove from fixture, check for cosmetic issues and repack into foam bag the base was taken from.
8. Initial and date the bag and place it on the appropriate shelf.



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**(INSERT NEW VISUAL OF FINISHED PRODUCT)**

Figure 1.2

<b>MAPICS PART #</b>	<b>INDIAN PART #</b>	<b>QTY/DESCRIPTION</b>
<b>715019</b>	<b>01-202</b>	<b>ROCKER BOX ASSEMBLY</b>
		(1)Rocker Base
800009	01-199	(2)Rocker Arm Shaft
715006	01-151	(1)Rocker Arm
715007	01-152	(1)Rocker Arm
750017	96-298	(2)Socket Head Cap Screws