

DART ALUMINUM SBC Block

Part#	31111112 thru 31112232
Material:	355-T61 Aluminum alloy
Bore:	4.00" & 4.125"
Bore & stroke :	4.185" x 4.125" max recommended
Cam bearing bore ID:	BBC - 2.1195"- 2.1205"
Cam bearings:	Special coated, grooved, w/3 oil holes
Cam bearing O.S.	+ .010", +.020", +.030"
Cam bearing press:	.002"
Camshaft position:	Raised .391"
Camshaft to Crank Ø	4.912"
Camshaft snout:	SBC on all
Cam Drive:	Timing chain, Gear drive & Belt drive for raised cam
Cam Plug:	2.375" dia. cup plug
Cam Plug snap ring:	.030" thick
Cubic inch:	455" max recommended
Cylinder Wall Thickness:	.250" min
Deck Height:	9.025", 9.325" , 9.500"
Deck Thickness:	.625" min.
Fuel Pump:	Mechanical pump provision
Fuel Pump Pushrod:	+ .200" long 5.950" OA
Freeze Plugs:	Threaded 1 5/16" OD (1.312")
Lifter Bores:	SBC .8427" - .8437"
Main bearing size:	2.450" (350) 2.650" (400)
Main bearing bore:	(350) 2.6405 - 2.6415 (400) 2.8405 - 2.8415
Main caps:	Steel - 4 bolt .005" press
Oil system:	Wet or Dry Sump - Main Priority Oiling
Oil Pump shaft:	BBC shaft with wet sump, or NEW Moroso 22077 (preferred)
Oil Filter:	No provision
Oil Pan:	Pan rails spread .400" each side
Rear Main Seal	350 main - std seal / 400 main - Fel-Pro# 2909
Serial No.	Left front & main caps
Sleeve OD:	4.300"
Sleeve O.S.	+ .010" & +.020" available
Sleeve thickness:	4.00" bore - .150" / 4.125" bore - .087"
Sleeve Length:	9.025" = 5.625" / 9.325" = 5.925" / 9.500" = 6.100"
Starter:	Mounts on either side
Studs, Mains:	(4) studs, #2, #3, #4 have 7/16" splayed bolts
Studs, heads:	Must use our head studs
Studs holes, Head:	Blind holes
Stud length in block:	1.770" - 1.550" thrd + .270 bottom bullet
Timing chain/gears	Must use raised cam components
Timing Cover:	Can use stock cover / Mag w/fuel pump provision avail.
Torque Specs:	1-5 7/16" studs - 75 ft lbs
	2-4 7/16" bolts - 65 ft lbs
	Rear 1/2" studs - 100 ft lbs