

## Dart FORD 225 CNC 20° Aluminum Cylinder Head

<b>Part#</b>	13072000
<b>Material:</b>	355T6 alum alloy
<b>Comb Chambers:</b>	62cc
<b>Intake Valve Dia:</b>	2.08"
<b>Intake Port volume:</b>	225cc
<b>Intake Port Dim:</b>	2.150"x 1.300"
<b>Int Port Location:</b>	Stock
<b>Intake Gasket:</b>	Fel-Pro# 1262
<b>Exh Valve Dia.:</b>	1.600"
<b>Exh Port volume:</b>	87cc
<b>Exhaust Port Dim:</b>	1.420" x 1.420" w
<b>Exh Port Location:</b>	Raised .135" Spread bolt pattern / SVO (3.00" bolt centers)
<b>Exhaust Gasket:</b>	Fel-Pro# 1487
<b>Flow, Intake:</b>	325 cfm @ .700" lift / 28"
<b>Flow, Exhaust:</b>	235 cfm @ .700" lift / 28"
<b>Head Bolts:</b>	Dart & 351W block 1/2" OD ARP# 154-3603 302 block 1/2"-7/16" stepped washer ARP# 154-3605
<b>Head Studs:</b>	Dart & 351W block 1/2" OD ARP# 154-4003 302 block 1/2"-7/16" stepped washer ARP# 154-4005
<b>Manifold:</b>	Most with std port location
<b>Milling:</b>	Min. 50cc (.0065" = 1cc) Flat Mill
<b>Pistons:</b>	Most 20° aftermarket pistons.
<b>Push Rod length:</b>	Should measure
<b>Push rod Guide Plate:</b>	Comp Cam # 4816 (flat)
<b>Retainers:</b>	Steel (10°)
<b>Spark Plug:</b>	.750" reach, gasketed, Autolite AR3933
<b>Spring Pockets:</b>	1.550" OD (.030" deeper max)
<b>Springs:</b>	Our Assembly: 1.437D = 130# 1.800" (solid & hyd roller) 1.550D = 195# 1.900" (solid roller)
<b>Valve Length:</b>	Std 4.890" / 5.015" (+.100)
<b>Valve Stem Dia:</b>	.3415" - 11/32"
<b>Valve Train:</b>	Std SBF 3/8" or 7/16" stud mount
<b>Valve Guides:</b>	1/2" OD Mag-bronze (.002" press)
<b>Valve Guide length:</b>	2.080"
<b>Valve Guide clearance:</b>	.0014" - .002" (with our .3415 dia. valve stem)
<b>Valve Guide Spacing:</b>	1.876" exh moved .050" from stock
<b>Valve Seats:</b>	Hardened Ductile Iron, .006" press
<b>Valve Seat dim.</b>	Int - 2.160x 1.810 x .350 Ex - 1.650x 1.350x .350
<b>Valve Seat angles:</b>	Int = 32°- 45°- 60°- 70° Ex = 37°- 45°- radius
<b>Stud Girdle:</b>	Use any standard girdle
<b>Torque:</b>	Head Bolts 7/16" = 70 ft/lb 1/2" = 100 ft/lb Rocker Studs = 45 ft/lb Manifold = 18 ft/lb
<b>Block Use:</b>	Dart Iron or Aluminum & any Ford
<b>Weight:</b>	23 lbs