

5QTS
w/FILTER

1970-71

Block # 1231138

10W-30

1231738

BREAK IN OIL
LUCAS

TOM MASEK ENGINEERING
4.350" X 3.900"

R.A 1.69

Date 12-9-13

Job # 455B1

Engine Make BUICK STAGE I Cu. In. 463.68

Bores (1) 4.357" (2) (3) (4)

(5) 4.350" (6) (7) (8)

TME
MARRY

Piston Make J.E. 303687 SRP Size 4.347"

T.A. 16611B

Piston to Wall .004" BTDC Plate 30°

Wrist Pin Make J.E. Size 1.00" X 2.930"

Ring Make XTREME 9905-30 Gap 1st .026" ^{.0015 SIDE} 2nd .018"

-.010" Crank Mains (1) 3.2413" (2) 3.2412" (3) 3.2412" (4) 3.2412" (5) 3.2413"

Crank Rods (1) 2.2393" (3) 2.2393" (5) 2.239" (7) 2.2393"

(2) 2.2393" (4) 2.2393" (6) 2.239" (8) 2.2393"

Block Mains (1) (2) 3.438" (3) 3.439" (4) (5)

Rods (1) (3) (5) (7)

(2) (4) (6) (8)

Crank Mains Clear (1) .0022" (2) .0022" (3) .0022" (4) .002" (5) .0022"

Rods Clear (1) .0022" (3) .002" (5) .0023" (7) .0022"

(2) .0023" (4) .002" (6) .0023" (8) .0022"

Main Bearings - Make SEAL POWER Size 157M/TA1551HP-.010

Rod Bearings - Make SEAL POWER Size 7260CH-10/TA1541HP
.010

Cam Bearings - Make TA 1559

Crank End Play .006" Cam End Play .008"

50LBS
w/LUBE

Rod Bolts ARP 125-6001 Rod Side Play .008" - .012"

Balanced By REUCO

Oil Pump - Make STOCK w/T.A. PARTS Part # MELLINGS K-201 GEAR

Block Decks 10.570" DECKS / .050" OLD PISTONS / .042" DOWN
DOWN

1970 360HP
HEAD # 1231786

TOM MASEK ENGINEERING

Date 12-9-13

Job# 455B1

Cam Make T.A.

Type HYD ROLLER Grind 57692

Degreed At 1.25° A ILC

TA 268-842H-14

Valve Lash

IN Ø

EX Ø

Valve Size

IN 2.125"

EX 1.750"

Valve Make S.I. 4006E/4005E

Type STAINLESS

Valve Guides NEW BRONZE LINED

Valve Seals USS .530" x 3/8" BLUE (MACHINE GUIDES)

Valve Springs Make T.A.

Part# 1125

Valve Springs Set Up - Seat 1.840"

Nose 1.290"

Pressure 145

lbs. Pressure 360

LIFT .550"
lbs.

Heads Type IRON

STOCK

Mill heads .010" off

Head cc 66-67.5

Head Gasket cc N/A

Piston cc -21

True Compression 9.83

MUST USE RACE GAS/91 PUMP GAS MIX

Heads ported by OTHERS / BACK CUT VALVES

Intake Manifold Make BUICK IRON

Type 4 BARRELL

Carb Make ROCHESTER QUADRAJET

Size STOCK

Ignition Make PERTRONIX 1181

Plug Gap .035" AC-RA4TS

Notes: MACHINE HEAD GUIDES TO CLEAR ROLLER INNER SPRINGS

75.5 > 113.75 ILC

CRANK GEAR @ 8° A MAXED OUT

IO - 8° > 211° @ .050"

VALUE DROP

IN. 390" / EX. 375"

IC 39°

EO 44

EC 1.5



TOM MASEK ENGINEERING
 Custom Engines & Dyno Service
 4227 Chase Avenue
 Los Angeles, California 90066
 (310)391-3446

2
 \$ 2262.40
 #455B1

TE: 11-21-13

JOB NAME MARK / JIM

QUANTITY ORDERED	QUANTITY DELIVERED	DESCRIPTION	PRICE	PER	AMOUNT			
1	1	KELLY'S HOT TANK PARTS - MAG - BEAD BLAST PRESS OUT PISTON PINS, FREEZE PLUGS & GASKET SET, INTAKE MANIFOLD GASKET.	383.91	C/T				
1	1					KELLYS HOT TANK - MAG - BEAD BLAST - NEW VALVES COMP VALUE JOB - VALVE GUIDE LINERS MILL HEADS .010"; REMOVE BROKEN BOLTS (3)	761.49	C/T
1	1							
1	1	LINE HONE MAINS	185.-	SP				
1	1	TURN CRANK .010" - .010"	150.-	SP				
1	1	BALANCE	200.-	SP				
1	1	PRESS RODS ON PISTONS	40.-	SP				
1	1	RESIZE BIG ENDS (RODS) W/NEW BOLTS SET ROD BENDING CLEARANCE	200.-	SP				
1	1					BOLTS - HOSES FOR DYNO	32.-	C
1	1	EHAUST PIPES FOR DYNO	50.-	C				
1	1	CHEMICALS & WASTE DISPOSAL	35.-	SP				
			# 2262.40					

No.

INVOICE DATE 7-14-14
CUSTOMER'S ORDER NO. 455 B1

SOLD TO:

SHIP TO:

SALES PERSON	SHIPPED VIA	TERMS	F.O.B.
--------------	-------------	-------	--------

QTY. ORDERED	QTY. SHIPPED	DESCRIPTION	UNIT	AMOUNT
1	1	PARTS SHEET ①		4893.98
1	1	PARTS & OUTSIDE LABOR SHEET ②		2262.40
1	56.5 HRS	SHOP LABOR BUILD COMPLETE } 455CUIN BUICK STAGE I		2260. -
1	7 HRS	DYNO READY ENGINE, HOSES, BELT PIPE PLUGS, EXHAUST SYSTEM		280. -
1	1	DAY AT DYNO		100. -
		TOTAL		9796.38
1	1	CREDIT	-	5000. -
		TOTAL DUE		\$ 4,796. -
		8-5-14		

455 B1

TA PERFORMANCE PRODUCTS
 16167 N. 81st STREET
 SCOTTSDALE, AZ 85260-1806

Invoice

Invoice Number: 88315

Duplicate

Invoice Date: Mar 7, 2014

Voice: 480-922-6807
 Fax: 480-922-6811

Page: 1

Sold To:
 TOM MASEK ENGINES
 4227 CHASE AVE.
 LOS ANGELES, CA 90066

Ship to: TOM MASEK ENGINES
 TOM MASEK ENGINES
 4227 CHASE AVE.
 LOS ANGELES, CA 90066

310-391-3446

Customer ID		Customer PO	Payment Terms		
TOM3446		70455	5126		
Sales Rep ID		Shipping Method	Ship Date	Due Date	
TIM		UPS GROUND	3/7/14	3/7/14	
Quantity	Item	Description	Backorder Qty	Unit Price	Extension
1.00	TA ROI-455-2	455 HYD OR SOLID ROLLER CAM CORE STD FIRING ORDER MUST PURCHASE TA1559 CAM BEARINGS TA1403E.F or G. TAROI 150F NEEDED WORKS W/TA153ARR & CR TSP FUJI PUMPS		398.00	398.00 ✓
1.00	7-GRIND	TA268-84RH-HI 340-210 345-225 115' IS HYD ROLLER		199.00	199.00 ✓
1.00	TA 1412	400-401-425-430-455 SHRIMPED HYDRAULIC ROLLER LIFTER		364.00	364.00 ✓
1.00	TA 1559	HIGH PERF. DUAL GROOVED CAM BEARING 350-400-430-455		68.95	68.95 ✓
1.00	TA ROI 150F	455 FLOATING ROLLER CAM BUTTON KIT		50.00	50.00 ✓
1.00	TA 1403E	455 HARDENED STEEL POINTS DISTRIBUTOR GEAR W/HR ROLL PIN 4895 SHAFT FOR USE WITH STEEL ROLLER CAMS ONLY GM POINTS MAJORY & SOME GM HFI		85.00	85.00 ✓

Check No:

Subtotal

Continued

Sales Tax

Continued

Shipping/Handling

Continued

Total Invoice Amount

Continued

Payment Received

Continued

CHECK YOUR ORDER AND REPORT ERRORS IMMEDIATELY!!

Check out our web site at

WWW.TAPERFORMANCE.COM for parts, prices, information, ordering and email address.

TA PERFORMANCE PRODUCTS
 16167 N. 81st STREET
 SCOTTSDALE, AZ 85260-1806

Invoice

Invoice Number:
 88915

Duplicate

Invoice Date:
 Mar 7, 2014

Voice: 480-922-6807
 Fax: 480-922-6811

Page:
 2

Sold To:
 TOM MASEK ENGINES
 4227 CHASE AVE.
 LOS ANGELES, CA 90066

Ship to: TOM MASEK ENGINES
 TOM MASEK ENGINES
 4227 CHASE AVE.
 LOS ANGELES, CA 90066

316-391-3446

Customer ID		Customer PO	Payment Terms		
TOM3446		70455	5126		
Sales Rep ID		Shipping Method	Ship Date	Due Date	
TIM		UPS GROUND	3/7/14	3/7/14	
Quantity	Item	Description	Backorder Qty	Unit Price	Extension
1.00	TA 1125	DUAL VALVE SUPER SPRINGS 125# 400-430-455		130.00	130.00 ✓
1.00	TA 1450	11' 3/8" CHROME MOI Y STEEL RETAINERS (SET OF 16)		69.95	69.95 ✓
1.00	TA 1434	264-322-350-364-400-401-425-430-4 55 VALVE KEEPERS (SET 32 PCS)		29.00	29.00 ✓
1.00	TA 1611R	455 20cc SPHERICAL SRP FORGED PISTON 038 - 4 350 BORE USE TA R979R PISTON RING SET		695.00	695.00 ✓
1.00	TA 151R	REAR MAIN SEAL - DIRECT FIT NEOPRENE 400-430-455		16.95	16.95 ✓
1.00	TA 1514	STOCK REPL NEO FRONT COVER SEAL 364-400-401-425-430-455 (NOT FOR TA COVER)		15.00	15.00 ✓
1.00	TA 1551HP-ST	HIGH PERF. MAIN BEARINGS. STD 400-430-455		125.00	125.00 ✓
1.00	TA 1541HP-ST	HIGH PERF ROD BEARINGS STANDARD 364-401-425-430-455		95.00	95.00 ✓
1.00	TA 1534RR	400-430-455 STD 1 FUEL PUMP TO BE USED WITH TA ROI-455-2 & 455-3 STEEL ROLLER CAMS		49.95	49.95 ✓

Check No:

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Subtotal

Sales Tax

Shipping/Handling

Total Invoice Amount

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Continued

Continued

Continued

TA PERFORMANCE PRODUCTS
 16167 N. 81st STREET
 SCOTTSDALE, AZ 85260-1806

Invoice

Voice: 480-922-6887
 Fax: 480-922-6811

Duplicate

Invoice Number: 88315

Invoice Date: Mar 7, 2014

Page: 3

Sold To:
 TOM MASEK ENGINES
 4227 CHASE AVE.
 LOS ANGELES, CA 90066

Ship to: TOM MASEK ENGINES
 TOM MASEK ENGINES
 4227 CHASE AVE.
 LOS ANGELES, CA 90066

930-391-3446

Customer ID		Customer ID	Payment Terms		
TOM 3446		70455	5126		
Sales Rep ID		Shipping Method	Ship Date	Due Date	
TIM		UPS GROUND	3/7/14	3/7/14	
Quantity	Item	Description	Backorder Qty	Unit Price	Extension
1.00	TA 1317HD	400-430-455 HEAVY DUTY SHAFTS & ROCKER ARM KIT W/ NYLON BUTTONS		215.00	215.00 ✓
1.00	TA 1509	HEAVY DUTY OIL PUMP PRIMER		25.00	25.00 ✓
		WILL RUN TA STRK HEAVY DUTY ROCKER ASSEMBLY			
		SHIP COMPLETE CALL TOM WHEN SHIPPING			
#2694.80					

Check No:

Subtotal

2,630.80

Sales Tax

CHECK YOUR ORDER AND REPORT ERRORS IMMEDIATELY!!

Check out our web site at

Shipping/Handling

64.00

WWW.TAPERFORMANCE.COM for parts, prices,

Total Invoice Amount

2,694.80

**PLEASE!!
INSPECT PACKAGE IMMEDIATELY**

#45581

RETURN MERCHANDISE POLICY

No merchandise may be returned for any reason unless prior authorization has been obtained from TA Performance. This RGA# is good for 30 days from the date issued. All shipments approved for return must be accompanied by the original invoice. A minimum of 15% service charge may be deducted on all returned merchandise, except in case of factory error.

ALL SHORTAGES/ DAMAGES MUST BE REPORTED WITHIN 5 DAYS OF RECEIPT OF ORDER

Invoice

Invoice Number: 89219

Invoice Date: Apr 29, 2014

Page: 1

5000 101
TOM MASEK ENGINES
4227 CHASE AVE.
LOS ANGELES, CA 90066

Ship to TOM MASEK ENGINES
TOM MASEK ENGINES
4227 CHASE AVE.
LOS ANGELES, CA 90066

810-391-2445

Customer ID		Customer PO	Payment Terms		
TOM3446			5126		
Sales Rep ID		Shipping Method	Ship Date	Due Date	
574074		UPS GROUND		4/29/14	
Quantity	Item	Description	Backorder Qty	Unit Price	Extension
1.00	TA 700A	PETRONIX IGNITOR CONVERSION KIT FOR ALL BUICK V6'S NEED 9V USE 1 4-1 5ohms COIL. TA700D. 700DBL.		84.95	84.95
1.00	TA 700DBL	TAMAI 29217 29219 29450 CON S PERTRONIX FLAME THROWER		40.00	40.00
1.00	TA 705F	40.000 VOLT 1.5ohms COIL. BLACK VAC ANV MODIFI FOR GM		25.00	25.00
1.00	TA 706C	POINTS DISTRIBUTOR		2.00	2.00
1.00	TA 706R	FELT SHAFT SEAL RETAINER FOR GM HEI & POINTS DISTRIBUTOR		2.95	2.95
1.00	TA 706D	PLASTIC SHAFT SEAL RETAINER FOR GM HEI & POINTS DISTRIBUTOR		1.25	1.25
1.00	TA 809D	GEAR SHIM (.000) FOR GM HEI & POINTS DISTRIBUTOR**		15.00	15.00
1.00	TA 1240	REPLACEMENT DIST CAP FOR GM ROVI POINTS DIST *BLACK*		8.00	8.00
1.00	TA 1531B	ENGINE ENAMEL BUICK RED		499.00	499.00
1.00	7-CATALOG	400-430-455 TIMING COVER (TA)		5.05	5.05
1.00	DISCOUNT	CATALOG OF PARTS & PRICES		5.05	-5.05
		DISCOUNT FOR SALE ITEMS			

Check No:

Subtotal

676.95

Sales Tax

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Shipping/Handling

29.45

Check out our web site at WWW.TAPERFORMANCE.COM for parts, prices, information, ordering and email address.

Total Invoice Amount

707.00

Payment Received

0.00

707.00

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RETURN MERCHANDISE POLICY

No merchandise may be returned for any reason unless prior authorization has been obtained from TA Performance. This RGA# is good for 30 days from the date issued. All shipments approved for return must be accompanied by the original invoice. A minimum of 15% service charge may be deducted on all returned merchandise, except in case of factory error.

**ALL SHORTAGES/ DAMAGES MUST BE REPORTED
WITHIN 5 DAYS OF RECEIPT OF ORDER**

#455 B1

Invoice

Invoice Number: 89057

Invoice Date: Apr 21, 2014

Page: 1

SOLO TO:
TOM MASEK ENGINES
4227 CHASE AVE.
LOS ANGELES, CA 90066

Ship to: TOM MASEK ENGINES
TOM MASEK ENGINES
4227 CHASE AVE.
LOS ANGELES, CA 90066

310-391-3446

Customer ID		Customer PO	Payment Terms		
TOM 3446			5126		
Sales Rep ID		Shipping Method	Ship Date	Due Date	
TIM		LPS GROUND		4/21/14	
Quantity	Item	Description	Backorder Qty	Unit Price	Extension
1.00	TA 1551HP-01	HIGH PERF. MAIN BEARINGS. .010 400-430-455		125.00	125.00
1.00	TA 1541HP-01	HIGH PERF ROD BEARINGS .010. 364-401-425-430-455		95.00	95.00

Check No:

Subtotal 220.00

Sales Tax

Shipping/Handling 23.65

Total Invoice Amount 243.65

Payment Received 0.00

TOTAL 243.65

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#455B1

TA PERFORMANCE PRODUCTS
 16167 N. RIND STREET
 SCOTTSDALE, AZ 85260-1806

Invoice

Voice: 480-922-6807
 Fax: 480-922-6811

Invoice Number: 89006

Sold To:
 TOM MASEK ENGINES
 4227 CHASE AVE.
 LOS ANGELES, CA 90086

Ship to: TOM MASEK ENGINES
 TOM MASEK ENGINES
 4227 CHASE AVE.
 LOS ANGELES, CA 90086

Invoice Date: Apr 16, 2014
 Page: 1

310-391-3446

Customer ID		Customer PO	Payment Terms		
TOM 3446		455 BU	5/126		
Sales Rep ID		Shipping Method	Ship Date	Due Date	
SHERRI		UPS GROUND		4/16/14	
Quantity	Item	Description	Backorder Qty	Unit Price	Extension
1.00	TA 1524	HI PERFORMANCE STEEL BILLET		150.00	150.00
1.00	TA 1508	DOUBLE FROILER 400-430-455			
1.00	TA 1510	OIL PUMP STOCK REPLACEMENT KIT. 400-430-455		34.95	34.95
1.00	TA 1502	OIL PUMP BOOSTER PLATE KIT 300-340-350-400-430-455-196-215-225-231-252- (4.16) V6		24.95	24.95
1.00	TA 1704	ADJUSTABLE OIL PRESSURE REGULATOR		19.95	19.95
1.00	TA 1704	OIL PUMP SHIM KIT. ALL EXCEPT NAIL HEAD 7MM IAP. 001 0015 002 003 005 0075 010 2 PAPER: 005 008		20.59	20.59

Check No:

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Subtotal	250.44
Sales Tax	
Shipping/Handling	25.00
Total Invoice	275.44

455B1

1 of 3

TA PERFORMANCE PRODUCTS
 16167 N. 81st STREET
 SCOTTSDALE, AZ 85260-1806

Invoice

Invoice Number:
88215

Duplicate

Invoice Date:
Mar 7, 2014

Page:
1

Voice: 480-922-8807
 Fax: 480-922-6811

Sold To:
 TOM MASEK ENGINES
 4227 CHASE AVE.
 LOS ANGELES, CA 90066

Ship to: TOM MASEK ENGINES
 TOM MASEK ENGINES
 4227 CHASE AVE.
 LOS ANGELES, CA 90066

910-991-3446

Customer ID		Customer PO	Payment Terms		
TOM3446		70455	5126		
Sales Rep ID		Shipping Method	Ship Date	Due Date	
TIM		UPS GROUND	3/7/14	3/7/14	
Quantity	Item	Description	Backorder Qty	Unit Price	Extension
1.00	TA ROI-455-2	455 HYD OR SOLID ROLLER CAM CORE STD FIRING ORDER MUST PURCHASE TA1559 CAM BEARINGS.TA1403E.F or G. TAROI 150F NEEDED WORKS W/TA153ARR & OR TSP FUEL PUMPS		399.00	399.00 ✓
1.00	Z-GROUND	TA268-840H-HI 340-210 345-225 115 IS HYD ROLLER		199.00	199.00 ✓
1.00	TA 1412	400-401-425-430-455 SHR GINED HYDRAULIC ROLLER LIFTER		364.00	364.00 ✓
1.00	TA 1559	HIGH PERF. DUAL GROOVED CAM BEARING 350-400-430-455		68.95	68.95 ✓
1.00	TA ROI 150F	455 EL COATING ROLLER CAM BUTTON KIT		50.00	50.00 ✓
1.00	TA 1403E	455 HARDENED STEEL POINTS DISTRIBUTOR GEAR WITH ROLLER PIN 4895 SHAFT FOR USE WITH STEEL ROLLER CAMS ONLY GM POINTS MALORY & SOME GM HFI		85.00	85.00 ✓

Check No:

Subtotal

Continued

Sales Tax

Continued

Shipping/handling

Continued

Total Invoice Amount

Continued

Payment Received

Continued

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Continued

TA PERFORMANCE PRODUCTS
 16187 N. 81st STREET
 SCOTTSDALE, AZ 85260-1806

Invoice

Invoice Number: 58315

Duplicate

Invoice Date: Mar 7, 2014

Voice: 480-922-6807

Fax: 480-922-6811

Page: 2

Sold To:
 TOM MASEK ENGINES
 4227 CHASE AVE.
 LOS ANGELES, CA 90066

Ship to: TOM MASEK ENGINES
 TOM MASEK ENGINES
 4227 CHASE AVE.
 LOS ANGELES, CA 90066

310-391-3436

Customer ID		Customer PO	Payment Terms		
TOM 3446		70455	5126		
Sales Rep ID		Shipping Method	Ship Date	Due Date	
TIM		UPS GROUND	3/7/14	3/7/14	
Quantity	Item	Description	Backorder Qty	Unit Price	Extension
1.00	TA 1125	DUAL VALVE SUPER SPRINGS 125# 400-430-455		130.00	130.00 ✓
1.00	TA 1450	11' 3/8" CHROME MOLY STEEL RETAINERS (SET OF 16)		69.95	69.95 ✓
1.00	TA 1434	264-322-350-364-400-401-425-430-4 55 VALVE KEEPERS (SET 32 PCS)		29.00	29.00 ✓
1.00	TA 1611B	455 20cc SPHERICAL SRP FORGED PISTON 028 - 4 350 BORE USE TA R9798 PISTON RING SET		695.00	695.00 ✓
1.00	TA 1516	REAR MAIN SEAL - DIRECT FIT NEOPRENE 400-430-455		16.95	16.95 ✓
1.00	TA 1514	STOCK REPL NEO FRONT COVER SEAL 364-400-401-425-430-455 (NOT FOR TA COVER)		15.00	15.00 ✓
1.00	TA 1551HP-ST	HIGH PERE. MAIN BEARINGS. STD 400-430-455		125.00	125.00 ✓
1.00	TA 1541HP-ST	HIGH PERE. ROD BEARINGS STANDARD 364-401-425-430-455		95.00	95.00 ✓
1.00	TA 1534BR	400-430-455 STD 1 FUEL PUMP TO BE USED WITH TA ROI-455-2 & 455-3 STEEL ROLLER CAMS		49.95	49.95 ✓

Check No:

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 information, ordering and email address.

Subtotal	Continued
Sales Tax	Continued
Shipping/Handling	Continued
Total Invoice Amount	Continued
Payment Received	Continued

TA PERFORMANCE PRODUCTS
 16167 N. 81st STREET
 SCOTTSDALE, AZ 85260-1906

Invoice

Voice: 480-922-6887
 Fax: 480-922-6611

Duplicate

Invoice Number: 68315

Invoice Date: Mar 7, 2014

Sold To:
 TOM MASEK ENGINES
 4227 CHASE AVE.
 LOS ANGELES, CA 90066

Ship to: TOM MASEK ENGINES
 TOM MASEK ENGINES
 4227 CHASE AVE.
 LOS ANGELES, CA 90066

Page: 3

310-991-9446

Customer ID		Customer PO	Payment Terms		
TOM3446		70455	5126		
Sales Rep ID		Shipping Method	Ship Date	Due Date	
TIM		LIPS GROUND	3/7/14	3/7/14	
Quantity	Item	Description	Backorder Qty	Unit Price	Extension
1.00	TA 1317HD	400-430-455 HEAVY DUTY SHAFTS & ROCKER ARM KIT W/ NYLON BUTTONS		215.00	215.00 ✓
1.00	TA 1509	HEAVY DUTY OIL PUMP PRIMER		25.00	25.00 ✓
		WILL RUN TA 5TK HEAVY DUTY ROCKER ASSEMBLY			
		SHIP COMPLETE CALL TOM WHEN SHIPPING			
#2694.80					

Check No:

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Subtotal	2,630.80
Sales Tax	
Shipping/Handling	64.00
Total Invoice Amount	2,694.80
Discount/Enclosed	0.00



455B1

936699

PISTON PART # TA 1611B 8

ENGINE BUICK 455

BUICK 455

PISTON TYPE INV SPHERCL

BORE 4.350

COMP. DIST. 1.980

.280 15 DEG

.280 15 DEG

	Groove	Land	Radial Depths
TOP	.064	.290	.210
2ND	.064	.145	.205
OIL	.188	.085	.2125

PIN DIA. 1.000

PIN LENGTH 2.930

LOCK TYPE DBL TRUE ARC

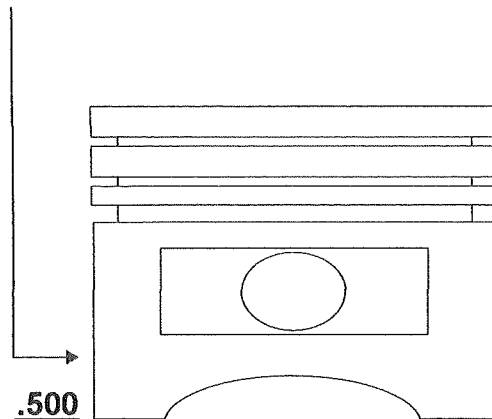
PISTON WEIGHT 702 GRAMS

IMPORTANT CLEARANCE INFORMATION GUIDELINES ONLY

SET CLEARANCE TO: .0030

Some applications may require more clearance. Measure piston diameter .500 from bottom of piston skirt.

CORRECT PISTON INSTALLATION IS THE RESPONSIBILITY OF THE CUSTOMER



ALL SPECIFICATIONS ARE SUBJECT TO MANUFACTURERS TOLERANCES

TA PERFORMANCE PRODUCTS, INC.

480-922-6807

www.TAPERFORMANCE.com

#455B1

REVCO BALANCING
LONG BEACH, CA

ENGINE 455 Buick

PISTON 858.5

WRIST PIN 1P Piston WS.

RINGS 52.3

SUPPORT RAIL N/A

PIN LOCKS PRESS FIT

TOTAL ROD 736.0

ROT ROD 496.0

BEARING 51.0

BOB WEIGHT 2253.8

All weights listed in grams

DATE 6-10-14

JOB NUMBER 214261

562-428-7481

www.revcoprecision.com

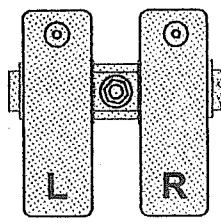
HD

#455B1

TA 1317 Rocker Installation

When assembling shafts (looking at it from the middle of the engine), the left rocker goes to the left of the rocker stand, the right rocker goes to the right of the rocker stand.

350 & 400-430-455 Rocker Orientation



PASSENGER'S SIDE							
2	4	6	8				
RH LH	RH LH	RH LH	RH LH				
DRIVER'S SIDE							
1	3	5	7				
LH RH	LH RH	LH RH	LH RH				

#455B1

3/11/03

TA 1559

GROOVED CAM BEARINGS

- With the block right side up, install the bearings so the oil feed holes are at the 3 and 7 o'clock position when viewed from the front of the block. **CALLED TIM TA TECH**
- For best cam break-in use a light weight oil such as 0-W30, 5-W30, or 10-W30. Use of lighter weight oils ensures quicker circulation than heavier oils.

QTY. 16 #455B1 ORDER # 56553

LENGTH 8.750 8.725 OA EL

PART NO. NH58BBB

5/32 RADIUS B RADIUS

FRONT

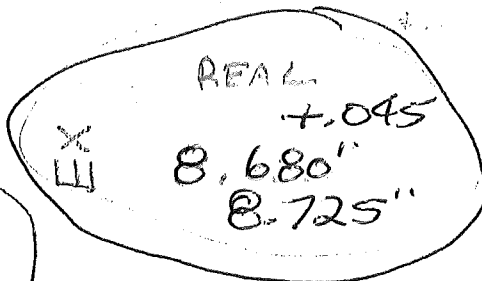
REAL

8.705"
8.750"

+ .045"

8.720"

8.750" + .030"

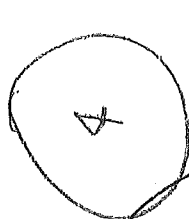


8.705" 8.750"
+ .045"

8.715"

8.750" + .035"

8.715" + .035"



8.720"
+ .030"
8.750"

8.685" + .040"
8.725"

8.700"
8.750"
+ .050"



8.700" 8.750"
+ .050"

8.750"
8.725"
+ .025"

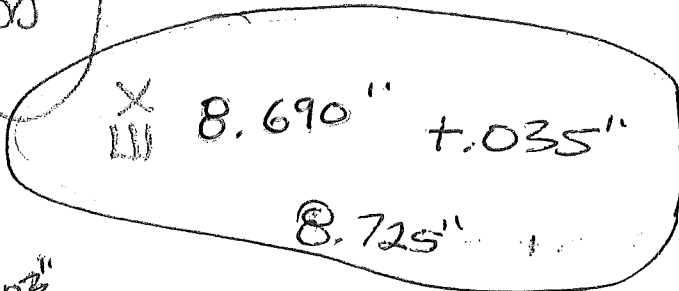
8.710" 8.750"
+ .040"

8.750"
8.708"
+ .042"



8.715" 8.750"
+ .035"

8.700"
8.750"
+ .050"



13 - 8.750"
3 - 8.725"
5/16 + .033"

PUSHROD LENGTHS

1
2
3
4
5
6
7
8
9
10
11
12

#45581



(480) 922-6808 16167 N. 81st St.
 FAX (480) 922-6811 Scottsdale, AZ 85260

CAM SPECIFICATIONS

Grind 57692
 Make Buck
 Engine 455
 Lobe Separation 115
 Part No. TA 268-8484-4L

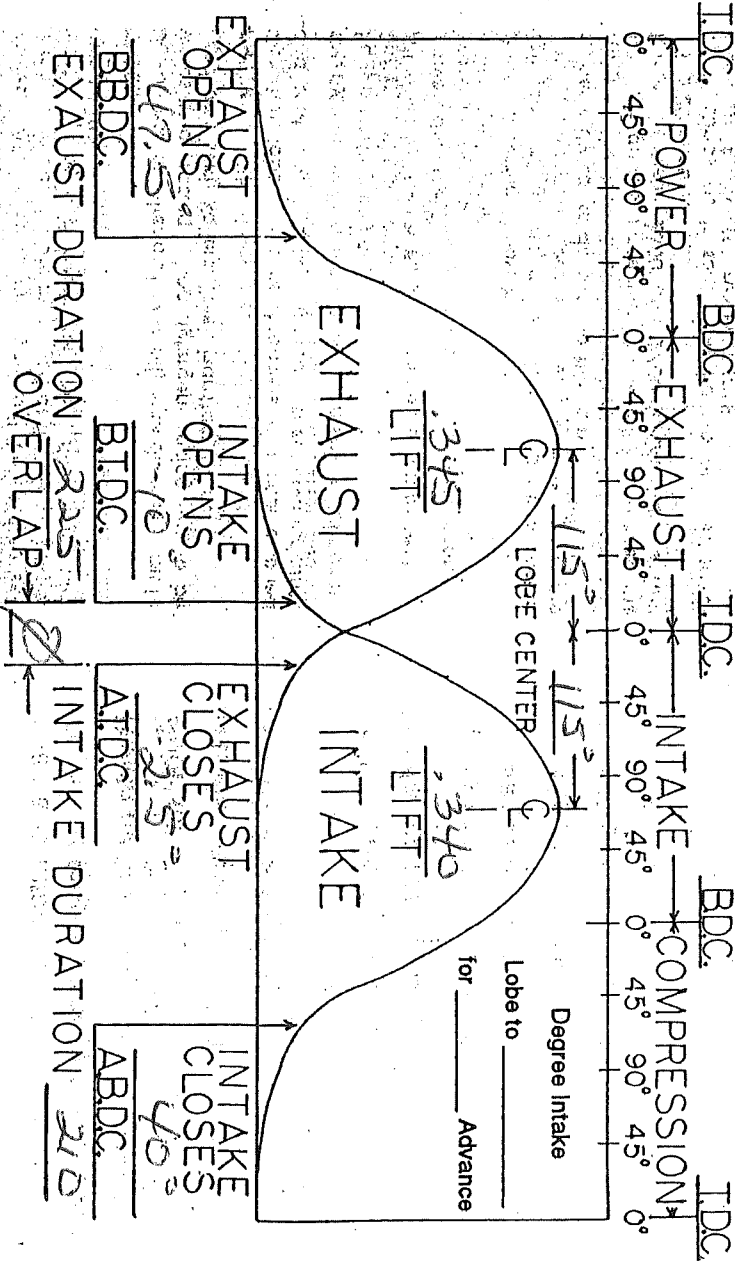
INTAKE EXHAUST

Lift x 1.6 .544 .552
 Duration 268 284
 Valve Lash — —
 Open 19° 77°
 Close 69° 27°

Recommended Spring Pressure

Open — Closed —
 Recommended Spring Part No. —
 Retainer Part No. —

DATA FOR DEGREEING CAM AT .050 TAPPET RISE



Duration on the graph is given at .050. Lift is lobe lift. All degrees are in crankshaft degrees. Timing data is shown at split overlap. In most applications the cam is run at 2 to 6 degrees advanced. To obtain cam timing, add the amount of advance to the opening figures. Subtract equal amount from the closing figures.

Use new tappets on a new cam. If cam or tappets are removed from the engine, tappets must be re-tuned to their original bosses.

CHECK
 Date on timing tag agrees with that on cam.

CHECK
 On engines with stud type rockers, rocker arm slot to stud clearance. Both ends of slot to stud must be checked, pushrod side with valve closed. Valve side with valve at full lift. This can be done with a paper clip or wire solder. Slot can be lengthened with a die grinder and stone.

CHECK
 Rocker arms, balls, trunnions or shafts. If galled, burnt or heat checked replace with new parts.

CHECK
 Rocker arms to valve cover clearance. Sit valve cover on engine without gasket, with valve train adjusted. Rotate engine, there should be no movement of valve cover.

CHECK
 Rocker to retainer clearance, through full lift cycle .060 minimum.

CHECK
 Springs for proper fit on spring seat, some seats must be machined to remove step or to increase O.D. of seat. Alloy heads must have hardened seat washers washers or bottom retainers.

CHECK
 All retainers for proper installed height ± .020. Shim to be installed in spring seat on head if needed.