

**Dart****20°X CNC BBC Aluminum Cylinder Head**

Part#:	19775090 – 19775199X
Material:	RMR Cast Aluminum Alloy
Comb Chambers:	97cc with stainless steel / 93cc with titanium 4.600" chamber standard / *4.500" chamber optional
Intake Valve Dia:	2.420"
Intake port volume:	485cc
Intake Port Dim:	2.650"T x 1.925"W Rectangle
Int Port Location:	Raised .500" from stock
Intake Gasket:	65123120 (.060")
Exh Valve Dia.:	1.800"
Exh Port volume:	157cc small port standard / *160cc large port optional
Exhaust Port Dim:	2.070" x 1.775" small port / 2.140" x 1.820" large port
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:	528cfm @ 1.000" lift w/ 28" H2O
Flow, Exhaust:	354cfm @ 1.000" 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:	Dart P/N# 28000093 - 2.400 x 1.800 x 1.625D Dart P/N# 28000095 - 2.400 x 1.800 x 1.650T
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:	Dart 20°X 1pc system P/N: 61222044-TDS (<i>Steel</i>) or P/N: 61222044-TDA (<i>Aluminum</i>)
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 50° or 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