



INSTRUCTIONS

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REV. 3-1-95

Kit Number 18507-85

SOLID LIFTER ADAPTER KIT

General

This kit fits Evolution™ 1340cc engines after crankcase number 1585 093 013 and all Evolution™ Sportster engines. These engines have late style tappets. Late style tappets have interim push rod sockets or 1986 style push rod sockets with an orifice disc as shown in Figure 1. Figure 1 also shows an early style push rod socket, from an early style tappet. If your engine has early style tappets, do not use this kit; use Solid Lifter Adapter Kit, Part No. 18500-84.

CAUTION

Do not use this kit with early tappets, production (stock) camshaft, or nonadjustable push rods. Use of solid tappets with production camshaft or push rods will result in engine damage.

This kit contains:	QTY	DESCRIPTION
	4	Tappet spacer ring
	2	Tappet guide gaskets (1340cc)

NOTE

Installation of this kit may void any limited warranty coverage. Installation may affect vehicle emissions and may be illegal for use in vehicles operated on public roads.

Installation

1. Remove push rod covers, push rods, tappet guides and tappets following the applicable Service Manual procedures.

NOTE

Do not attempt to convert the tappets without removing them from the engine. The small parts could drop through the oil drain hole and require removing gear case cover to retrieve them.

2. Remove tappets from tappet guides and mark them so they will be returned to their original locations.
3. See Figure 1. Press down on socket in tappet and remove retaining clip.
4. Remove socket, plunger and spring from tappet.
5. Remove the spring from the tappet plunger. Using a small screwdriver or a pliers, remove the valve assembly from the base of the plunger.
6. Place a spacer ring into the tappet body. Reinstall the plunger, orifice disc, if applicable, and socket. Secure with retaining clip. Do not install spring or valve.
7. Repeat steps 3 thru 6 for the remaining tappets.
8. Install tappets and tappet guides following Service Manual procedures.
9. Install push rods and covers and adjust as follows:

NOTE

Engine must be cold (room temperature). The tappet of the push rod being adjusted must be on the base circle of cam

(lowest position). Turn engine as required to bring tappet to lowest position.

Turn adjuster on push rod until zero clearance exists in valve train. Push rod should turn with slight drag and no up-down "shake."

Tighten locknut.

Install push rod spring cap retainers on push rod covers.

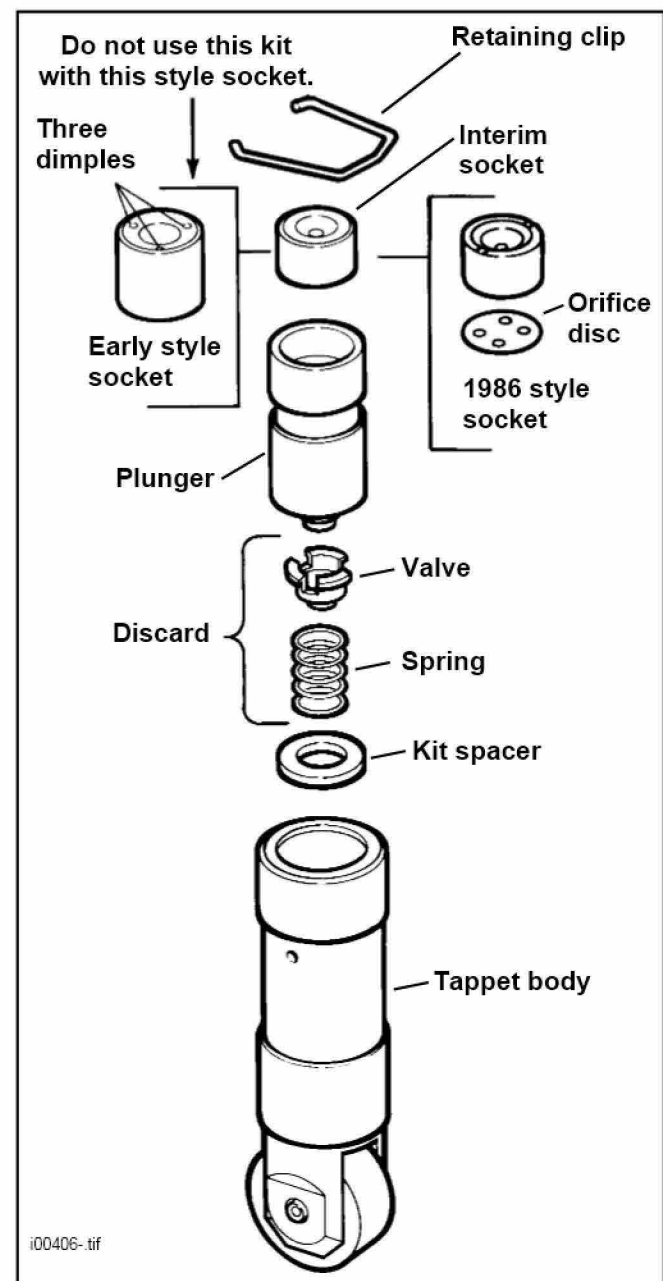


Figure 1. Solid Lifter Assembly