



## 18° SBC Aluminum Cylinder Head

<b>Part#</b>	14132010 - 14182131
<b>Material:</b>	RMR Cast Aluminum Alloy
<b>Comb Chambers:</b>	62cc - Tit / 65cc - SS valve w/CNC
<b>Intake Valve Dia:</b>	2.150", 2.180", 2.200"
<b>Intake Port volume:</b>	237cc as cast, FP/sm 252cc, FP/std 261cc
<b>Intake Port Dim:</b>	2.150"x 1.175" (as cast) - 2.150"x 1.290"(FP std), 2.170"x 1.310" (FP large)
<b>Int Port Location:</b>	Raised, 5° Intake face (stock = 10°)
<b>Intake Gasket:</b>	Mr. Gasket# 143
<b>Exh Valve Dia.:</b>	1.600" or 1.625"
<b>Exh Port volume:</b>	104cc (as cast), 105cc (FP sm), 108 (FPstd)
<b>Exhaust Port Dim:</b>	(As cast) 1.520"w x 1.330t", 1.740"w x 1.500"t (FP STD),
<b>Exh Port Location:</b>	Raised & spread port, GM & Stahl spread pattern
<b>Exhaust Gasket:</b>	Dart 65222000
<b>Flow, Intake:</b>	(F/P sm) - 371 cfm (F/P STD) - 382 cfm @ .700-.750 lift / 28"
<b>Flow, Exhaust:</b>	(F/P sm) - 241 cfm (F/P STD) - 261 cfm @ .750 lift / 28"
<b>Lifter:</b>	.180" offset lifters required
<b>Manifold:</b>	Alum Single Plane Dart, 5° face
<b>Milling:</b>	Min. 48cc / .115" (.0065" = 1cc) Flat mill only.
<b>Pistons:</b>	Most 18° aftermarket pistons.
<b>Push Rod:</b>	Should always measure (Clearance not machined)
<b>Retainers:</b>	Titanium (10 deg)
<b>Spark Plug:</b>	Angled .750" reach, gasket
<b>Spring Cups:</b>	1.550" - ID locator
<b>Spring Pockets</b>	1.550" OD (.030" deeper max)
<b>Springs:</b>	Our Assembly: 1.550D = 215# @ 1.950" / .680" max 1.550D = 235# @ 1.950" / .750" max
<b>Studs, head:</b>	Dart 18° stud kit w/ (4) 3/8"x 7/16" step studs Dart# 66110012
<b>Valve Angles:</b>	18°
<b>Valve Length:</b>	5.510" (+.600") .250" tip
<b>Valve Stem Dia:</b>	.3415" - 11/32" or 5/16"
<b>Valve Train:</b>	1.6/1.55 Jesel (In .550"/Ex .220" off) or T&D (In .550"/Ex .170" off)
<b>Valve Guides:</b>	1/2" OD Mag - bronze Cut for .530" PC seals (.002" press)
<b>Valve Guide length:</b>	2.250"
<b>Valve Guide clearance:</b>	.0014" - .0020" (with our .3415 dia. valve stem)
<b>Valve Guide Spacing:</b>	1.935"
<b>Valve Seats:</b>	Ductile Iron, or Copper beryllium .006" press
<b>Valve Seat dim.</b>	Int. - 2.250" x 1.850" x .375" Ex. - 1.680" x 1.350" x .375"
<b>Valve Seat angles:</b>	Int = 38°- 45°- 60°- 70°- 80° Exh = 38°- 45°- Radius
<b>Torque:</b>	Head Studs = 70 ft/lb (3/8" = 50 ft/lb) Manifold = 35 ft/lb
<b>Block Use:</b>	Any SBC Iron or Aluminum
<b>Weight:</b>	27 lbs bare – 32 lbs assembled
<b>Notes:</b>	Fuel Injection down nozzle bosses provided