

Dart  **FORD 302 SB Iron Block - Technical Notes**

Part#	31384175 - 31384285
Material:	Special RMR alloy
Bore:	4.00" or 4.125" unfinished
Bore & stroke:	4.185" x 3.500" max recommended
Cam bearing bore ID:	SVO 2.203"- 2.205"
Cam bearings:	Special coated, grooved, w/3 oil holes
Cam Bearing O.S.	+ .010", +.020", +.030"
Cam bearing press:	.002" - .003"
Cam journal OD:	Standard Ford SB
Cam Plug:	2.375" dia. Cup plug Dart PN# 32510000
Cylinder Wall Thickness:	.250" min @ 4.185" bore
Cubic inch:	385" max recommended
Deck Height:	8.200" & 8.700"
Deck Thickness:	.675" min.
Fuel Pump:	Mechanical pump provision
Freeze Plugs:	STD Ford press in cup plugs 1.500" OD
Head Bolts:	1/2" Blind holes
Lifter Bores:	STD Ford .8747" - .8757" Honed to size
Lifters:	STD Ford - Hydraulic rollers need tie-bar style lifters.
Main journal size:	302 (2.249")
Main bearing bore:	2.4412" - 2.4420" Honed to size
Main thrust width:	.926" - .928"
Main Cap Bolts:	#1 7/16" (2) 3/8" (2) #2, #3, #4 7/16" (2) 7/16" splayed (2) #5 7/16" (2) 3/8" (2)
Main cap press:	.003" - .004"
Main caps:	Steel - 4 bolt, all 5
Main cap register:	Deep stepped register on each side (no need for dowels)
Oil system:	STD Wet Sump or SVO dry sump Priority Main oiling with external pump (wet or dry)
Oil Filter:	Standard filter w/ adapter Dart PN# 3294000 (sold separately)
Oil Pan:	Aftermarket 302 with dip stick in pan (May require some modification)
Rear Main Seal	Std 1 piece seal - FelPro# 2922 or 2941 4.250"x3.625"
Serial No.	Right front & main caps
Starter:	Standard SBF
Stud & bolt holes, Head:	1/2" STD SVO with Blind holes
Timing chain/gears	Standard components Note: (Late model 302 timing chain required)
Timing Cover:	Uses stock 302 cover
Torque Specs:	1-5 7/16" bolts - 65 ft lbs 1 & 5 3/8" bolts - 35 ft lbs
Weight, approx:	160 lbs - 8.200" 175 lbs - 8.700"