



DART 200cc Aluminum Cylinder Head Tech Sheet

Part#	127311 – 127422
Material:	356-T6
Comb Chambers:	64cc & 72cc
Intake Valve Dia:	2.020"
Intake Port volume:	200cc
Intake Port Dim:	1.190"W x 2.000"H
Int Port Location:	Stock
Intake Gasket:	Fel-Pro # 1205
Exh Valve Dia.:	1.600"
Exh Port volume:	75cc
Exhaust Port Dim:	1.375"H x 1.325"W
Exh Port Location:	Stock location & bolt pattern
Exhaust Gasket:	Fel-Pro 1404 or 1405
Flow, Intake:	252 cfm @ .500"
Flow, Exhaust:	186 cfm @ .500"
Head Bolts:	Dart bolt kit PN# 66220011
Head Studs:	Dart stud kit PN# 66120011
Manifold:	Dart dual plane PN# 42811000
Milling:	Min. 58cc = .060" (.0065" = 1cc) Flat Mill Angle milling = .125" safely / .200" = 49cc w/ 1.5° rolled angle.
Pistons:	Most 23° aftermarket pistons
Push Rod length:	+/- .100" should always measure
Push Rod Guide Plate:	Dart adjustable PN# 27001410
Retainers:	1.250" steel 7° or 1.437" steel 10°
Plug Location:	Straight plug location.
Spark Plug:	.750" reach, 14mm hex with gasket seat
Spring Pockets:	1.550" O.D .030" deeper max.
Springs:	Hyd Flat tappet: 1.250"S = 120# @ 1.700"/ .510" max Hyd Roller: 1.437"D = 130# @ 1.800" / .600" max
Valve Angle:	23°
Valve Length:	Standard 4.890" O.A.L
Valve Stem Dia:	.3415" – 11/32 dia.
Valve Train:	Standard SBC 3/8 or 7/16 stud mount.
Valve Guides:	.502" dia. Mag bronze w / .530" seal.
Valve Guide length:	2.100"
Valve Guide clearance:	.0014" - .002" (with our .3415 dia. valve stem)
Valve Guide Spacing:	1.890" moved .030" from stock.
Valve Seats:	Powdered metal
Valve Seat dim.	Int – 2.160" x 1.810" x .350" Exh – 1.650" x 1.350" x .350"
Valve Seat angles:	Int – 32° - 45° - 60° - 70° - 80° Exh – 37° - 45° - radius
Stud Girdle:	Dart stud girdle PN# 64110002
Torque: w/oil	Head bolts = 70 ft/lbs Rocker studs = 45° ft/lbs Manifold = 25 ft/lbs Rocker studs = 45 ft/lbs Manifold = 25 ft/lbs
Block Use:	Any SBC Iron or Aluminum
Weight:	23 lbs bare & 26 lbs assembled.