



## 14° Big Chief Oval Port (Program 385) CNC Aluminum Cylinder Head

<b>Part#</b>	<b>18375080 – 18375189</b>
<b>Material:</b>	<b>355-T61 alum alloy</b>
<b>Comb Chambers:</b>	<b>86cc with Tit valves</b>
<b>Intake Valve Dia:</b>	<b>2.500"</b>
<b>Intake Port volume:</b>	<b>FP CNC - 433cc</b>
<b>Intake Port Dim:</b>	<b>1.835" x 2.650"</b>
<b>Int Port Location:</b>	<b>Raised 1.500" Spread ports</b>
<b>Intake Gasket:</b>	<b>Dart# 65002155 or Fel-Pro# 1290 (trim to fit)</b>
<b>Exh Valve Dia.:</b>	<b>1.800"</b>
<b>Exh Port volume:</b>	<b>200cc</b>
<b>Exhaust Port Dim:</b>	<b>2.100" w x 1.850" h</b>
<b>Exh Port Location:</b>	<b>Raised .900" STD Chevy bolt pattern</b>
<b>Exhaust Gasket:</b>	<b>Mr. Gasket 5914</b>
<b>Flow, Intake:</b>	<b>525 cfm @ .900" lift/28"</b>
<b>Flow, Exhaust:</b>	<b>349 cfm @ .900" lift/28"</b>
<b>Lifter:</b>	<b>Use .180" offset lifter</b>
<b>Manifold:</b>	<b>Dart Big Chief Oval 1x4 bbl = 8" tall</b>
<b>Milling, flat:</b>	<b>Min. 76cc / .020" max (.006" = 1cc)</b>
<b>Milling, angle:</b>	<b>76cc / 0" - .100"</b>
<b>Pistons:</b>	<b>Must use pistons for 14° Big Chief head.</b>
<b>Push Rod length:</b>	<b>Should always measure</b>
<b>Retainers:</b>	<b>Titanium 10°</b>
<b>Spark Plug:</b>	<b>.750" reach, gasketed Autolite AR3932</b>
<b>Spring Cups:</b>	<b>1.625" - .060 cup</b>
<b>Spring Pockets</b>	<b>1.740" OD for 1.625" cup (.030" deeper max)</b>
<b>Springs:</b>	<b>Our Assembly: 1.625T = 330# @ 2.100" / .910" max P.S.I</b>
<b>Valve Angles:</b>	<b>Int - 14°, Exh - 7°, 4° cant</b>
<b>Valve Length:</b>	<b>Int - 6.600" Exh - 6.450"</b>
<b>Valve Stem Dia:</b>	<b>.3415" - 11/32" 5/16" optional</b>
<b>Valve Train:</b>	<b>Jesel or T&amp;D 14° rocker system</b>
<b>Valve Guides:</b>	<b>1/2" OD Mag - bronze Cut for .500" PC seals (.002" press)</b>
<b>Valve Guide length:</b>	<b>3.000"</b>
<b>Valve Guide clearance:</b>	<b>.0014" - .0021" (with our .3415 dia. valve stem)</b>
<b>Valve Guide Spacing:</b>	<b>Widened for use on min. 4.600" bore. Int. valve moved .020 from 3815 program.</b>
<b>Valve Seats:</b>	<b>Copper-Beryllium, .006" press</b>
<b>Valve Seat dim</b>	<b>Int - 2.520" x 2.00" x .375" Exh - 2.000" x 1.560" x .375</b>
<b>Valve Seat angles:</b>	<b>Int: 45° - 55° - 65° - 75° - 83° Exh: 45° - 55° - Radius</b>
<b>Studs, head:</b>	<b>Must use Big Chief stud kit #66120015</b>
<b>Titanium Valves</b>	<b>Must use lash caps</b>
<b>Torque: w/oil</b>	<b>Head Bolts = 70 ft/lb Dart's inner head studs 3/8-7/16 = 50 ft/lb</b>
	<b>Manifold = 35 ft/lb</b>
<b>Block Use:</b>	<b>Mark IV, Gen V, and Gen VI with proper head gasket</b>
<b>Weight:</b>	<b>42 lbs</b>