



**VICTOR 18° CNC & VICTOR 23° HIGH-PORT CNC
ALUMINUM CYLINDER HEADS FOR SMALL-BLOCK CHEVROLET V8s
CATALOG #6104 Through #6124
INSTALLATION INSTRUCTIONS**

- **PLEASE** study these instructions carefully before installing your new cylinder heads. If you have any questions or problems, do not hesitate to contact our **Technical Hotline at: (800) 416-8628** from 7:00 am to 5:00 pm, Monday through Friday, Pacific Standard Time or e-mail us at: edelbrock@edelbrock.com.
- **DESCRIPTION**

Victor 23° High-Port CNC heads are ideal for applications that require higher flow levels than those available from standard port heads. Fully CNC-ported by Mike Chapman and his team of expert machinists, these heads have 71cc combustion chambers and come in three intake port sizes. The valve cover rail is raised .600" and the rocker arm minimum offsets are: Intake .350" with zero offset on the exhaust side. These heads require intake and exhaust valves that are +.200" longer than stock or if 1.980" or taller valve spring height is maintained, use .300" long valves. Actual flow at 28" of water: 240 cfm on the exhaust and 314 cfm on the 238cc intake, 315 cfm on the 243cc intake, and 321 cfm on the 247cc intake. Match these heads with our Victor Series High-Port manifolds for maximum, proven performance and a winning combination.

Victor 18° CNC heads have fully CNC-ported combustion chambers, intake and exhaust ports. An ideal match for Edelbrock Victor Series 18° manifolds, these heads have a 1.625" exhaust valve diameter with a 2.125" intake valve diameter for the 236cc port and a 2.180" intake valve diameter for the larger ports. They require valves that are +.600" longer than stock (+.700" longer for 6117) with rocker arm minimum offsets of .550" intake and .220" exhaust. The intake flange is drilled for both one- and two-piece manifolds.

VICTOR 18° CNC HEADS							
Chamber Size	Intake Port	Intake Valve Size	Exhaust Valve Size	Valve Length	Min. Cross Sectional Area	Part No. (pair)	Part No. (single)
52cc	236cc	2.125	1.625	+.600	2.50	#6104	#61049
65cc	236cc	2.125	1.625	+.600	2.50	#6110	#61109
52cc	246cc	2.150	1.625	+.600	2.612	#6115	#61159
65cc	246cc	2.150	1.625	+.600	2.612	#6118	#61189
52cc	252cc	2.180	1.625	+.600	2.625	#6106	#61069
65cc	252cc	2.180	1.625	+.600	2.625	#6112	#61129
52cc	256cc	2.180	1.625	+.600	2.71	#6108	#61089
65cc	256cc	2.180	1.625	+.600	2.71	#6114	#61149
52cc	266cc	2.180	1.625	+.600	2.71	#6116	#61169
65cc	266cc	2.180	1.625	+.600	2.71	#6119	#61199
47cc	255cc	2.150	1.625	+.700	2.625	#6105	#61059
47cc	270cc	2.180	1.625	+.700	2.71	#6117	#61179
VICTOR 23° CNC HEADS							
71cc	238cc	2.100	1.625	+.200*	2.684	#6120	#61209
71cc	243cc	2.100	1.625	+.200	2.53	#6122	#61229
71cc	247cc	2.100	1.625	+.200	2.53	#6124	#61249

- **ACCESSORIES:** Although Edelbrock Cylinder Heads will accept some OEM components (valve covers, etc.), we highly recommend that premium quality hardware be used with your new heads.
- **HEAD BOLTS or STUDS:** High quality head studs or head bolts with hardened washers, such as Edelbrock Head Bolt Kit #8550, ARP stud kit #234-4601, ARP bolt kit #434-3701, etc., must be used for proper gasket seal and to prevent galling of the aluminum bolt bosses.
- **ROCKER ARMS: Roller rocker arms and hardened pushrods must be used,** along with hardened pushrod guideplates. Carefully check clearance between rockers and valve covers and between pushrod and head.
- **VALVE COVERS:** Edelbrock Victor series heads accept standard small-block Chevrolet racing valve covers such as Edelbrock #4153, #4154, #4156, #4157, #4166, or #4167. These die-cast valve covers are available polished or black, with or without breather tubes.
- **INTAKE MANIFOLD:** Edelbrock Victor 23° High-Port CNC cylinder heads are matched in size and operating range with Edelbrock Victor Jr. High-Port intake manifold #2967 or Victor High-Port #2926, #2968 #2971. Fel-Pro intake manifold gaskets #1263 are recommended.

Edelbrock Victor 18° CNC cylinder heads are matched in size and operating range with Edelbrock Victor Series intake manifolds #2959, #2993, #2994, #2995 and #2950 as well as two-piece manifolds base #2992 and spiders #2958, #2955 and #2922. Fel-Pro intake manifold gaskets #1282 are recommended.
- **SPARK PLUGS:** Use 14mm x 3/4" reach gasketed spark plugs. Heat range may vary by application, but we recommend Champion "C" series for most applications. Champion "C" series have a 5/8" hex and are 1/4" shorter than "N" series plugs and may be required for header clearance. Use anti-seize on the plug threads to prevent galling in the cylinder head, and torque to 10 ft./lbs. Do not overtighten sparkplugs!

Victor CNC heads are not legal for sale or use on pollution-controlled motor vehicles.

