



## How to install the Hughes 1555A Rocker Arm Kit and the 1555 Conversion Kit (For Edelbrock 61779 & 61767)

Please read all instruction before starting this job. Always wear eye protection.



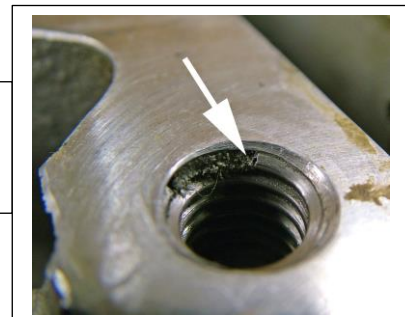
Step 1. Remove all the studs & guide plates from heads.



Note: The studs & guide plates will not be re-used.



Step 2. Find the end of the thread insert as shown in the photo to the right.



Step 3. Using a sharp chisel and a light tap from a hammer, bend the tail of the thread insert in toward the center of the hole.



Step 4. Grab the tail of the thread insert with some good heavy-duty needles nose pliers.



Step 5. Twist the insert counter clockwise (lefty Lucy). The insert is stainless steel so it is stiff and will require some pressure and a tight grip on the pliers.



Step 6. Hey, you got it out!  
Only 15 more to go.



Step 7. It is a good idea to “chase” the threads with a tap. You must use a 7/16”-14 Helicoil tap. Normally this can be done with your fingers. No wrenches required—unless you boogered-up the threads with the needle nose pliers.



Step 8. Assemble the installation kit as shown below.



Step 9. Thread on the new insert with the machined side (the pretty side) against the washer.



Step 10. Thread the installing bolt about  $\frac{3}{4}$  of the way into the insert and tighten the nut up *VERY* tightly to the washer.





Step 11. The new insert should be thread snugly by hand into the original threaded hole. These inserts are a tight fit.



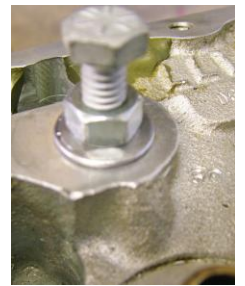
Step 12. Before installing the inserts for the final time clean the threads both in the head and on the insert with brake cleaner or solvent. If you don't, the thread lock will not work very well.

Step 13. Apply a small amount of thread lock (we used green, but you use red) on the threads in the head and on the insert.



Step 14. Install the insert until the washer bottoms against the head. Back the nut on the installation tool away from the washer while holding the bolt securely.

*Note:* **DO NOT** leave the installation tool in the insert. If the thread lock gets on the tool threads and hardens you will have a problem.



Finished product should look like this.



Step 15. You may have burrs around the edge of the hole. Lightly, I said *LIGHTLY* Bubba, draw file this area to dress it up.



Step 20. You are now ready to install your rocker pedestal assemblies. Make sure the pedestal is properly positioned to set the shaft into the saddle of the pedestal. Double check this. This is a common place for a mistake. Tighten the fasteners to 10-12 lb.ft.



**Tech Tip:** Twist the pedestals back & forth as you tighten the fastener to make sure the shaft nests properly in the saddle.

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