Dart FORD 302 SB Iron Block

Part# 31384175 / 31384275 / 31384185 / 31384285

Material: Superior iron alloy

Bore: 4.00" or 4.125" unfinished

Bore & stroke: 4.185" x 3.500" 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 (can be bored for 55mm)

Cam Plug: 2.375" dia. cup plug
Cylinder Wall Thickness: .250" min @ 4.185" bore
Cubic inch: 385" max recommended

Deck Height: 8.200" & 8.700" 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 - Hyd rollers need tie-bar style lifters.

Main journal size: 2.249" Std 302

Main bearing bore: 2.441" - 2.442" Honed to size

Main thrust width: .926" - .928"

Main Cap Bolts: #1 7/16" (2) 3/8" (2)

#2, #3, #4 7/16" (2) 7/16" splayed (2)

#5 7/16" (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

Oil Pan: Aftermarket 302 with dip stick in pan

Rear Main Seal Std 1 piece seal - FelPro# 2922 or 2941 4.250"x3.625"

Serial No. Right front & main caps

Starter: Standard

Stud & bolt holes, Head: 1/2" std SVO with Blind holes

Timing chain/gears Standard components
Timing Cover: Uses stock 302 cover

Torque Specs: 1-5 7/16" bolts - 65 ft lbs

1 & 5 3/8" bolts - 35 ft lbs

Weight, approx: 160 lbs - 8.200" 175 lbs - 8.700"