



## **Dart S/S VORTEC SBC Iron Cylinder Head**

<b>Part#</b>	10024370
<b>Material:</b>	Superior iron alloy
<b>Comb Chambers:</b>	67cc
<b>Intake Valve Dia:</b>	1.940"
<b>Intake Port volume:</b>	175cc
<b>Intake Port Dim:</b>	1.090"w x 1.975"t
<b>Int Port Location:</b>	Stock
<b>Intake Gasket:</b>	Fel-Pro# 1255 (.120" thick) or OEM type
<b>Exh Valve Dia.:</b>	1.500"
<b>Exh Port volume:</b>	65cc
<b>Exhaust Port Dim:</b>	1.340"w x 1.360"t
<b>Exh Port Location:</b>	Stock location & bolt pattern
<b>Exhaust Gasket:</b>	Fel-Pro# 1404
<b>Flow, Intake:</b>	232 cfm @ .500" lift / 28"
<b>Flow, Exhaust:</b>	138 cfm @ .500" lift / 28"
<b>Head bolts:</b>	Stock bolts can be used. ARP# 134-3601
<b>Manifold:</b>	Must use Vortec style manifold
<b>Milling:</b>	Min. 60cc = .060" (.0065" = 1cc) Flat Mill
<b>Pistons:</b>	Most 23° aftermarket pistons.
<b>Push Rod length:</b>	Stock
<b>Push Rod Guide:</b>	Not needed. Use self-aligning rocker arms
<b>Retainers:</b>	Steel 1.250" = (7°) 1.437" = (10°)
<b>Rocker Arm stud:</b>	Use screw-in stud w/integral nut
<b>Spark Plug:</b>	.460" reach, tapered seat, Autolite AR24
<b>Spring Cups:</b>	None
<b>Spring Pockets:</b>	Cut for 1.250" & 1.550" OD (.030" deeper max)
<b>Springs:</b>	Our Assembly: 1.250S = 110# @ 1.700" / .520" max Comp 981
<b>Valve Covers:</b>	Center bolt covers only
<b>Valve Angles:</b>	23°
<b>Valve Length:</b>	STD = 4.890"
<b>Valve Stem Dia:</b>	.3415" - 11/32"
<b>Valve Guides:</b>	Integral
<b>Valve Guide clearance:</b>	.002" - .0025" (with our .3415 dia. valve stem)
<b>Valve Guide Spacing:</b>	1.890" moved .030" from stock
<b>Valve Seals:</b>	Cut for umbrella seals
<b>Valve Seats:</b>	Exh = Hardened Ductile Iron, .006" press
<b>Valve Seat dim:</b>	Exh - 1.650" x 1.280" x .350"
<b>Valve Seat angles:</b>	Int = 32° - 45° - 60° - 70° Exh = 37° - 45° - radius
<b>Stud Girdle:</b>	Use any standard girdle
<b>Torque: w/oil</b>	Head Bolts = 70 ft/lb Rocker Studs = 45 ft/lb
<b>Block Use:</b>	Any SBC Iron or Aluminum
<b>Weight:</b>	48 lbs