



SHAFT MOUNT ROCKER ARMS INSTALLATION INSTRUCTIONS

For Chevrolet, Small Block Chrysler, Ford, Oldsmobile and Pontiac applications.

Please read these instructions and notes carefully and completely before beginning.

Follow these instructions closely for easy installation.

If you have any problems please contact Scorpion Technical Support at 352-512-0800.

CAUTION: DO NOT install or remove these rockers with valve spring load present or damage may occur.

Installation Notes:

- Aftermarket valve covers may be necessary.
- Lube pushrods and adjusters with the provided Extreme Pressure Lube #3.
- Tighten all fasteners and adjuster nuts with a quality, calibrated torque wrench.
- Check cylinder head rocker stand bolt holes for proper threading and depth.
- Check head bolt or head stud / nut clearance to underside of rocker stand.
- Check cylinder head for pushrod clearance throughout the lift range.
- Due to the type of cylinder head and the components used, cylinder head machining may be necessary in some cases.

Installation Instructions:

1. Adjust Stand Height

The proper stand height is determined by the roller tip being centered on the valve tip. This can be accomplished by putting black marker on the valve tip and installing the rocker stand, pushrod and rocker assembly with no lash. Then rotate the engine so the valve travels through the lift cycle, remove the rocker to see the pattern left in the black marker. If the stand is too low the mark on the valve will be off center toward the intake manifold, so add shims accordingly. If the stand is too high the mark on the valve will be off center toward the exhaust port, so a longer valve, lash cap, or cylinder head machining would be necessary.

2. Attach Stand

The rocker stand mounting holes have a small amount of elongation. Loosely attach stand (with provided lube or sealant on the attaching screws) and rockers to obtain the best front to rear stand position. Remove rockers and torque stand (see included torque spec).

3. Adjust Pushrod Length

Pushrod length is correct when the adjuster is from $\frac{1}{4}$ to 2 turns out from the fully seated position. This is determined after rocker stand height is established. **DO NOT** use force when seating the adjuster.

4. Install Rocker Arms

Lube the adjusters and pushrods with the provided Extreme Pressure Lube #3. Lube the attaching bolts with 30-weight motor oil and torque to the proper spec. Install rockers one cylinder at a time with the lifters on the base circle of the camshaft and the adjusters turned up enough so there is no spring load on the rocker.

IMPORTANT: Torque Specifications

- 7/16-14, T50 six-lobe stand attaching bolts on aluminum heads 60-65 ft. lbs. with high quality moly lube or sealant
- 7/16-14, T50 six-lobe stand attaching bolts on cast iron heads 60-65 ft. lbs. with high quality moly lube or sealant
- 5/16-18, T45 six-lobe rocker shaft attaching bolts 24-26 ft. lbs. with 30-weight motor oil
- 12-point adjuster lock nuts 18 ft. lbs. minimum to 20 ft. lbs. maximum with the provided Extreme Pressure Lube #3