



PERFORMANCE ASSEMBLY SOLUTIONS

OBSOLETE

Work Instruction

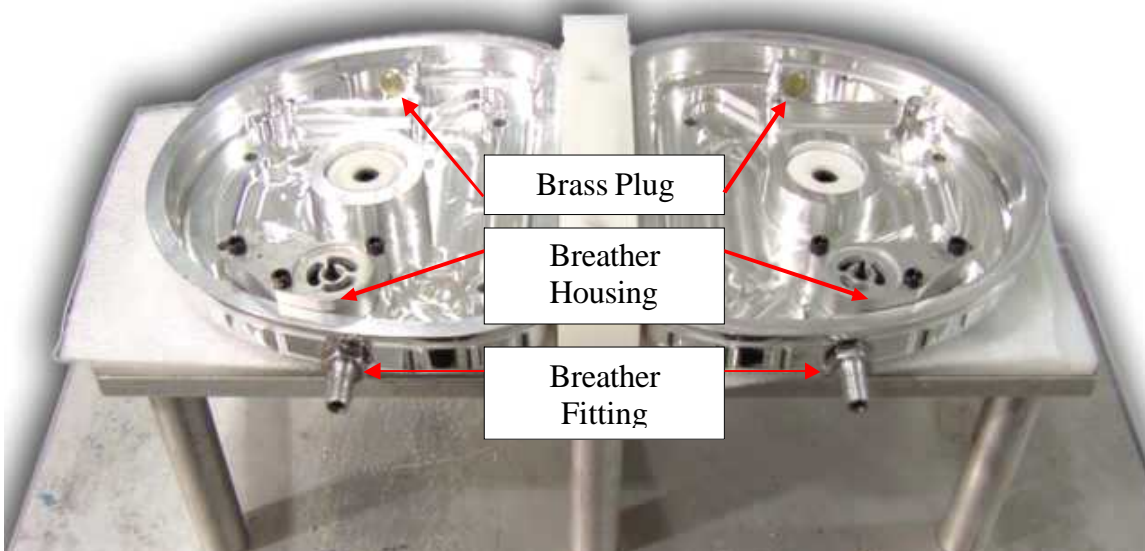
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Operation: 55 Description: Rocker Cover Sub-Assembly	Prepared By: Quality Approved by: Manufacturing
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Title: Rocker Cover Sub-Assembly	

ROCKER COVER SUB-ASSEMBLY

(INSERT NEW VISUAL HERE)

1. Inspect all components for dents, scratches, dirt, oil, debris, etc.
2. Place two Rocker covers on the assembly jig. NOTE: They are NOT interchangeable, and right and left orientation can be determined by the location of the breather housing mount.
3. Insert one Umbrella Valve (PN01-318) into each of the two Breather Housings. Pull taut with a pair of needle nose pliers to ensure proper installation and seating. (*Breather Housings may have valves pre-installed.*)








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Figure 1.1

4. Lubricate O-Ring with silicone and thread by hand, two brass plugs, one on each cover (PN01-325) thread and torque to 8-12 ft lbs  with Tool#I-07.
5. Lubricate O-Ring with silicone and thread by hand, two Breather Fittings, one on each cover (PN01-316) and torque to 8-12 ft lbs  with Tool#I-07.
6. Place a Breather Housing Gasket (PN01-290) and one Breather Housing (PN01-312 for the front and PN01-311 for the rear), onto each rocker cover.
7. Apply a drop of blue thread lock to six (6) (PN96-965) 10-24 x1” socket cap screws, thread into Breather (PN450020) and torque fasteners at 8-12 ft lbs with Tool#I-08. 

MAPICS #	INDIAN PART #	QTY/DESCRIPTION
715019	01-202	ROCKER BOX ASSEMBLY
715020	01-206	(1)Rocker Box Cover
450003	01-312	(1)Breather Valve Housing
950022	01-318	(1)Umbrella Valve
390052	01-290	(1)Breather Housing Gasket
750020	96-965	(3)Breather Housing Screw
640012	01-325	(1)Plug and O-Ring
345001	01-316	(1)Fitting