



## Trick Flow Ultra 18™ 250 Cylinder Heads

### General Specifications

- Material: A356-T6 Aluminum alloy
- Intake Port Volume: 250cc Competition Ported
- Intake Port Dimensions: 1.350" x 2.200"
- Intake Seat Material: Ductile iron (TFS-31800271)
- Intake Valve: 2.150", 11/32" stem, 5.560" OAL (TFS-31800211)
- Combustion Chamber Volume: 56cc CNC-Profiled
- Exhaust Port Volume: 100cc Competition Ported
- Exhaust Port Dimensions: 1.760" x 1.460" Oval
- Exhaust Seat Material: Copper bronze alloy (TFS-31800272)
- Exhaust Valve: 1.600", 11/32" stem, 5.570" OAL (TFS-31800212)
- Exhaust Flange Pattern: Standard GM 18° Chevy
- Plug Location: Standard GM 18° Chevy
- Spring Pocket Diameter: 1.660"
- Valve Guide Material: Manganese bronze
- Seals: Viton® fluoroelastomer (TFS-51400454)
- Locks: 10° w/recess for lash cap (TFS-52400444)
- Retainers: 10° titanium 1.550" (TFS-214T0520)
- Valve Spring ID Locators: 1.550" x .060" thick (TFS-21400440)
- Springs: 1.560" O.D. Double spring with damper (TFS-16318-16)  
240lbs @ 2.000" installed height  
500 lbs/inch rate  
.700" max lift
- Maximum Intake Valve Diameter: 2.20"
- Minimum Bore Diameter: 4.155"

### Recommended Parts

- Rocker Arms: Shaft-style with a .550" offset on the intakes and a .220" offset on the exhausts.
- Lifters: Requires roller lifters with a .180" offset on the intakes and no offset on the exhausts.
- Gaskets: Intake: TFS-31800921  
Exhaust: TFS-31800931  
Head: TFS-30494200-040
- Head Studs: ARP 234-4721
- Head Bolts: ARP 234-3721
- Spark Plugs: Autolite 3932
- Manifold: Requires intake manifold designed for the 18° heads
- Headers: Requires headers designed for the 18° heads

**NOTES:** After all machining and cleaning operations are complete; you must install the small allen plugs into the holes on the exhaust side of the head (located between the center exhaust ports). Use a small amount of thread sealer to prevent any leaks. Do not screw the plug in too far.

## **Ultimate Bolt-On Performance® Lifetime Warranty**

**Trick Flow Specialties cylinder head castings are backed by a lifetime warranty. If a cylinder head casting fails to provide the original purchaser with complete satisfaction, Trick Flow Specialties will repair or replace it free of charge — guaranteed!**

Moreover, the valves, valve guides, valve seats, valve job, valve springs, valve spring retainers, valve locks, rocker arm studs, guideplates, and valve stem seals included on assembled Trick Flow Specialties cylinder heads are warranted to the original purchaser to be free from defects in materials and workmanship for a period of two years from the date of purchase. All other Trick Flow Specialties products are warranted to be free from defects in materials and workmanship for a period of 90 days. There are no mileage limitations.

### **Extent of Warranty**

Customers who believe they have a defective product should return it to the dealer from which they purchased or ship it freight prepaid to Trick Flow Specialties along with proof of purchase and a complete description of the problem. If a thorough inspection indicates defects in materials or workmanship, our sole obligation is to repair or replace the product.

This warranty is only if the product is properly installed, subjected to normal use and service, did not fail due to owner negligence or misuse, and has not been altered or modified.

Trick Flow Specialties warranties do not cover any installation or removal costs.

Trick Flow Specialties is not liable for consequential damages for breach of contract of any warranty in excess of the purchase price of the product sold.

### **PROPOSITION 65 WARNING**

This product may contain one or more substances or chemicals known to the state of California to cause cancer, birth defects or other reproductive harm.

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