Heavy-Duty Billet Steel Hold-Down Instructions
P/N 7440 and 7442
2/20/2021

These heavy-duty hold-downs cradle and support the shaft and spread the loads over a wider area than O.E.M. or aluminum counter parts, reducing shaft flex. These heavy-duty hold-downs are not "drop on" and require custom fitting. Careful attention to our installation instructions will give you the best results.

1. Install the rockers, spacers and hold-downs as shown in Illustration 1 noting the position of oil holes, in the shafts (Illustration 2).

2. Locate the heavy-duty billet hold-downs as shown in Illustration 3. Start with the center hold-down and work toward each end and center the rockers. The roller (or pad) on the rocker arm must be centered over the valve stem tip (See Illustration #4). This may require shimming at one or both ends of the hold-down with the included shims. Each rocker arm pair should have .005"/.010" side clearance.

3. Once a hold-down and shim combination is determined, do not switch parts or positions.

4. The centering of the roller tip is very important on the Small Blocks, as it also centers the rocker arm cut out for proper spring and retainer clearance.

5. Position the remaining rockers, hold-downs, shims and spacers as required, working from the center out. Keep all parts in their proper position.

6. With some rocker, spring, valve and retainer combinations, the underside of the rocker arm may touch the top of the retainer on the Small Blocks. If this occurs, use a rocker shaft saddle shim combination to raise the rockers up. .020" clearance is adequate. The clearance will be tightest when the valve is closed (see Illustration #5 at arrow).

Tips: If it becomes necessary to remove material from the ends of the hold-downs, keep the cut as square as possible. De-burr before final assembly. When possible, use a thin spacer between the rocker arm and the hold-down. If your rocker arm manufacturer does not supply spacers, use one of the supplied shims from this hold-down kit. This will minimize wear on the sides of the rocker arms.

Torque specs for the hold-down nuts:	Small Blocks	35 lbs-ft
	Big Blocks	40 lbs-ft

Note: When properly installed, the top of the studs will be flush with the top of the nuts, with no threads exposed on either piece.

Caution: Edelbrock Big Block Victor heads and their clones have been known to split the pedestals on the two outer and center positions. See our website (part number HUG AUTOHEAD610) for a preventative operation.

If you have any questions, contact us!

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