

Dart  **FORD 351W SB Iron Block Technical Notes**

Part#	31385135 - 31385235
Material:	Special RMR alloy
Bore:	4.00" or 4.125" unfinished
Bore & stroke:	4.185" x 4.250" 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
Cylinder Wall Thickness:	.250" min @ 4.185" bore
Cubic inch:	468" max recommended
Deck Height:	9.200" & 9.500"
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") or 351C (2.749")
Main bearing bore:	2.9415" - 2.9425" Honed to size
Main thrust width:	.913" - .915"
Main Cap Bolts:	#1 1/2" (2) 3/8" (2)
	#2, #3, #4 1/2" (2) 7/16" splayed (2)
	#5 1/2" (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# 32940000 (Sold separately)
Oil Pan:	Standard 351W oil pan (May require some modification for fitment)
Rear Main Seal	STD 1 piece seal - FelPro# 2921 or 2942 4.500"x 3.750" SVO
Serial No.	Right front & main caps
Starter:	Standard
Stud & bolt holes, Head:	1/2" STD SVO with blind holes
Timing chain/gears	Standard components Note: (Late model 351W chain required)
Timing Cover:	Uses stock 351W timing cover
Torque Specs:	1-5 1/2" bolts - 100 ft lbs
	2-4 7/16" bolts - 65 ft lbs
	1 & 5 3/8" bolts - 35 ft lbs
Weight, approx:	190 lbs - 9.200" 195 lbs - 9.500"