

Dart  **180 SBC 23° Iron Cylinder Head**

Part#	10110010 thru 10220010
Material:	Superior Iron alloy
Comb Chambers:	64cc & 72cc
Intake Valve Dia:	2.02"
Intake Port volume:	180cc
Intake Port Dim:	1.920"x 1.120"
Int Port Location:	Stock
Intake Gasket:	Fel-Pro # 1204
Exh Valve Dia.:	1.600"
Exh Port volume:	77cc
Exhaust Port Dim:	1.350" x 1.400" w
Exh Port Location:	Stock location & bolt pattern
Exhaust Gasket:	Fel-Pro# 1404
Flow, Intake:	222cfm @ .500" lift / 28"
Flow, Exhaust:	175cfm @ .600" lift / 28"
Head Bolts:	Dart bolt kit PN# 66220011
Head Studs:	Dart stud kit PN# 66120011
Manifold:	Dart Alum Dual Plane PN# 42811000
Milling:	Min. 58cc = .060" (.0065" = 1cc) Flat Mill Angle mill .125" safely / .200" = 49cc 1.5° (carefully)
Pistons:	Most 23° aftermarket pistons.
Push Rod length:	Stock (Stock length = 7.800")
Push Rod Guide Plate:	Dart adjustable guide Plate PN# 27001410
Retainers:	Steel 1.250" = (7°) 1.437" = (10°)
Spark Plug:	Angle or straight, .460" reach, tapered seat
Spring Cups:	None
Spring Pockets:	1.550" OD (.030" deeper max)
Springs:	Our Assembly: 1.250S = 110# @ 1.700" / .520" max 1.437D = 130# @ 1.800" / .620" max
Valve Angles:	23°
Valve Length:	STD = 4.890"
Valve Stem Dia:	.3415" - 11/32"
Valve Train:	STD SBC 3/8" stud mount
Valve Guides:	.439" OD In = Mag-bronze Ex. = Mag-bronze (.002" press)
Valve Guide length:	1.950"
Valve Guide clearance:	.0014" - .002" (with our .3415 dia. valve stem)
Valve Guide Spacing:	1.890" moved .030" from stock
Valve Seats:	Ex. = Powdered Metal, .006" press
Valve Seat dim.	Ex. - 1.650" x 1.350" x .350"
Valve Seat angles:	In = 32° - 45° - 60° - 70°-80° Ex. = 37° - 45° - radius
Stud Girdle:	Dart PN# 64110002
Torque: w/oil	Head Bolts = 70 ft/lb Rocker Studs = 55 ft/lb Manifold = 35 ft/lb
Block Use:	Any SBC Iron or Aluminum
Weight:	52 lbs Bare – 58 lbs Assembled