



## DART 200cc Aluminum Cylinder Head Tech Sheet

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|-------------------------------|---|
| <b>Part#</b>                  | 127311 – 127422   |
| <b>Material:</b>              | RMR Cast Aluminum Alloy   |
| <b>Comb Chambers:</b>         | 64cc & 72cc   |
| <b>Intake Valve Dia:</b>      | 2.020"  |
| <b>Intake Port volume:</b>    | 200cc   |
| <b>Intake Port Dim:</b>       | 1.190"W x 2.000"H   |
| <b>Int Port Location:</b>     | Stock   |
| <b>Intake Gasket:</b>         | Fel-Pro # 1205  |
| <b>Exh Valve Dia.:</b>        | 1.600"  |
| <b>Exh Port volume:</b>       | 75cc  |
| <b>Exhaust Port Dim:</b>      | 1.375"H x 1.325"W   |
| <b>Exh Port Location:</b>     | Stock location & bolt pattern   |
| <b>Exhaust Gasket:</b>        | Fel-Pro 1404 or 1405  |
| <b>Flow, Intake:</b>          | 252 cfm @ .500"   |
| <b>Flow, Exhaust:</b>         | 186 cfm @ .500"   |
| <b>Head Bolts:</b>            | Dart bolt kit PN# 66220011  |
| <b>Head Studs:</b>            | Dart stud kit PN# 66120011  |
| <b>Manifold:</b>              | Dart dual plane PN# 42811000  |
| <b>Milling:</b>               | Min. 58cc = .060" (.0065" = 1cc) Flat Mill<br>Angle milling = .125" safely / .200" = 49cc w/ 1.5° rolled angle.           |
| <b>Pistons:</b>               | Most 23° aftermarket pistons  |
| <b>Push Rod length:</b>       | +/- .100" should always measure   |
| <b>Push Rod Guide Plate:</b>  | Dart PN# 27001110   |
| <b>Retainers:</b>             | 1.250" steel 7° or 1.437" steel 10°   |
| <b>Plug Location:</b>         | Straight plug location.   |
| <b>Spark Plug:</b>            | .750" reach, 14mm hex with gasket seat  |
| <b>Spring Pockets:</b>        | 1.550" O.D .030" deeper max.  |
| <b>Springs:</b>               | Hyd Flat tappet: 1.250"S = 120# @ 1.700"/ .510" max<br>Hyd Roller: 1.437"D = 130# @ 1.800" / .600" max                    |
| <b>Valve Angle:</b>           | 23°   |
| <b>Valve Length:</b>          | Std. = 4.915"   |
| <b>Valve Stem Dia:</b>        | .3415" – 11/32 dia.   |
| <b>Valve Train:</b>           | Standard SBC 3/8 or 7/16 stud mount.  |
| <b>Valve Guides:</b>          | .502" dia. Mag bronze w / .530" seal.   |
| <b>Valve Guide length:</b>    | 2.100"  |
| <b>Valve Guide clearance:</b> | .0014" - .002" (with our .3415 dia. valve stem)   |
| <b>Valve Guide Spacing:</b>   | 1.890" moved .030" from stock.  |
| <b>Valve Seats:</b>           | Powdered metal  |
| <b>Valve Seat dim.</b>        | Int – 2.160" x 1.810" x .350" Exh – 1.650" x 1.350" x .350"   |
| <b>Valve Seat angles:</b>     | Int – 32° - 45° - 60° - 70° - 80° Exh – 37° - 45° - radius  |
| <b>Stud Girdle:</b>           | Dart stud girdle PN# 64110002   |
| <b>Torque: w/oil</b>          | Head bolts = 70 ft/lbs Rocker studs = 45° ft/lbs Manifold = 25 ft/lbs<br>Rocker studs = 45 ft/lbs<br>Manifold = 25 ft/lbs |
| <b>Block Use:</b>             | Any SBC Iron or Aluminum  |
| <b>Weight:</b>                | 23 lbs bare & 26 lbs assembled.   |