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## INSTALLATION INSTRUCTIONS

Please follow these instructions to ensure the proper operation of your T&D Machine Products Rocker Arm Assembly for the Buick 350/455 V-8.

1. Inspect the rocker arm assembly to be sure that the rocker arms are the proper ratio.
2. Remove the old rocker arm assembly and inspect the tapped holes in the cylinder head rocker stands. Be sure that the holes are clean and free of dirt or grit and no holes have stripped threads.
3. Remove all the pushrods and place a rocker shaft assembly on one cylinder head, being careful to have all the roller tips on the valves. Install the pushrods for one cylinder and check for proper clearance in the pushrod holes in the cylinder head. If it appears that there is adequate clearance all around the pushrod, bolt the rocker assembly to the cylinder head, making sure the pushrod is seated in the adjuster cup of the rocker arm. Carefully rotate the engine, constantly checking the pushrod hole for clearance through the entire valve lift cycle.

**CAUTION:** Rocker arms that are higher than the stock ratio (1.60 or 1.65) or the use of larger than stock pushrods will require machining of the pushrod holes in the cylinder head for pushrod clearance.

**CAUTION:** If you do not have at least 1/16" clearance in the pushrod hole, interference between the pushrod and the cylinder head may occur. This can result in bent or broken pushrods and damage to the engine or valve train.

**NOTE:** This rocker system is not designed to accommodate valve springs larger than 1-3/8" (1.375).

4. The rocker arms are cut to fit next to the mounting stands on the cylinder heads. Be sure that they do not interfere with the head when bolted down. If interference does exist, notify T&D tech staff at once.
5. Attach the shaft assembly to the cylinder head and torque to 25-30 ft-lbs. Adjust the valves per the camshaft manufacturers' specifications.