



## DART 180cc Aluminum Cylinder Head Tech Sheet

<b>Part#</b>	1271111 – 127222
<b>Material:</b>	Special RMR alloy
<b>Comb Chambers:</b>	64cc & 72cc
<b>Intake Valve Dia:</b>	2.020"
<b>Intake Port volume:</b>	180cc
<b>Intake Port Dim:</b>	1.180"W x 2.095"H
<b>Int Port Location:</b>	Stock
<b>Intake Gasket:</b>	Fel-Pro # 1205
<b>Exh Valve Dia.:</b>	1.600"
<b>Exh Port volume:</b>	75cc
<b>Exhaust Port Dim:</b>	1.375"H x 1.325"W
<b>Exh Port Location:</b>	Stock location & bolt pattern
<b>Exhaust Gasket:</b>	Fel-Pro 1404 or 1405
<b>Flow, Intake:</b>	248 cfm @ .500"
<b>Flow, Exhaust:</b>	170 cfm @ .500"
<b>Head Bolts:</b>	Dart bolt kit PN# 66220011
<b>Head Studs:</b>	Dart stud kit PN# 66120011
<b>Manifold:</b>	Dart dual plane PN# 42811000
<b>Milling:</b>	Min. 58cc = .060" (.0065" = 1cc) Flat Mill Angle milling = .125" safely / .200" = 49cc w/ 1.5° rolled angle.
<b>Pistons:</b>	Most 23° aftermarket pistons
<b>Push Rod length:</b>	+/- .100" should always measure
<b>Push Rod Guide Plate:</b>	Dart adjustable PN# 27001410
<b>Retainers:</b>	1.250" steel 7° or 1.437" steel 10°
<b>Plug Location:</b>	Straight plug location,
<b>Spark Plug:</b>	.750" reach, 14mm hex with gasket seat
<b>Spring Cups:</b>	N/A
<b>Spring Pockets:</b>	1.550" O.D .030" deeper max.
<b>Springs:</b>	Hyd Flat tappet: 1.250"S = 120# @ 1.700" / .510" max Hyd Roller: 1.437"D = 130# @ 1.800" / .600" max
<b>Valve Angle:</b>	23°
<b>Valve Length:</b>	Standard 4.890" O.A.L
<b>Valve Stem Dia:</b>	.3415" – 11/32 dia.
<b>Valve Train:</b>	Standard SBC 3/8 or 7/16 stud mount.
<b>Valve Guides:</b>	.502" dia. Mag bronze w / .530" seal.
<b>Valve Guide length:</b>	2.100"
<b>Valve Guide clearance:</b>	.0014" - .002" (with our .3415 dia. valve stem)
<b>Valve Guide Spacing:</b>	1.890" moved .030" from stock.
<b>Valve Seats:</b>	Powdered metal
<b>Valve Seat dim.</b>	Int – 2.160" x 1.810" x .350"    Exh – 1.650" x 1.350" x .350"
<b>Valve Seat angles:</b>	Int – 32° - 45° - 60° - 70° - 80°    Exh – 37° - 45° - radius
<b>Stud Girdle:</b>	Dart stud girdle PN# 64110002
<b>Torque: w/oil</b>	Head bolts = 70 ft/lbs Rocker studs = 45 ft/lbs Manifold = 35 ft/lbs
<b>Block Use:</b>	Any SBC Iron or Aluminum
<b>Weight:</b>	23 lbs bare & 26 lbs assembled.