

**Dart**  **FORD 302 Sportsman SB Iron Block**

<b>Part#</b>	31354175 / 31354275
<b>Material:</b>	Superior iron alloy
<b>Bore:</b>	4.00" or 4.125" unfinished
<b>Bore &amp; stroke:</b>	4.185" x 3.500" max recommended
<b>Cam bearing bore ID:</b>	SVO 2.203"- 2.205"
<b>Cam bearings:</b>	Special coated, grooved, w/3 oil holes (Not included)
<b>Cam Bearing O.S.</b>	+ .010", +.020", +.030"
<b>Cam bearing press:</b>	.002" - .003"
<b>Cam journal OD:</b>	Standard Ford SB
<b>Cam Plug:</b>	2.375" dia. cup plug
<b>Cylinder Wall Thickness:</b>	.250" min @ 4.185" bore
<b>Cubic inch:</b>	385" max recommended
<b>Deck Height:</b>	8.200"
<b>Deck Thickness:</b>	.675" min.
<b>Fuel Pump:</b>	Mechanical pump provision
<b>Freeze Plugs:</b>	Std Ford press in cup plugs 1.500" OD
<b>Head Bolts:</b>	1/2" Blind holes
<b>Lifter Bores:</b>	Std Ford .8747" - .8757" Honed to size
<b>Lifters:</b>	Stock Ford hyd rollers, solid hyd, flat tappet or rollers
<b>Main journal size:</b>	2.249" Std 302
<b>Main bearing bore:</b>	2.441" - 2.442" Honed to size
<b>Main thrust width:</b>	.926" - .928"
<b>Main Cap Bolts:</b>	#1 - #5 7/16" (2) #2, #3, #4 7/16" splayed (2)
<b>Main cap press:</b>	.003" - .004"
<b>Main caps:</b>	Steel - 4 bolt, center 3
<b>Main cap register:</b>	Deep stepped register on each side (no need for dowels)
<b>Oil system:</b>	Priority Main oiling
<b>Oil Filter:</b>	Standard filter
<b>Oil Pan:</b>	Aftermarket 302 with dip stick in pan
<b>Rear Main Seal</b>	Std 1 piece seal - FelPro# 2922 or 2941 4.250"x3.625"
<b>Serial No.</b>	Right front & main caps
<b>Starter:</b>	Standard
<b>Stud &amp; bolt holes, Head:</b>	1/2" std SVO with Blind holes
<b>Timing chain/gears</b>	Standard components
<b>Timing Cover:</b>	Uses stock 302 cover
<b>Torque Specs:</b>	1-5 7/16" bolts - 65 ft lbs
<b>Weight, approx:</b>	160 lbs