

# Installation Instructions for 514040 to 514044

## Small Block Chevy 210cc Cylinder Heads

### Materials

Casting	A356-A Virgin Grade, Heat Treated to T-6
Valve Guides	Manganese Bronze
Valve Seats	Alloy, For use with Unleaded Gasoline

### Intake

Port Volume	210cc
Valve Diameter	2.055" Stainless Steel
Valve Length	4.910"
Valve Stem Diameter	11/32"
Valve Stem Seal Diameter	0.530", Teflon
Port Dimension	2.150" Tall x 1.300" Wide
Flow Rate	291 CFM @ 0.700" Lift - 28" H2O
Gasket	JEGS 555-210000 or equivalent

**Adjusting the Guide Plates:** The guide plates have some extra clearance around the holes to allow adjustment for optimum alignment (loosen the rocker studs and adjust the guide plates for best fit when assembling the valve-train on your engine). Make sure the pushrods don't rub on the heads and that rocker tip has adequate contact on the top of the valve stem. Re-torque the rocker studs to 45 ft/lbs.

### Exhaust

Port Volume	85cc
Valve Diameter	1.600" Stainless Steel
Valve Length	4.910"
Valve Stem Diameter	11/32"
Valve Stem Seal Diameter	0.530" Teflon
Port Dimension	1.530" Tall x 1.545" Wide "D" Shape
Flow Rate	216 CFM @ 0.700" Lift - 28" H2O
Gasket	555-210052 or equivalent

### Valve Train

Stud Size	3/8"-24 (555-20580)
Guide Plates	5/16" Flat (555-202000)
Pushrods	5/16" Hardened, <b>Must Check Length</b> - Use 555-80670 Pushrod Length Checker
Retainers	Chrome Moly Steel 7 Degree
Valve Locks	7 Degree
Spring Locator	I.D. Locator - 1.490" x .060"
Springs	1.440" OD Dual Spring - 0.600" Max Lift
Spring Pressure	1.440" Spring - 135# @ 1.800" / 340# @ 1.200" - Coil Bind - 1.125"

### Accessories

Head Bolts	555-83400 or equivalent ( <b>Use 555-28011 or similar sealant on the threads</b> )
Head Studs	Standard SB-Chevy

**NOTE: The head bolt washer located in between the two middle exhaust valve springs may require trimming due to spring locator interference. The edges should be "Clipped" to allow the washer to lay flat without contacting the spring locator.**

Spark Plug	14mm x 3/4" Reach - Gasket Seat - 5/8" Hex
Stud Girdle	JEGS 555-20510 or equivalent
Rocker Arms	Stock Size HP SB-Chevy for 3/8"-24 Studs (i.e. extruded aluminum or HD Steel)
Head Gasket	555-210041 or equivalent
Accessory Bolt Locations	Stock Placement

### Torque Specifications

Rocker Studs	45 ft/lbs.
Manifold Bolts	35 ft/lbs.
Head Bolts or Studs	Per Specifications of the Fastener Manufacturer

**NOTE: Piston to valve clearance should always be checked!**



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