Dart FORD PRO1 *225 CNC* 20° Aluminum Cylinder Head

Part#	13072040 – 13072143
Material:	355-T61 alum alloy
Comb Chambers:	62cc
Intake Valve Dia:	2.08”
Intake Port volume:	225cc
Intake Port Dim:	2.150”x 1.300”
Int Port Location:	Stock
Intake Gasket:	Fel-Pro# 1262
Exh Valve Dia.:	1.600”
Exh Port volume:	87cc
Exhaust Port Dim:	1.420” x 1.420” w
Exh Port Location:	Raised .135” Spread bolt pattern / SVO (3.00” bolt centers)
Exhaust Gasket:	Fel-Pro # 1487
Flow, Intake:	325 cfm @ .700” lift / 28”
Flow, Exhaust:	235 cfm @ .700” lift / 28”
Head Bolts:	Dart PN# 66230010 (7/16 w/ inserts)
	Dart PN# 66230011 (Std. ½”)
Head Studs:	Dart PN# 66130021
	302 block 1/2"-7/16” stepped washer ARP# 154-4005
Manifold:	Most with STD port location
Milling:	Min. 50cc (.0065” = 1cc) Flat Mill
Pistons:	Most 20°aftermarket pistons.
Push Rod length:	Should measure
Push rod Guide Plate:	Dart adjustable PN# 27001410
Retainers:	Steel (10°)
Spark Plug:	.750” reach, gasketed, Autolite AR3933
Spring Pockets:	1.550” OD (.030” deeper max)
Springs:	Our Assembly: 1.437D = 130# 1.800”
	1.550D = 215# 1.900”
Valve Length:	STD 4.890” / 5.015” (+.100)
Valve Stem Dia:	.3415” - 11/32”
Valve Train:	STD SBF 3/8” or 7/16” stud mount
Valve Guides:	1/2” OD Mag-bronze (.002” press)
Valve Guide length:	2.080”
Valve Guide clearance:	.0014” - .002” (with our .3415 dia. valve stem)
Valve Guide Spacing:	1.876” exh moved .050” from stock
Valve Seats:	Powdered metal, .006” press
Valve Seat dim.	Int - 2.160x 1.810 x .350 ex - 1.650x 1.350x .350
Valve Seat angles:	Int = 32°- 45°- 60°- 70°-80° Ex = 37°- 45°- radius
Stud Girdle:	Jomar Performance #1123
Torque:	Head Bolts 7/16” = 70 ft/lb 1/2" = 100 ft/lb
	Rocker Studs = 45 ft/lb Manifold = 18 ft /lb
Block Use:	Dart Iron or Aluminum & any Ford
Weight:	23 lbs bare – 26 lbs assembled