

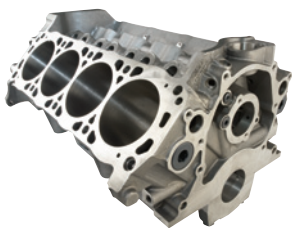


<b>ENGINE GROUP PART NUMBER</b>	<b>302 FORD M-6010-BOSS302</b>	<b>302 FORD M-6010-B302BB</b>	<b>351 FORD M-6010-BOSS35192</b>	<b>351 FORD M-6010-BOSS35195</b>	<b>351 FORD M-6010-BOSS3518B</b>
Description/Intended Usage	Professional Competition	Professional Competition	Professional Competition	Professional Competition	Professional Competition
Block Material	Cast Iron	Cast Iron	Cast Iron	Cast Iron	Cast Iron
Nominal Deck Height	8.206"	8.206"	9.200"	9.500"	9.500"
CID Capacity	363	363	427	454	468
Cylinder Design	Siamese	Siamese	Siamese	Siamese	Siamese
Cylinder Bore Range	4.000-4.125"	4.125"	4.000-4.125"	4.000-4.125"	4.125"-4.185"
Oil Sump Design	Wet	Wet	Wet	Wet	Wet
Crankshaft Journal Diameter	2.2480"	2.248"	2.750"	2.750"	2.750"
Main Cap Bolts	Four on 2,3,4	Four on 2,3,4	Four on 2,3,4	Four on 2,3,4	Four on 2,3,4
Bearing Cap Material	Nodular Iron	Nodular Iron	Nodular Iron	Nodular Iron	Nodular Iron
Recommended Max. Stroke	3.400"	3.400"	4.000"	4.250"	4.250"
Rear Crankshaft Seal Type	1-Piece	1-Piece	1-Piece	1-Piece	1-Piece
Cam Bearing Design	M-6261-R351 Common Journal Dia. Cam Req'd. M-6261-J351 Standard Cam	M-6261-R351 Common Journal Dia. Cam Req'd. M-6261-J351 Standard Cam	M-6261-R351 Common Journal Dia. Cam Req'd. M-6261-J351 Standard Cam	M-6261-R351 Common Journal Dia. Cam Req'd. M-6261-J351 Standard Cam	M-6261-R351 Common Journal Dia. Cam Req'd. M-6261-J351 Standard Cam
Oil Filter Mount	Block	Block	Block	Block	Block
Hyd. Roller Cam. Compatible	Yes	Yes	Yes	Yes	Yes
Cam Plug	M-6026-S351	M-6026-S351	M-6026-S351	M-6026-S351	M-6026-S351

<b>ENGINE GROUP PART NUMBER</b>	<b>351 FORD M-6010-CG452</b>	<b>351 FORD M-6010-Z351</b>	<b>460 FORD M-6010-A460</b>	<b>460 FORD M-6010-A460BB</b>	<b>NASCAR® FORD M-6010-R500</b>	<b>NHRA® FORD M-6010-JC50</b>
Description/Intended Usage	Professional Competition	Professional Competition	Professional Competition	Professional Competition	Professional Competition	Professional Competition
Block Material	Compacted Graphite Iron	Aluminum	Cast Iron	Cast Iron	Compacted Graphite Iron	Compacted Graphite Iron
Nominal Deck Height	9.125"	9.500"	10.322"	10.322"	9.000"	9.125"
CID Capacity	434	434	598	598	–	–
Cylinder Design	Siamese	Siamese	Siamese	Siamese	Non-Siamese	Siamese
Cylinder Bore Range	4.000-4.180"	4.000-4.125"	4.360-4.600"	4.500-4.600"	4.000-4.185"	4.590-4.750"
Oil Sump Design	Dry	Wet	Wet	Wet	Dry	Dry
Crankshaft Journal Diameter	2.248"	2.750"	3.000"	3.000"	2.000-2.250"	2.500"
Main Cap Bolts	Four	Four	Four on 2,3,4,5	Four on 2,3,4,5	Four	Four
Bearing Cap Material	Steel	Steel	Nodular Iron	Nodular Iron	Steel	Steel
Recommended Max. Stroke	4.000"	4.250"	4.500"	4.500"	–	–
Rear Crankshaft Seal Type	1-Piece	1-Piece	2-Piece	2-Piece	1-Piece	1-Piece
Cam Bearing Design	M-6261-R351 Common Journal Dia. Cam Req'd. M-6261-J351 Standard Cam	M-6261-R351 Common Journal Dia. Cam Req'd. M-6261-J351 Standard Cam	Std.	Std.	Roller	Roller
Oil Filter Mount	Remote	Block	Block	Block	Remote	Remote
Hyd. Roller Cam Compatible	No	–	–	–	–	–
Cam Plug	M-6026-S351	M-6026-S351	–	–	–	–



## FR BOSS 302



*Did you know...*

*The BOSS 302 block features cylinder bores designed for stroker applications without additional clearancing. Durability tested up to 3.400" stroke, some racers have run as much as 3.500" stroke and 9.00 second E.T.s!*

## FR BOSS 351



	<b>STOCK 302</b>	<b>1969-1970 BOSS 302</b>	<b>FR BOSS 302</b>	<b>1971 BOSS 351</b>	<b>FR BOSS 351 9.2"</b>	<b>FR BOSS 351 9.5"</b>
<b>Main caps</b>	2-bolt cast iron	4-bolt cast iron (2,3,4)	4-bolt nodular iron machined splayed (2,3,4)	4-bolt cast iron	4-bolt nodular iron machined splayed (2,3,4)	4-bolt nodular iron machined splayed (2,3,4)
<b>Siamese bore</b>	No	No	Yes with engineered cross drilling	No	Yes with engineered cross drilling	Yes with engineered cross drilling (BB no cross drilling)
<b>Freeze plugs</b>	Press	Screw in tapered pipe thread	Screw in O-ring sealed straight thread	Press	Screw in O-ring sealed straight thread	Screw in O-ring sealed straight thread
<b>Material</b>	Cast iron	Cast iron	Diesel-grade heat treated cast iron	Cast iron	Diesel-grade heat treated cast iron	Diesel-grade heat treated cast iron
<b>Head bolts</b>	7/16"	7/16"	1/2"	1/2"	1/2"	1/2"
<b>Recommended max. bore</b>	4.030"	4.030"	4.125"	4.030"	4.125"	4.125" (BB 4.185 with sonic check)
<b>Front oil crossover for lifter galley</b>	No	No	Yes	No	Yes	Yes
<b>Main bolts</b>	7/16"	7/16" (all) 3/8" outer (2,3,4)	1/2" (all) 3/8" outer (2,3,4)	1/2" (all) 3/8" (all)	1/2" (all) 3/8" outer (2,3,4)	1/2" (all) 3/8" outer (2,3,4)
<b>Oil galley plugs</b>	Pipe thread and press in	Pipe thread	Screw in O-ring sealed straight thread	Pipe thread and modified locking	Screw in O-ring sealed straight thread	Screw in O-ring sealed straight thread
<b>Hydraulic roller compatible</b>	Yes	No	Yes	No	Yes	Yes
<b>Clutch cross shaft pivot hole</b>	No	Yes	Yes	Yes	Yes	Yes
<b>Rear main seal</b>	1-Piece	2-Piece	1-Piece	2-Piece	1-Piece	1-Piece
<b>CID capacity</b>	347	347	363	408	427	454 (BB 468)

<b>Block</b>	<b>M-6010-BOSS302</b>	<b>M-6010-B302BB</b>	<b>M-6010-BOSS35192</b>	<b>M-6010-B35192BB</b>	<b>M-6010-BOSS35195</b>	<b>M-6010-BOSS351BB</b>
Bore Size as delivered	3.990" - 3.995"	4.115" - 4.120"	3.990" - 3.995"	4.115" - 4.120"	3.990" - 3.995"	4.115" - 4.120"
Siamese Bore	Yes	Yes	Yes	Yes	Yes	Yes
Cross Drilled	Yes	No	Yes	No	Yes	No
Maximum Bore Size	4.125"	Sonic test for greater than 4.125"	4.125"	Sonic test for greater than 4.125"		Sonic test for greater than 4.125"
Maximum Stroke recommended	3.400"	3.400"	4.000"	4.000"	4.250"	4.250"
Main Bearings	Main bearing bore same as stock 302	Main bearing same as as stock 302	Main bearing bore same as stock 351 Cleveland	Main bearing bore same as stock 351 Cleveland	Main bearing bore as stock 302 stock 351 Cleveland	Main bearing bore same as stock 351 Cleveland
Deck Thickness	.500" - .560"	.500" - .560"	.500" - .560"	.500" - .560"	.500" - .560"	.500" - .560"
Head Bolt Size			1/2-13 UNC			
Lifter Bore Size	.8753" - .8768"	.8753" - .8768"	.8753" - .8768"	.8753" - .8768"	.8753" - .8768"	.8753" - .8768"
Rear Seal Type	1-piece rear seal M-6701-B302	1-piece rear seal M-6701-B302	1-piece rear seal M-6701-B351	1-piece rear seal M-6701-B351	1-piece rear seal M-6701-B351	1-piece rear seal M-6701-B351
Weight	175	175	195	195	205	205
Maximum Displacement	363 cubic inches	363 cubic inches	427 cubic inches	427 cubic inches	454 cubic inches	454 cubic inches
<b>Recommended Parts</b>						
Head Gaskets	M-6051-S331 M-6051-CP331 M-6051-R351 M-6051-B341	M-6051-R351	M-6051-S331 M-6051-CP331 M-6051-R351 M-6051-B341	M-6051-R351	M-6051-S331 M-6051-CP331 M-6051-R351 M-6051-B341	M-6051-R351
Cam Bearings	M-6261-J351 or M-6261-R351					
Head Stud Kit	Head Stud Kit M-6014-Z304, M-6014-BOSS					
Head Bolt Kit	Head Bolt Kit M-6014-BOSS					
Rear Main Seal	M-6701-B302	M-6701-B302	M-6701-B351	M-6701-B351	M-6701-B351	M-6701-B351