



Installation Instructions  
**Steel Roller Tappets**  
 Horizontal Locking Bar Roller Tappets

**For more information, see [www.cranecams.com](http://www.cranecams.com)**

The design and use of these roller tappets requires an adequate supply of oil for proper lubrication and cooling. Many of the newer racing oil pans reduce windage and eliminate splash oiling. Utilizing oil restrictors can reduce important oil flow to the tappets and will cause needle bearing failure, axle failure, and severe tappet body damage. Be sure that your oiling system provides adequate oiling to cool and lubricate your roller tappets and the balance of your valve train components.

To test for tappet problems, turn the roller with your finger. Should a rough or gritty feeling occur, the tappet has been damaged. If they are damaged, contact Crane Cams Technical Department (386-258-6174) for assistance.

After any cleaning, you must soak the roller end of the tappets in oil before installing. This is necessary to prevent premature wear.

**SPECIAL APPLICATION INSTRUCTIONS**  
**Check for your Application and Part Number**

Part No. **81520** Buick Stage II On Center V-6 181-252

Part No. **81521** Buick Stage II On Center V-6 181-252 with .875" Dia. Lifter Bores

Tappet set **81520** contains 1 pair of tappets with a slightly wider locking bar. This part (**81520W-2**) is used **only for #3 cylinder**. Replacement pairs of tappets for the other cylinders can be ordered as part number **81520-2**.

Tappet set **81521** contains 1 pair of tappets with a **slightly wider locking bar**. This part, **81521W-2** is used **only for #3 cylinder**. Replacement pairs of tappets for the other cylinders can be ordered as part number **81521-2**.

Part No. **11515** 55-98 Chevrolet V-8 262-400

Part No. **11522** 87 & Up Chevrolet V-8 262-400 Hyd. Roller Style Blocks

Part No. **11527** Chevrolet V-8 262-400 with .875" Dia. Lifter Bores

Part No. **11540** Chevrolet V-8 262-400 Pro Series

Part No. **11528** 55-98 Chevrolet V-8 262-400

One end of the roller tappet locking bar may have to be shortened by grinding or filing to enable it to lie flat. Number 8 cylinder is usually the most critical. Only part number **11522** should be used in 87 and up factory hydraulic roller style blocks, due to tall lifter bores.

Part No. **13515** 67 & Up Chevrolet V-8 396-454

Part No. **13527** 67 & Up Chevrolet V-8 396-454 with .875" Dia. Lifter Bores

Part No. **13540** 67 & Up Chevrolet V-8 396-454 Pro Series

Part No. **13522** Rodeck 481 Aluminum Block Only

Part No. **13528** 67 & Up Chevrolet 396-454

The guideplate has a "T" stamped on one side, place this **side up**. Also, place **straight edge of bar towards center of block**.

You **must** use our 3/8" diameter heat-treated pushrods, Part No. **13634** for standard blocks or Part No. **13635** for "high" or "truck" blocks. Crane roller tappets have a 5/16" pushrod seat cup with a 5/32" radius. Using 7/16" diameter pushrods will cause the locking bar to bind, usually with disastrous results!

Some Chevrolet pushrod ends have a ball end, which is **several thousandths larger than 5/16"**! This will cause the pushrod seat in the tappet to crack or break.

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**CRANE CAMS, INC. 530 Fentress Blvd., Daytona Beach, FL 32114**  
**[www.cranecams.com](http://www.cranecams.com) Tech Line: (386) 258-6174 Fax: (386) 258-6167**

**slot in the lifter or coil bind the guide bar hold-down spring** on the base circle of the camshaft.

The Crane rev kit is designed for a stock block. If the block is milled, make sure that the rev kit spring **does not stack**. If it does stack, the top of the roller will break or crack, therefore destroying the roller tappet.

If the tappets are disassembled, they must be reassembled with the locking bar **under** the coil spring, not on top. Check to make sure it travels freely.

Since some pushrod seats in the tappets do not have a leading edge, you must be extremely careful that the pushrod is **in the seat** when adjusting the valves. To insure this, we highly recommend that you utilize the following installation and adjustment procedure.

Install the pushrods and adjust the valves with the manifold off, so that you can see the end of the pushrod. **The best method is to install the pushrods in one cylinder at a time, and then adjust these before going to the next cylinder.** Make sure the pushrod is not binding in the guide-plate or head casting.

If all the pushrods and rocker arms are installed at the same time, the pushrod will sometimes jump out of the roller tappet seat or rocker arm seat when the engine is turned over, before they are adjusted. This can cause **severe damage** when the engine is started.

If you any questions regarding these tappets and their installation, contact our Tech Department.

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Part No. **17515** Chevrolet V-6 200-229  
with V-8 Style Oiling

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Part No. **17527** Chevrolet V-6 200-229  
with V-8 Style Oiling and .875" Dia.  
Lifter Bores

One end of the tappet locking bar may have to be shortened by grinding or filing to enable it to lie flat. Number 6 cylinder is usually the most critical. These can **only be used** with blocks machined for V-8 style **oiling**.

Tappet set **17515-12** contains 2 pairs of tappets (**17515-2**) with copper-plated locking bars and 4 pairs of tappets (**11515-2**) with black locking bars. The tappets with **copper-plated locking bars** are for **cylinders 3 and 4 only**.

Tappet set **17527-12** contains 2 pairs of tappets (**17527-2**) with copper-plated locking bars and 4 pairs of tappets (**11527-2**) with black locking bars. The tappets with **copper-plated locking bars** are for **cylinders 3 and 4 only**.

## GENERAL INSTRUCTIONS

These roller tappets are designed to be used with our 8620 steel roller cams. Some manufacturers produce a cam with wider lobes. If you are using a "wide lobe" camshaft you must check the clearance between the side of the adjacent lobes and the side of the roller tappet around the axle area.

When using a cam with an extremely small base circle, make sure the guide bar **does not contact the top of the**