Adjustable lifter instructions

Revised August 2018

When setting up the proper rocker arm geometry and pushrod length with a hydraulic lifter, it is important to use a checking lifter that is the same running length as the final assembly lifter. Chrysler lifters from different sources may vary in running length. This procedure and the checking lifter have changed slightly to make it easier to get good results.

To use the adjustable lifter:

Step #1: Measure the internal length of the lifter you intend to use for final assembly. This is best done with a 1.0”-2.0” or 2.0”-3.0” micrometer. If you are using the Hughes 5001 lifter make this measurement 1.650”. If you are using the Hughes 5003 lifter make this measurement 1.588”. If you are using any other lifter you must measure it yourself.

Step #2: For all lifters except for HUG 5003, determine the preload amount you will use during final assembly and subtract that from the internal length. This gives you the running length. Use the following chart to determine the proper preload. This preload is the amount the pushrod cup will be below the retaining ring when the engine is running. HUG 5003 note – The 5003 has a built-in preload and does not need the subtraction.

Lifter P/N	Turns	Preload	Application
5001 & 5003	1 ½ to 2	.075”/.100”	RV/Cruiser/4x4
5006 & 5007	2	.100”	Cast iron block & iron heads
	2 ½	.125”	Cast iron block & aluminum heads
RHD 1068 RHD 1068L RHD 1068X RHD 1068XL	Follow instructions in box for all Rhoads® lifters		
5319 & 5321	1	.050”	Cast iron block & head
	1 ½	.075”	Cast iron block & aluminum heads
	2	.100”	Aluminum block & aluminum heads

3. Adjust the Hughes Engines adjustable lifter to match your running length by moving the set screw and nut to the length measured in Step #1 and with the preload (as shown above) subtracted. Note: The lifter **does not** come to you pre-adjusted.