

Year	Model	Valve Lash		Valve Angles		Valve Spring Installed Height	Valve Spring Pressure Lbs. @ In.	Valve Lift		Stem Clearance		Stem Dia.
		Int.	Exh.	Seat	Face			Int.	Exh.	Intake	Exhaust	
1953-54	All	Zero	Zero	44	44	1 1/16	140 @ 1 1/4	.365	.365	.001-.0025	.001-.0025	.3420
1955-56	All	Zero	Zero	44	44	1 5/64	157 @ 1 1/32	.411	.411	.001-.0025	.001-.0025	.3420
1957	All	Zero	Zero	44	44	1 5/64	157 @ 1 1/32	.451	.451	.001-.0025	.001-.0025	.3420
1958	All	Zero	Zero	44	44	1 5/16	160 @ 1 1/2	.451	.451	.001-.0025	.001-.0025	.3420
1959	All	Zero	Zero	44	44	1 5/16	160 @ 1 1/2	.450	.450	.0005-.0025	.001-.0025	.3420
1960-62	All	Zero	Zero	45	44	1 5/16	160 @ 1 1/2	.450	.450	.0005-.0025	.001-.0025	.3420

PISTONS, PINS, RINGS, CRANKSHAFT & BEARINGS

Year	Model	Fitting Pistons		Ring End Gap ①		Wrist-pin Diameter	Rod Bearings		Main Bearings		
		Shim To Use	Pounds Pull On Scale	Comp.	Oil		Shaft Diameter	Bearing Clearance	Shaft Diameter	Bearing Clearance	Thrust on Bear. No.
1953-55	All	②	②	.010	.010	.9995	2.2488-2.2493	.0005-.002	2.499-2.4995	.0008-.0025	5
1956-59	All	②	②	.013	.013	.9995	2.2488-2.2493	.0005-.002	2.624-2.625	.0008-.0025	5
1960-62	All	②	②	.013	.013	.9995	2.2488-2.2493	.0005-.002	2.624-2.625	.0008-.0025	5

①—Fit rings in tapered bores for clearance given in tightest portion of ring travel.

②—See Piston Clearance Chart, Fig. 11.

ENGINE TIGHTENING SPECIFICATIONS★

★Torque specifications are for clean and lightly lubricated threads only. Dry or dirty threads produce increased friction which prevents accurate measurement of tightness.

Year	Spark Plugs Ft. Lbs.	Cylinder Head Bolts Ft. Lbs.	Intake Manifold Ft. Lbs.	Exhaust Manifold Ft. Lbs.	Rocker Arm Shaft Bracket Ft. Lbs.	Rocker Arm Cover Ft. Lbs.	Connecting Rod Cap Bolts Ft. Lbs.	Main Bearing Cap Bolts Ft. Lbs.	Flex Plate or Flywheel to Crankshaft Ft. Lbs.	Vib. Damper Ft. Lbs.
1953-55	20-25	65-70	25-30	25-30	65-70	20-25①	40-45	90-100	80-85	6
1956-57	20-25	65-70	25-30	25-30	65-70	20-25①	40-45	90-100	75-80	6
1958-60	20-25	65-70	25-30	25-30	65-70	35-40①	40-45	90-100	75-80	6
1961	20-25	75	②	30-35	75	16-36①	40-50	80-105	65-85	10
1962	20-25	75	②	60	75	30①	45	95	70	

①—Inch pounds

②—Bolt 30, nut 25.

STARTING MOTOR SPECIFICATIONS

Year	Model	Starter Number	Brush Spring Tension Oz ①	Free Speed Test			Resistance Test③		Lock Torque Test		
				Amperes	Volts	R.P.M.	Amperes ①	Volts	Amperes ①	Volts	Torque Ft. Lbs.
1953	All	1107602	24	75	10.3	6500	...	...	520	4.9	
1954	All	1107622	35	95	10.1	3500	...	...	470	5.4	
1955	All	1107629	35	95	10.1	3500	...	...	470	5.4	
1956	All	1107642	35	91	10.6	3240①	395	3.5	...	...	
1957-58	All	1107657	40	65②	10.6	3600①	300②	3.5	...	...	
1958	All	1107668	35	65②	10.6	3600①	300②	3.5	...	...	
1959-60	All	1107657	35	65②	10.6	3600①	300②	3.5	...	...	
1961-62	All	1107799	40	65②	10.6	3600①	300②	3.5	...	...	

①—Minimum.

②—Includes solenoid.

③—Check capacity of motor by using a 500-ampere meter and a carbon pile rheostat to control voltage. Apply volts listed across motor with ture locked. Current should be as listed.