

**DART** 18° Big Chief **PRO 1** Aluminum Cylinder Head

<b>Part#</b>	18474030 - 18475136
<b>Material:</b>	355-T61 alum alloy
<b>Comb Chambers:</b>	95cc w/ Titanium 100cc w/ SS
<b>Intake Valve Dia:</b>	2.400"
<b>Intake Port volume:</b>	424cc
<b>Intake Port Dim:</b>	1.890" x 2.530"
<b>Int Port Location:</b>	Raised 1.500" Spread ports
<b>Intake Gasket:</b>	Fel-Pro # 1298 or Dart # 65124101 (.060")
<b>Exh Valve Dia.:</b>	1.900"
<b>Exh Port volume:</b>	185cc
<b>Exhaust Port Dim:</b>	2.100" x 1.800"
<b>Exh Port Location:</b>	Raised .900" STD Chevy bolt pattern
<b>Exhaust Gasket:</b>	Mr. Gasket 5914
<b>Flow, Intake:</b>	455 cfm @ .900" lift/28" SS valve / 1020 bench
<b>Flow, Exhaust:</b>	325 cfm @.900" lift/28" " "
<b>Manifold:</b>	Dart Big Chief (opening - 1.750"x 2.350") 8.00" tall
<b>Milling:</b>	Min. 85cc / .020" max (.006" = 1cc) Flat mill only.
<b>Pistons:</b>	Must use pistons for 18° Big Chief.
<b>Push Rod length:</b>	Should always measure
<b>Retainers:</b>	Titanium 10°
<b>Spark Plug:</b>	.750" reach, gasketed. Autolite AR3932
<b>Spring Cups:</b>	1.625" - .035 cup
<b>Spring Pockets</b>	1.740" OD for 1.625" cup (.030" deeper max)
<b>Springs:</b>	Our Assembly: 1.625D = 275# @ 2.000" / .850" max Optional triple: 1.650T = 338# @ 2.100" / .900" max
<b>Valve Angles:</b>	Int - 18°, Exh - 9°, 4° cant
<b>Valve Length:</b>	Int - 6.600" Exh - 6.450" Our assemblies w/ SS – 6.380"
<b>Valve Stem Dia:</b>	.3415" - 11/32" 5/16 optional
<b>Valve Train:</b>	Jesel or T&D rocker system
<b>Valve Guides:</b>	1/2" OD Mag - bronze Cut for .500" PC seals (.002" press)
<b>Valve Guide length:</b>	3.000"
<b>Valve Guide clearance:</b>	.0014" - .0021" (with our .3415 dia. valve stem)
<b>Valve Guide Spacing:</b>	Widened for use on min. 4.500" bore
<b>Valve Seats:</b>	Ductile Iron, .006" press
<b>Valve Seat dim.</b>	Int. - 2.490" x 2.000" x .375" Exh - 2.000" x 1.600" x .375"
<b>Valve Seat angles:</b>	Int = 32° - 45° - 60° - 70° - 80° Exh = 37° - 45° - radius
<b>Studs, head:</b>	Must use Big Chief stud kit #66120015
<b>Titanium Valves</b>	Must use lash caps
<b>Torque:</b>	Head Bolts = 70 ft/lb Dart's inner head studs 3/8-7/16 = 50 ft/lb Manifold = 35 ft/lb
<b>Block Use:</b>	Dart Big M, Mark IV, Gen V, and Gen VI with proper head gasket
<b>Weight:</b>	42 lbs