Installing and Adjusting Hughes Hydraulic Lifters #5319 & 5321:

1. **Do not wash in any solvent. Wipe the parts off with a lint free towel.**
2. **Use 10W30 oil and lube the O.D. of the body and wheel.**
3. **Make sure the lifter-to-bore clearance on cast iron blocks is: .0015" - .0017".**
   On aluminum blocks that oil the lifter, the clearance is: .0012" - .0014".
   Both of these measurements are at 70 Deg F.
   The aluminum block will have a higher rate of expansion and that is why the clearance is tighter.

Adjusting the pre-load setting of the Lifter:

1. **Use the firing order to set the valves. Put #1 cylinder on top dead center.**
2. **This puts the int. and exh. to be adjusted on the base circle of the camshaft.**
3. **Select the pre-load needed from the list below.**
   Cast iron block and cast iron heads = .020" - .025"
   Cast block and aluminum heads = .030" - .035"
   Aluminum block and aluminum heads = .045" - .050"
4. **Place a feeler gage blade, chosen from the list above, between the valve tip and and the rocker arm.**
5. **Tighten the adjusting screw, or nut, until you can no longer spin the pushrod by rubbing your finger across it. This is zero ("0") lash.**
6. **Withdraw the feeler gage and note how far you must continue to turn the adjuster screw to reach zero ("0") lash. Now continue to tighten the adjuster screw that same amount to preload the lifter.**
7. **Repeat these adjustments for each cylinder running through the firing order.**

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