

## **Dart SHP *FORD* 302 SB Iron Block**

<b>Part#</b>	<b>31364175 31364275</b>
<b>Material:</b>	<b>Cast Iron</b>
<b>Bore:</b>	<b>4.00" or 4.125" unfinished</b>
<b>Bore &amp; stroke:</b>	<b>4.185" x 3.500" max recommended</b>
<b>Cam bearing bore ID:</b>	<b>SVO 2.203"- 2.205"</b>
<b>Cam bearings:</b>	<b>Special coated, grooved, w/3 oil holes</b>
<b>Cam Bearing O.S.</b>	<b>+ .010", +.020", +.030"</b>
<b>Cam bearing press:</b>	<b>.002" - .003"</b>
<b>Cam journal OD:</b>	<b>Standard Ford SB</b>
<b>Cam Plug:</b>	<b>2.375" Dia. Cup plug</b>
<b>Cylinder Wall Thickness:</b>	<b>.250" min @ 4.185" bore</b>
<b>Cubic inch:</b>	<b>385" max recommended</b>
<b>Deck Height:</b>	<b>8.200"</b>
<b>Deck Thickness:</b>	<b>.675" min.</b>
<b>Fuel Pump:</b>	<b>N/A</b>
<b>Freeze Plugs:</b>	<b>STD Ford press in cup plugs 1.500" OD</b>
<b>Head Bolts:</b>	<b>1/2" Blind holes</b>
<b>Lifter Bores:</b>	<b>STD Ford .8747" - .8757" Honed to size</b>
<b>Lifters:</b>	<b>STD Ford Hydraulic roller compatible</b>
<b>Main journal size:</b>	<b>2.249" STD 302</b>
<b>Main bearing bore:</b>	<b>2.441" - 2.442" Honed to size</b>
<b>Main thrust width:</b>	<b>.926" - .928"</b>
<b>Main Cap Bolts:</b>	<b>Inners 1/2-13 x 3.250 Qty 10 Outers 7/16-14 x 2.750 Qty 6 10-1/2 washers 6-7/16 washers</b>
<b>Main cap press:</b>	<b>.003" - .004"</b>
<b>Main caps:</b>	<b>Steel - splayed center three and two bolt front and rear</b>
<b>Main cap register:</b>	<b>Deep stepped register on each side (no need for dowels)</b>
<b>Oil system:</b>	<b>STD Wet Sump</b>
<b>Oil Filter:</b>	<b>Standard filter</b>
<b>Oil Pan:</b>	<b>Aftermarket 302 with dip stick in pan</b>
<b>Rear Main Seal</b>	<b>Std 1 piece seal - Felpro# 2922 or 2941 4.250"x3.625"</b>
<b>Serial No.</b>	<b>Right front &amp; main caps</b>
<b>Starter:</b>	<b>Standard</b>
<b>Stud &amp; bolt holes, Head:</b>	<b>1/2" STD SVO with Blind holes</b>
<b>Timing chain/gears</b>	<b>Standard components</b>
<b>Timing Cover:</b>	<b>Uses stock 302 cover</b>
<b>Torque Specs:</b>	<b>1-5 inners 1/2" bolts - 100 ft lbs 2-3-4 outers 7/16" bolts - 65 ft lbs</b>
<b>Weight, approx:</b>	<b>175 lbs w/4" bore 165lbs w/4.125" bore</b>