

Dart SHP *FORD* 302 SB Iron Block

Part#	31364175 31364275
Material:	Cast Iron
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
Cam Plug:	2.375" Dia. Cup plug
Cylinder Wall Thickness:	.250" min @ 4.185" bore
Cubic inch:	385" max recommended
Deck Height:	8.200"
Deck Thickness:	.675" min.
Fuel Pump:	N/A
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 Hydraulic roller compatible
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:	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
Main cap press:	.003" - .004"
Main caps:	Steel - splayed center three and two bolt front and rear
Main cap register:	Deep stepped register on each side (no need for dowels)
Oil system:	STD Wet Sump
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 inners 1/2" bolts - 100 ft lbs
	2-3-4 outers 7/16" bolts - 65 ft lbs
Weight, approx:	175 lbs w/4" bore 165lbs w/4.125" bore