



## TP PRO-SERIES® ENGINES – ASSEMBLY SPECIFICATIONS

	TORQUE	SIZE	LENGTH	THREAD	SPEC
<b>ROCKER BOXES</b>					
5/16" BOLTS	18-20 FT LBS				
1/4" BOLTS	110 IN LBS				
<b>HEAD BOLTS</b>	HEAD BOLT THREADS AND WASHER SURFACES MUST BE LUBRICATED PRIOR TO ASSEMBLY TO OBTAIN ACCURATE TORQUE VALUES DURING TIGHTENING.				
1ST PASS	10 FT LBS				
2ND PASS	20 FT LBS				
3RD PASS	30 FT LBS*	* FINAL TORQUE VALUE OF 30 FT LBS IF THREADS LUBRICATED WITH MOLY LUBE. IF MOTOR OIL IS USED AS THE LUBRICANT, TIGHTEN HEAD BOLTS TO 40 FT LBS.			
<b>OIL PUMP</b>	110 IN LBS				
CAM COVER	110 IN LBS				
TAPPET BLOCK	110 IN LBS				
<b>ENGINE CASE</b>					
5/16" BOLTS	24 FT LBS				
1/4" BOLTS	110 IN LBS				
IGNITION TIMING	(NOSE CONE IGNITIONS, ONLY)				32° BTDC
SPARK PLUG GAP	Autolite # 4164				.035"
INTAKE MANIFOLD	RUBBER SEALS MUST BE LUBED W/ ASSEMBLY LUBE DURING INSTALLATION				
PUSHROD ADJUSTMENT	(Crane pushrods, 3/8 nut size) ZERO-LASH, THEN TIGHTEN THREE FULL TURNS. ( TP Logo pushrods, 7/16 nut size) ZERO-LASH, THEN TIGHTEN FOUR FULL TURNS.				



CLEARANCES / SPECS		SPEC
FLYWHEEL RUNOUT		0.001 – 0.0015
PINION BEARING		0.001 – 0.0025
ROD BEARING		0.0008 – 0.0017
PISTON PIN IN BUSHING		0.0005 – 0.001
CAM END PLAY		0.0012 – 0.020
PINION BUSHING IN COVER		0.001 – 0.0025
CAM BUSHING IN COVER		0.001 – 0.0025
TAPPETS IN GUIDE		0.001 – 0.002
PISTONS IN CYLINDERS		0.0018 – 0.0026
CYLINDERS BORE		4.125 + .0004 -0
PISTON DIAMETER		4.123 +/- .0002
COMPRESSION RING END GAP		0.018 – 0.027
OIL CONTROL RING GAP		0.010 – 0.040
EXHAUST VALVE IN GUIDE		0.002 – 0.003
INTAKE VALVE IN GUIDE		0.0019 – 0.0025

Assembly Specifications 2007