



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

GASKET RECOMMENDATION

Head: Up to 4.060" bore - Fel-Pro 1021
4.125" - 4.155" bore - Fel-Pro 1022/1023
4.160" - 4.185" bore - Fel-Pro 1031L/1031R

Intake: 170 / 195cc - Fel-Pro 1262

Exhaust: 170 / 195cc - Fel-Pro 1487

SPARK PLUG RECOMMENDATION

.750" Reach Gasketed 5/8" Hex

Autolite# 3933 Std tip, race

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

HEAD BOLTS & STUDS

Due to the fact that the head bolt holes in these heads are 1/2", when installing these heads on stock 302 blocks you must use head bolts with a stepped washer 1/2" - 7/16" or stepped bolts.

Bolt Kit w/stepped washers ARP 154-3605

Bolt Kit w/ stepped bolts ARP 254-3708

351 & Dart Block 1/2" bolts ARP 154-3603

Torque Specifications: w/oil

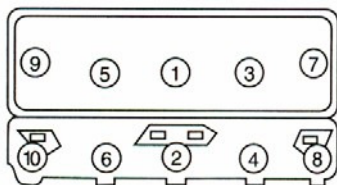
7/16" Head Bolts 65 ft lb

1/2" Head Bolts 100 ft lb

Rocker Arm Studs 45 ft lb

Intake Manifold bolts 18 ft lb

Torque Sequence:



170cc / 195cc

Aluminum Small Block Ford 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.

PUSH RODS

Push rods may need to be changed depending on rocker arm, cam, lifter and spring used. Length should always be measured during installation. You must use 5/16" hardened push rods.

It is recommended that you use Dart #27001310 guide plates with these heads.

ROCKER ARMS

You can use standard stud mount rockers on your  Ford aluminum heads. The screw-in rocker studs supplied with our assemblies are 3/8". Optional 7/16" studs are available.

When using any roller rocker you must check rocker arm to retainer & spring clearance, leaving .060" minimum.

Valve Springs on our assemblies:

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

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

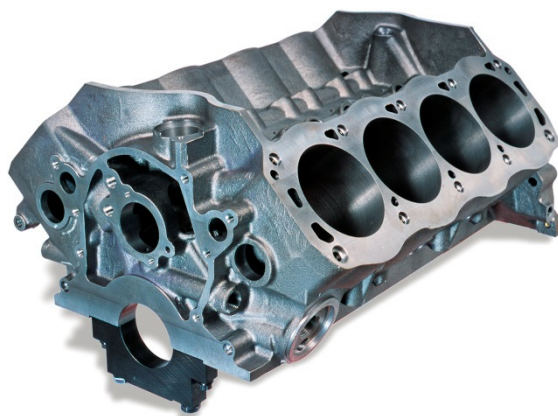
PORTING INFORMATION

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' *as sold* condition, the manufacturer, Dart, takes no responsibility for the cylinder head. *This is done entirely at your own risk.*

MILLING DECK

These cylinder heads may be flat milled .080" which will leave a chamber volume of 50cc.

We do not recommend angle milling these unless you are a machinist with a good deal of experience angle milling heads. Whenever milling heads be sure to check deck thickness and be careful not to machine the top angle of the valve job.



Iron Eagle Block for Small Block Ford

- 8.200 std 302 deck height
- 8.700" +.500 deck height
- 9.200 Cleveland deck height
- 9.500 Windsor deck height
- Priority main oiling
- 4 bolt billet caps
- Up to 4.185" bore
- 1/2" head bolts

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