



VICTOR AS-CAST ALUMINUM CYLINDER HEADS  
 For Small-block CHEVROLET V8s  
 #77509, #77519, #77529, #77559  
 INSTALLATION INSTRUCTIONS

DESCRIPTION

Edelbrock Victor As-Cast Small Block Chevrolet heads are for the professional cylinder head shop or engine builder. We offer them in both Victor 23° and 18° versions. The as-cast ports have enough metal thickness to allow for hand or CNC porting to several different sizes for various applications providing the versatility for whatever your design requirements may be. Manganese-bronze replaceable guides and ductile iron seats included but are not installed. The proper valve seat insert installation will require machining the seat insert bores to the press fit size of seats being used. Valve guide bores are machined to final size. Valve stem clearance needs to be finished by reaming and honing guides to size.

Note: Parts listed below are included but NOT installed.

Qty	Description
1	Cylinder head
6	3/8-16 x .500 Helicoil
8	7/16-14 x .625 Helicoil
4	Valve Seat 2.250 OD. x 0.400 Tall x 1.81 ID
4	Valve Seat 1.680 OD. x 0.400 Tall x 1.35 ID
8	Valve guide 0.502 OD. x 2.23 Long

Edelbrock Corporation  
 2700 California St.  
 Torrance, CA 90503

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