

DART FORD 351 SBF Aluminum Block - *Technical notes*

Part#	31344195 - 31345295
Material:	RMR Cast Aluminum Alloy
Bore:	4.00" or 4.125" unfinished
Bore & stroke:	4.165" x 4.250" 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 Dart PN# 32510000
Cam Plug snap ring:	.030" thick Dart PN# 32610000
Cylinder Wall Thickness:	.250" min
Cubic inch:	463" max recommended
Deck Height:	9.200" & 9.500"
Deck Thickness:	.675" min.
Fuel Pump:	Mechanical pump provision
Freeze Plugs:	Threaded 1 5/16" OD w/ o-ring Dart PN# 32310000 & 32410000
Lifter Bores:	STD Ford .8747" - .8757" Honed to size
Lifters:	Tie-bar style lifters
Main journal size:	2.749" STD 351 Cleveland
Main bearing bore:	2.9415" - 2.9425" Honed to size
Main thrust width:	.913" - .915"
Main cap press:	.003" - .004"
Main caps:	Steel - 4 bolt, all 5
Main cap register:	Dowel pinned & deep stepped register on each side
Oil system:	STD Wet Sump or SVO dry sump
	Priority Main oiling with external pump (wet or dry)
Oil Filter:	Standard filter w/ adapter PN# 32940000 (Sold separately)
Oil Pan:	Requires oil pan specifically for a 4 bolt block.
Rear Main Seal	STD 1 piece seal - FelPro# 2921 or 2942 4.500"x 3.750" SVO
Serial No.	Right front & main caps
Sleeve OD:	4.300"
Sleeve O.S.	+ .010" & +.020" available
Sleeve thickness:	4.000" bore = .150" / 4.155" bore = .072"
Sleeve Length:	9.200" deck = 5.575" 9.500" deck = 5.850"
Studs, head:	1/2" Bind holes
Timing chain/gears	Standard components, 351W cover w/ late model 351W timing chain.
Torque Specs:	1-5 1/2" studs - 100 ft lbs
	2-4 7/16" bolts - 65 ft lbs
	1 & 5 3/8" bolts - 35 ft lbs
Weight, approx:	93 lbs - 9.500" 91 lbs - 9.200"

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