

## Dart 310, 325, 345 BBC Aluminum Cylinder Head

<b>Part#</b>	19100000, 19200000, 19300000
<b>Material:</b>	355-T61 alum alloy
<b>Comb Chambers:</b>	121cc
<b>Intake Valve Dia:</b>	(310) 2.250" (325) 2.250"/2.300" (345) 2.300"
<b>Intake Port Dim:</b>	1.700" x 2.430"
<b>Int Port Location:</b>	Stock
<b>Intake Gasket:</b>	Mr. Gasket# 121
<b>Exh Valve Dia.:</b>	1.880"
<b>Exh Port volume:</b>	129cc
<b>Exhaust Port Dim:</b>	1.650" x 1.800"
<b>Exh Port Location:</b>	Raised .300" STD bolt pattern
<b>Exhaust Gasket:</b>	Fel-Pro 1412
<b>Exhaust Bolts:</b>	1" longer than stock (4) ea.
<b>Flow, Intake:</b>	(310) 369 cfm (325) 376 cfm (345) 397 cfm @.800 lift/28"
<b>Flow, Exhaust:</b>	266 cfm @.800 lift/28"
<b>Head Bolts/studs;</b>	Bolts – ARP# 135-3603 Studs – ARP# 235-4103
<b>Manifold:</b>	Rect. Port Dart (opening - 1.575"x 2.250") 6.25" tall
<b>Milling:</b>	Min. 108cc. (.005" = 1cc) Flat mill only.
<b>Pistons:</b>	Most aftermarket pistons.
<b>Push Rod length:</b>	Avg. +.200" / +.250" Should always measure Stock length Int. = 8.275" / Exh = 9.250"
<b>Push Rod Guide Plate</b>	Must use Dart adjustable PN# 27001230-4
<b>Retainers:</b>	1.625" - Tit / 1.550" - Moly Steel (10°)
<b>Spark Plug:</b>	.750" reach, gasketed. Autolite Ar3933 Street AR3924
<b>Spring Cups:</b>	1.625" - .035 cup / 1.550" - ID locator
<b>Spring Pockets</b>	1.740" OD for 1.625" cup (.030" deeper max)
<b>Springs:</b>	Our Assembly: 1.550S = 145# @ 1.900" / .660" max 1.550D = 195# @ 1.900" / .650" max 1.625D = 275# @ 2.000" / .850" max
<b>Valve Angles:</b>	Int - 24°, Exh - 15° (Rolled 2°) 4° cant
<b>Valve Length:</b>	Int - 5.505" (+.250) Exh - 5.435" (stock)
<b>Valve Stem Dia:</b>	.3415" - 11/32"
<b>Valve Train:</b>	STD BBC 7/16" stud mount
<b>Valve Guides:</b>	1/2" OD Mag - bronze Cut for .530" PC seals (.002" press)
<b>Valve Guide length:</b>	Int - 2.100" (Except 345 Int – 2.250") Exh - 2.250"
<b>Valve Guide clearance:</b>	.0014" - .0021" (with our .3415 dia. valve stem)
<b>Valve Guide Spacing:</b>	Exh moved .045" away from Int
<b>Valve Seats:</b>	Powdered Metal, .006" press (TIR .004)
<b>Valve Seat dim.</b>	Int. - 2.450" 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>Stud Girdle:</b>	Must use DART design. Part# 64110001
<b>Valve Covers:</b>	Part# 68000040 Inverted flange
<b>Torque:</b>	Head Bolts = 70 ft/lb Rocker Studs = 55 ft/lb Manifold = 35 ft/lb Dart inner head studs 3/8-7/16 = 50 ft/lb
<b>Block Use:</b>	Mark IV, Gen V, and Gen VI with proper head gasket
<b>Weight:</b>	29 lbs