



Cylinder Heads • Engine Blocks • Intake Manifolds

The following information should be helpful in the installation of these heads.

Recommended Gaskets:

Head:	350 Block	- Fel-Pro 1003
	400 Block	- Fel-Pro 1014
Intake:	180cc	- Fel-Pro 1204
	200cc	- Fel-Pro 1205
	215/230cc	- Fel-Pro 1206
Exhaust:	All except	- Fel-Pro 1404 or 1405
	230cc	- Fel-Pro 1405

Recommended Spark Plug:

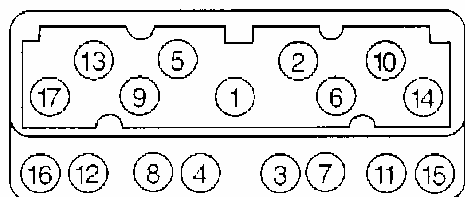
.750" reach gasket seat w/ 5/8" hex
NGK# FR4 w/ 8:1 - 9:1 compression
NGK# FR5 w/ 10:1 - 10.5:1 compression
NGK# R5671A-8 w/ 13:1 compression

Note: Always consult the manufacturer's catalog for correct heat range.

Torque Specifications: w/ CMD#3 High Pressure Lube

Head Bolts & Studs	70 ft lb
Rocker Arm Studs	45 ft lb
Manifold bolts	35 ft lb

Torque Sequence:



Valve Springs on our assemblies:

Cam Type / OD / type / pres / install ht / max lift

Hydraulic - 1.250" single, 110lb @ 1.700" .520"
Hyd Roller - 1.437" dual, 135lb @ 1.800" .600"
Solid Roller - 1.550" dual, 195lb @ 1.900" .650" *

*-When using this spring it may be necessary to check rocker arm interference with the retainer.



180cc/200cc/215cc/227cc/230cc Aluminum Small Block Chevy Cylinder Heads



Pro1 Aluminum cylinder heads are designed to produce optimum performance "Out of the Box". Several important features have been incorporated in the Pro1 heads. The finish and wall integrity are a result of the latest improved casting techniques. Bronze guides are a standard feature on all Pro1 heads. The latest technology in port design produces an "as cast" port that performs as if it were fully ported.

INTAKE MANIFOLDS



are found on race engines around the world. They are designed to develop maximum power for the intended purpose. The following manifolds are designed specifically for the Pro1 heads:

Part# 42811000	Dual plane, 4150 carb.
Part# 42411000	Single plane, 4150 carb.
Part# 42421000	Single plane, 4500 carb.

PUSH RODS:

Standard length push rods should be used except with our 1.550" diameter roller cam springs. These valves are .100" longer and require longer pushrods. Length should always be measured before ordering. You must use 5/16" hardened push rods.

VALVE COVERS:

DART Cast aluminum valve covers are available for your Iron Eagle and Pro1 heads. The cast Dart logo is the same one that's found on Pro Stock and Pro Mod cars in winner circles everywhere.

Part# 68000015 (Cast Alum.) & 68000050 (Stamped steel)

PORTING INFORMATION:

The intake and exhaust ports are very efficient on these heads "as cast". We recommend that if any porting is done it should only be done by a qualified head porter. As with any cylinder head, once it is modified from its original condition, the manufacturer, Dart, takes no responsibility for the cylinder head.

*****This is done entirely at your own risk*****

Iron Eagle Block for SBC

- Raised cam
- 9.025" & 9.325" deck height
- 350 & 400 mains
- Spread pan rails
- Priority main oiling
- 4 bolt billet caps
- Wet or dry sump

Little M Block for SBC

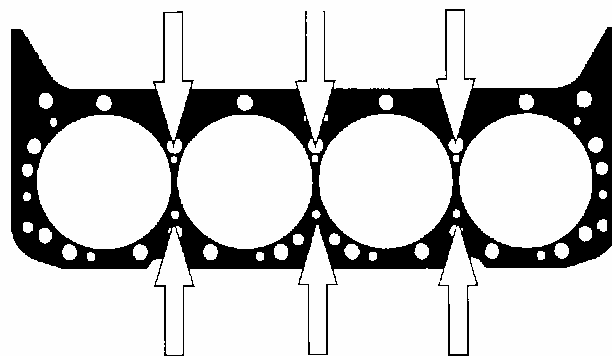
- Standard cam location & size
- Uses standard pan
- 9.025" deck height
- 350 mains - 4 bolt billet caps
- Priority main oiling
- Oil filter provision



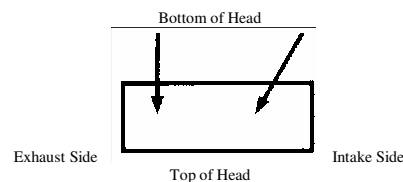
400 STEAM HOLES:

In applications where a 400 engine block is used, you must drill six 9/64" steam holes in the cylinder heads. With the head upside down uses the 400 head gasket as a template to mark the locations of the holes to be drilled. The three holes on the intake side should be drilled at a 30 degree angle towards the center of the head and may need to be over one inch deep. The remaining three holes are drilled straight down towards the top of the head.

Intake Side - Drill these 3 holes at 30° angle towards the Exhaust side of head.



Exhaust Side - Drill these 3 straight holes



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