

**Dart****220 SBC Aluminum Cylinder Head**

Part#	12172030 thru 12172161
Material:	RMR Cast Aluminum Alloy
Comb Chambers:	As cast - No chamber, full port -72cc @ 4.155"
Intake Valve Dia:	2.080" 2.100", 2.120", 2.150"
Intake Port volume:	236cc FP program only
Intake Port Dim:	As cast -1.900"T x .900W" Full port 2.300T"x 1.320W"
Int Port Location:	Stock
Intake Gasket:	Fel-Pro# 1207
Exh Valve Dia.:	1.600" or 1.625"
Exh Port volume:	95cc FP program only
Exhaust Port Dim:	As cast - 1.150T" x 1.00W" & Full port - 1.460T" x 1.690W
Exh Port Location:	Stock location & bolt pattern, Spread Exhaust has GM & Stahl spread pattern
Exhaust Gasket:	STD exhaust = Fel-Pro 1406 Spread Exhaust = Fel-Pro 1409
Flow, Intake:	Full Port CNC - 324 cfm @ .800 lift / 28"
Flow, Exhaust:	Full Port CNC - 251 cfm @ .800 lift / 28"
Head Bolts:	Dart PN# 66220011
Head Studs:	Dart PN# 66120011 (12pt)
Manifold:	Dart PN# 42311000 (4150) Dart PN# 42321000 (4500)
Milling:	Min. 58cc / .080" flat mill (.0065" = 1cc).
Pistons:	Most 23° aftermarket pistons.
Push Rod length:	Stock thru +.200" Should always measure (Stock length = 7.800")
Retainers:	Titanium (10 deg)
Spark Plug:	Angled .750" reach, gasketed seat.
Spring Cups:	1.550" ID locator
Spring Pockets	1.550" OD (.030" deeper max)
Springs:	Our Assembly: 1.550D = 215# @ 1.900" / .650" max 1.550D = 230# @ 1.950" / .750" max
Valve Angles:	23°
Valve Length:	5.115" (+.200") w/ .250" tip
Valve Stem Dia:	.3415" - 11/32"
Valve Train:	Shaft rocker .220"-.250" offset (can use .250" offset stud mount)
Valve Guides:	1/2" OD Mag - bronze Cut for .530" PC seals (.002" press)
Valve Guide length:	2.100"
Valve Guide clearance:	.0012" - .0015" (with our .3415 dia. valve stem)
Valve Guide Spacing:	1.890" moved .030" from stock
Valve Seats:	Ductile iron, or Copper beryllium .006" press
Valve Seat dim.	Int. - 2.200" x 1.680" x .375" Ex. - 1.680" x 1.350" x .375"
Valve Seat angles:	Int = 30° - 45° - 60°-70°-80° Ex. = 35° - 45° - radius
Stud Girdle:	
Torque:	Head Bolts = 70 ft/lb
	Rocker Studs = 45 ft/lb
	Manifold = 35 ft/lb
Block Use:	SBC Dart blocks recommended.
Weight:	24 lbs