



Dart 20° 409cc CNC BBC Aluminum Cylinder Head

Part#:	19774080
Material:	RMR Cast Aluminum Alloy
Comb Chambers:	95cc with stainless steel / 91cc with titanium 4.500" chamber only
Intake Valve Dia:	2.350"
Intake port volume:	409cc
Intake Port Dim:	2.475"T x 1.755"W Rectangle
Int Port Location:	Raised .500" from stock
Intake Gasket:	65123120 (.060")
Exh Valve Dia.:	1.800"
Exh Port volume:	157cc
Exhaust Port Dim:	2.070" x 1.775"
Exh Port Location:	Raised .600" from stock
Exhaust Gasket:	65224020
Exhaust Bolts:	1" longer than stock Dart PN# 66526000
Head Bolts/studs:	Dart PN# 66120014-20
Flow, Intake:	446cfm @ .900" lift w/ 28" H2O
Flow, Exhaust:	334cfm @ .900" lift w/ 28" H2O
Manifold:	Aftermarket stock configuration Dart PN# 41114000 or 41115000 End Rail Spacer set PN# 62220010
Valve Cover:	68000045 *includes gaskets & hardware
Valve Cover Gasket:	65323020
Milling:	Min 95cc w/ stainless / 91cc w/titanium (.005" = 1cc) Flat mill only
Parts kits:	N/A
Pistons:	Aftermarket 20° valve pocket
Push Rod length:	Always measure
Push Rod Guide Plate:	N/A
Retainers:	Titanium 10°
Spark Plug:	.750" reach, gasketed
Spring Cups:	1.750" O.D x .060" thick
Spring Pockets	1.750" OD for 1.625" cup (.030" deeper max)
Springs:	Our Assembly: 1.625D = 275# @ 2.000" .850 P.S.I
Valve Angles:	Intake 20° x 4° cant Exhaust 13° x 4° cant
Valve Length:	6.030" Intake 5.930" Exhaust
Valve Stem Dia:	.3415" - 11/32"
Valve Train:	Jesel or T&D Shaft system
Valve Guides:	1/2" OD Nickel Bronze Cut for .500" PC seals (.002" press)
Valve Guide length:	2.750" Intake and Exhaust
Valve Guide clearance:	.0014" - .0021" (with our .3415 dia. valve stem)
Valve Guide Spacing:	Exhaust moved .045" away from Intake valve
Valve Seats:	Copper impregnated powdered metal for use with Stainless valves *must use Copper Beryllium seats for Titanium valves
Valve Seat dim.	Intake 2.500" x 2.040" x .375" Exhaust 1.960" x 1.625" x .375"
Valve Seat angles:	Intake 55° Seating Angle Exhaust 55° Seating Angle
Stud Girdle:	N/A
Torque:	Head Bolts = 70 ft/lb Dart inner head studs 3/8-7/16 = 50 ft/lb Manifold = 35 ft/lb
Block Use:	Mark IV, Gen V, and Gen VI with proper head gasket
Weight:	35lbs Bare