

**Dart**  **215cc Ford Iron Cylinder Head**

<b>Part#</b>	13500020-13521123
<b>Material:</b>	Superior Iron Alloy
<b>Comb Chambers:</b>	58cc and 62cc
<b>Intake Valve Dia:</b>	2.050"
<b>Intake Port volume:</b>	215cc
<b>Intake Port Dim:</b>	2.125" x 1.240"
<b>Int Port Location:</b>	Stock location
<b>Intake Gasket:</b>	Fel Pro 1262
<b>Exh Valve Dia.:</b>	1.600"
<b>Exh Port volume:</b>	72cc
<b>Exhaust Port Dim:</b>	1.325" x 1.325"
<b>Exh Port Location:</b>	stock
<b>Exhaust Gasket:</b>	Fel Pro 1486
<b>Flow, Intake:</b>	306 CFM @ .700" lift
<b>Flow, Exhaust:</b>	204 CFM @ .700" lift
<b>Head Bolts:</b>	Dart PN# 66230010 (7/16" w/inserts) Dart PN# 66230011 (Std 1/2")
<b>Head Studs:</b>	Dart PN# 66130021
<b>Manifold:</b>	Conventional SBF
<b>Milling:</b>	Flat= .006" per cc / Angle milling= .0075 per cc
<b>Pistons:</b>	Most SBF 20° aftermarket pistons
<b>Push Rod length:</b>	Should always measure
<b>Push Rod Guide Plate:</b>	Dart Adjustable PN# 27001410
<b>Retainers:</b>	Steel (10°)
<b>Spark Plug:</b>	.460" reach tapered seat
<b>Spring Cups:</b>	N/A
<b>Spring Pockets:</b>	Cut to accept up to 1.550" springs, not recommended to cut deeper
<b>Springs:</b>	Our Assembly: 1.437D = 130# 1.800" 1.550D = 215# 1.900"
<b>Valve Length:</b>	Std. = 4.890" / 5.015" (+.100) roller
<b>Valve Stem Dia:</b>	11/32" .3415"
<b>Valve Train:</b>	Standard Stud mounted 3/8" rockers
<b>Valve Guide:</b>	.439" O.D. Mag-Bronze (.002" Press)
<b>Valve Guide length:</b>	2.000"
<b>Valve Guide clearance:</b>	.0014"-.002" with Dart .3415" diameter valve
<b>Valve Guide Spacing:</b>	1.890"
<b>Valve Seats:</b>	Powdered Metal (Exhaust Only)
<b>Valve Seat dim.</b>	1.650" x 1.350" x .350"
<b>Valve Seat angles:</b>	Intake: 32° 45° 60° 70° 80° Exhaust: 37°- 45° Radius
<b>Stud Girdle:</b>	Jomar Performance # 1123
<b>Torque:</b>	Rocker Studs 45ft. lbs. Intake Manifold 35ft. lbs. Head Bolt torque to OEM spec.
<b>Block Use:</b>	Dart I.E, Sportsman or SHP
<b>Weight:</b>	49lbs bare – 56lbs assembled