



18° SBC Aluminum Cylinder Head

Part#	14132010 - 14182131
Material:	355-T61 alum alloy
Comb Chambers:	62cc - Tit / 65cc - SS valve w/CNC
Intake Valve Dia:	2.150", 2.180", 2.200"
Intake Port volume:	237cc as cast, FP/sm 252cc, FP/std 261cc
Intake Port Dim:	2.150"x 1.175" (as cast) - 2.150"x 1.290"(FP std), 2.170"x 1.310" (FP large)
Int Port Location:	Raised, 5° Intake face (stock = 10°)
Intake Gasket:	Mr. Gasket# 143
Exh Valve Dia.:	1.600" or 1.625"
Exh Port volume:	104cc (as cast), 105cc (FP sm), 108 (FPstd)
Exhaust Port Dim:	(As cast) 1.520"w x 1.330t", 1.740"w x 1.500"t (FP STD),
Exh Port Location:	Raised & spread port, GM & Stahl spread pattern
Exhaust Gasket:	Dart 65222000
Flow, Intake:	(F/P sm) - 371 cfm (F/P STD) - 382 cfm @ .700-.750 lift / 28"
Flow, Exhaust:	(F/P sm) - 241 cfm (F/P STD) - 261 cfm @ .750 lift / 28"
Lifter:	.180" offset lifters required
Manifold:	Alum Single Plane Dart, 5° face
Milling:	Min. 48cc / .115" (.0065" = 1cc) Flat mill only.
Pistons:	Most 18° aftermarket pistons.
Push Rod:	Should always measure (Clearance not machined)
Retainers:	Titanium (10 deg)
Spark Plug:	Angled .750" reach, gasket
Spring Cups:	1.550" - ID locator
Spring Pockets	1.550" OD (.030" deeper max)
Springs:	Our Assembly: 1.550D = 215# @ 1.950" / .680" max 1.550D = 235# @ 1.950" / .750" max
Studs, head:	Dart 18° stud kit w/ (4) 3/8"x 7/16" step studs Dart# 66110012
Valve Angles:	18°
Valve Length:	5.550" (+.600") .250" tip
Valve Stem Dia:	.3415" - 11/32" or 5/16"
Valve Train:	1.6/1.55 Jesel (In .550"/Ex .220" off) or T&D (In .550"/Ex .170" off)
Valve Guides:	1/2" OD Mag - bronze Cut for .530" PC seals (.002" press)
Valve Guide length:	2.250"
Valve Guide clearance:	.0014" - .0020" (with our .3415 dia. valve stem)
Valve Guide Spacing:	1.935"
Valve Seats:	Ductile Iron, or Copper beryllium .006" press
Valve Seat dim.	Int. - 2.250" x 1.850" x .375" Ex. - 1.680" x 1.350" x .375"
Valve Seat angles:	Int = 38°- 45°- 60°- 70°- 80° Exh = 38°- 45°- Radius
Torque:	Head Studs = 70 ft/lb (3/8" = 50 ft/lb) Manifold = 35 ft/lb
Block Use:	Any SBC Iron or Aluminum
Weight:	27 lbs bare – 32 lbs assembled
Notes:	Fuel Injection down nozzle bosses provided