

Dart  **180 SBC 23° Iron Cylinder Head**

Part#	10110010 thru 10220010
Material:	Superior iron alloy
Comb Chambers:	64cc, 72cc, 49cc
Intake Valve Dia:	2.02"
Intake Port volume:	180cc
Intake Port Dim:	1.920"x 1.120"
Int Port Location:	Stock
Intake Gasket:	Fel-Pro#'s #1204 (can Not use an OEM type)
Exh Valve Dia.:	1.600"
Exh Port volume:	77cc
Exhaust Port Dim:	1.350" x 1.400" w
Exh Port Location:	Stock location & bolt pattern
Exhaust Gasket:	Fel-Pro# 1404
Flow, Intake:	222cfm @ .500" lift / 28"
Flow, Exhaust:	175cfm @ .600" lift / 28"
Head Bolts:	Stock bolts may be used. ARP# 134-3601
Head Studs:	ARP# 134-4001 or 234-4301 (12pt)
Manifold:	Dart Alum Dual Plane (opening 1.125"x1.880") 5" tall or most aftermarket
Milling:	Min. 58cc = .060" (.0065" = 1cc) Flat Mill Angle mill .125" safely / .200" = 49cc 1.5° (carefully)
Pistons:	Most 23° aftermarket pistons. 49cc heads, 21 Degree flat top
Push Rod length:	Stock (Stock length = 7.800")
Push Rod Guide Plate:	Dart #27001110
Retainers:	Steel 1.250" = (7°) 1.437" = (10°)
Spark Plug:	Angle or straight, .460" reach, tapered seat, Autolite AR133
Spring Cups:	None
Spring Pockets:	1.550" OD (.030" deeper max)
Springs:	Our Assembly: 1.250S = 110# @ 1.700" / .520" max Comp 981 1.437D = 130# @ 1.800" / .620" max Comp 987
Valve Angles:	23°
Valve Length:	Std = 4.890"
Valve Stem Dia:	.3415" - 11/32"
Valve Train:	Std SBC 3/8" stud mount
Valve Guides:	.439" OD Int = Mag-bronze Exh = Phos-bronze (.002" press)
Valve Guide length:	1.950"
Valve Guide clearance:	.0014" - .002" (with our .3415 dia. valve stem)
Valve Guide Spacing:	1.890" moved .030" from stock
Valve Seats:	Exh = Hardened Ductile Iron, .006" press
Valve Seat dim.	Exh - 1.650" x 1.350" x .350"
Valve Seat angles:	Int = 32° - 45° - 60° - 70°-80° Exh = 37° - 45° - radius
Stud Girdle:	Use any standard girdle
Torque: w/oil	Head Bolts = 70 ft/lb Rocker Studs = 45 ft/lb Manifold = 35 ft/lb
Block Use:	Any SBC Iron or Aluminum
Weight:	52 lbs