

# Installation Instructions for 514070 Big Block Chevy 320cc 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	320cc
Valve Diameter	2.250" Stainless Steel
Valve Length	5.490"
Valve Stem Diameter	11/32"
Valve Stem Seal Diameter	0.530", Teflon
Port Dimension	2.325" Tall x 1.625" Wide
Flow Rate	395 CFM @ 0.700" Lift - 28" H2O
Gasket	JEGS 555-210100 or equivalent

## Exhaust

Port Volume	140cc
Valve Diameter	1.880" Stainless Steel
Valve Length	5.350"
Valve Stem Diameter	11/32"
Valve Stem Seal Diameter	0.530", Teflon
Port Dimension	1.780" Tall x 1.950" Wide
Flow Rate	265 CFM @ 0.700" Lift - 28" H2O
Gasket	555-210151 or equivalent

## Valve Train

Stud Size	7/16"-24 (555-20582)
Guide Plates	3/8" (555-202010)
Pushrods	3/8" Hardened, <b>Must Check Length</b> - Use 555-80670 Pushrod Length Checker
Retainers	Chrome Moly Steel 10 Degree
Valve Locks	10 Degree
Spring Locator	I.D. Locator - 1.570" x .060"
Springs	1.550" OD Double Spring - 0.700" Max Lift
Spring Pressure	1.550" Spring - 240# @ 2.000" / 600# @ 1.250" - Coil Bind - 1.200"

## Accessories

Head Bolts	ARP 070-135-3603 or equivalent	Requires 4 longer bolts or studs over each exhaust port which are included in the recommended kits. The longer bolts and studs can also be purchased separately.
Head Studs	ARP 070-235-4103 or equivalent	
Spark Plug	14mm x 3/4" Reach - Gasket Seat - 5/8" Hex	
Stud Girdle	JEGS 555-20518 or equivalent	
Rocker Arms	Standard BB-Chevy For 7/16"-24 Studs	
Head Gasket	555-210142 or equivalent	
Accessory Bolt Locations	Stock Placement	
Pistons	Most Aftermarket Pistons. Heads have 24° Intake Valve and 15° Exhaust Valve	
Intake Manifolds	Cylinder heads do not utilize the upper intake manifold bolt hole between the intake ports. It is up to the installer to insure the manifold properly covers the port and seals.	

## 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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