

Dart 310, 325, 345 BBC Aluminum Cylinder Head

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| Part# | 19100000, 19200000, 19300000 |
| Material: | RMR Cast Aluminum Alloy |
| Comb Chambers: | 121cc |
| Intake Valve Dia: | (310) 2.250" (325) 2.250"/2.300" (345) 2.300" |
| Intake Port Dim: | 1.700" x 2.430" |
| Int Port Location: | Stock |
| Intake Gasket: | Mr. Gasket# 121 |
| Exh Valve Dia.: | 1.880" |
| Exh Port volume: | 129cc |
| Exhaust Port Dim: | 1.650" x 1.800" |
| Exh Port Location: | Raised .300" STD bolt pattern |
| Exhaust Gasket: | Fel-Pro 1412 |
| Exhaust Bolts: | 1" longer than stock (4) ea. |
| Flow, Intake: | (310) 369 cfm (325) 376 cfm (345) 397 cfm @.800 lift/28" |
| Flow, Exhaust: | 266 cfm @.800 lift/28" |
| Head Bolts/studs; | Bolts – 66220014 Studs – 66120014-20 |
| Manifold: | Rect. Port Dart (opening - 1.575"x 2.250") 6.25" tall |
| Milling: | Min. 108cc. (.005" = 1cc) Flat mill only. |
| Pistons: | Most aftermarket pistons. |
| Push Rod length: | Avg. +.200" / +.250" Should always measure Stock length Int. = 8.275" / Exh = 9.250" |
| Push Rod Guide Plate | Must use Dart adjustable PN# 27001230-4 |
| Retainers: | 1.625" - Tit / 1.550" - Moly Steel (10°) |
| Spark Plug: | .750" reach, gasketed. Autolite Ar3933 Street AR3924 |
| Spring Cups: | 1.625" - .035" cup / 1.550" - .150" cup |
| Spring Pockets | 1.740" OD for 1.625" cup (.030" deeper max) |
| Springs: | Our Assembly: 1.550S = 145# @ 1.900" / .660" max 1.550D = 195# @ 1.900" / .650" max 1.625D = 275# @ 2.000" / .850" max |
| Valve Angles: | Int - 24°, Exh - 15° (Rolled 2°) 4° cant |
| Valve Length: | Int - 5.505" (+.250) Exh - 5.435" (stock) |
| Valve Stem Dia: | .3415" - 11/32" |
| Valve Train: | STD BBC 7/16" stud mount |
| Valve Guides: | 1/2" OD Mag - bronze Cut for .530" PC seals (.002" press) |
| Valve Guide length: | Int - 2.100" (Except 345 Int – 2.250") Exh - 2.250" |
| Valve Guide clearance: | .0014" - .0021" (with our .3415 dia. valve stem) |
| Valve Guide Spacing: | Exh moved .045" away from Int |
| Valve Seats: | Powdered Metal, .006" press (TIR .004) |
| Valve Seat dim. | Int. - 2.450" x 2.000" x .375" Exh - 2.000" x 1.600" x .375" |
| Valve Seat angles: | Int = 32° - 45° - 60° - 70° - 80° Exh = 37° - 45° - radius |
| Stud Girdle: | Must use DART design. Part# 64110001 |
| Valve Covers: | Part# 68000040 Inverted flange |
| Torque: | Head Bolts = 70 ft/lb Rocker Studs = 55 ft/lb Manifold = 35 ft/lb Dart inner head studs 3/8-7/16 = 50 ft/lb |
| Block Use: | Mark IV, Gen V, and Gen VI with proper head gasket |
| Weight: | 29 lbs |