



The following information should be helpful in the installation of these heads.

Recommended Gaskets:

- Head:** Mark IV block 4.54" bore - Fel-Pro 1017-1
 Mark IV block 4.37" bore - Fel-Pro 1027
 Gen V, VI 4.54" bore - Fel-Pro 1047
 Gen V, VI 4.37" bore - Fel-Pro 1037

Note: Always consult the manufacturer's catalog for proper gasket application.

- Intake:** All Pro1 - Mr. Gasket 121
 - Fel-Pro 1275

- Exhaust:** All Pro1 - Fel-Pro 1412
 - Dart 65224000

Recommended Spark Plug:

Gasketed flat seat, .750" Reach 5/8" Hex

- Autolite # 3933 Std tip, race
 Autolite # 3911 Projected tip

Note: Always consult the manufacturer's catalog for correct heat range.

Torque Specifications: w/oil

- Head Bolts & Studs 70 ft lb
 Rocker Arm Studs 45 ft lb
 Manifold bolts 35 ft lb

Valve Lengths:

- Intake 5.475" (+.250")
 Exhaust 5.435" (std)

Valve Springs on our assemblies:

Cam Type / OD / type / pres / install ht / max lift

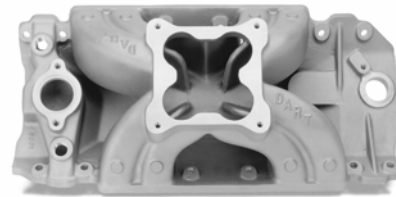
- Hydraulic - 1.550" single, 145lb @ 1.900" .660"
 & Solid
 Hyd Roller- 1.550" dual, 140lb @ 1.900" .600"
 Roller - 1.550" dual, 195lb @ 1.900" .690"
 Roller - 1.625" dual, 250lb @ 2.000" .800"



**310cc/325cc/335cc/345cc/355cc
 Aluminum Big Block Chevy Cylinder Heads**

DART Pro1 Aluminum cylinder heads are designed to produce optimum performance "Out of the Box". Several important features have been incorporated in the Pro1 heads. The finish and wall integrity are a result of the latest improved casting techniques. Bronze guides are a standard feature on all Pro1 heads. The latest technology in port design produces an "as cast" port that performs as if it were fully ported.

INTAKE MANIFOLDS



DART MANIFOLDS are found on race engines around the world. They are designed to develop maximum power for the intended purpose. The following single plane manifolds are designed specifically for the Pro1 heads:

| | | | |
|--------------|----------|-----------|-----------------|
| Part# | 41114000 | 4150 carb | 9.800" deck ht |
| | 41115000 | 4150 carb | 10.200" deck ht |
| | 41124000 | 4500 carb | 9.800" deck ht |
| | 41125000 | 4500 carb | 10.200" deck ht |

Head Bolts:

The (4) short head bolts or studs along the exhaust (bottom) side of the head need to be one (1) inch longer than stock. These should be available at most performance parts suppliers.

VALVE COVERS



DART cast aluminum Pro valve covers are available for your Pro1 aluminum heads. The cast Dart logo is the same one that's found on Pro Stock and Pro Mod cars in winners circles everywhere.

Part# 68000020

PORTING INFORMATION

The intake and exhaust ports are very efficient on these heads "as cast". We recommend that if any porting is done it should only be done by a qualified head porter. As with any cylinder head, once it is modified from its' *as sold* condition, the manufacturer, Dart, takes no responsibility for the cylinder head. *This is done entirely at your own risk.*

ROCKER ARM STUDS

All Dart big block heads use an exhaust rocker arm stud with an increased thread length where it is installed in the cylinder head. It has a 1.300" thread length for the raised rocker arm boss. *Do Not Use a Shorter Length.*

Part# Dart 27002204 exhaust stud
Dart 27002223 intake stud
ARP 235-7202 Kit

STUD GIRDLE



All Dart big block heads have the valve angles rolled 2 degrees for better flow characteristics. Due to this, if you decide to utilize a stud girdle it is mandatory to use one specifically designed for a **DART** cylinder head. We stock a heavy duty girdle that fits these heads correctly.

Part# 64110001

PUSH ROD INFORMATION

Pushrod length on all Dart big block cylinder heads will be longer than stock. Due to numerous variables in deck height, cam diameter, lifter length, rocker arm, etc., you will need to measure the pushrod length with an adjustable pushrod checker. The most common length is +.200" (Stock lengths are 8.275"-Int / 9.250"-Exh)
You must use 3/8" hardened push rods.

GUIDE PLATES

A Dart adjustable guide plate is recommended for use with these heads.

Part# Dart 27001230-4