

PART NUMBER 12491352 - 454 REMANUFACTURED (1991-1993)

RPO	L19	VALVE SYSTEM	
GENERAL (STOCK CONFIGURATION)		Type	OHV
Liter Displacement	74	Lifters	New - hydraulic flat tappet
Cubic Inch Displacement	454	Valve Rotators	Intake/exhaust
Bore (Inches/mm)	4.25/107.95	Pushrods	5/16" tubular steel
Stroke (Inches/mm)	4.00/101.60	Rocker Arm Ratio	1.7:1
Compression Ratio	7.9:1	VALVES	
Firing Order	1-8-4-3-6-5-7-2	Intake Valve Material	New - S.B. International
Cylinder Head Material	Cast iron	Intake Face Angle (degrees)	45
Block Material	Cast iron	Intake Guides	Press-in/reamed for oversize valve stem
Main Bearing Cap Design	4-bolt	Intake Head Diameter (inches)	2.065
Horsepower	230	Intake Lift (inches)	0.43000
BLOCK		Intake Duration (degrees)	224
Core Plug Material	Brass	Exhaust Valve Material	New - S.B. International
Cylinder Bore Remanufacturing	Cylinders bored oversize (.040" Max.) Honed to match ring set	Exhaust Face Coating	Hard faced
CAMSHAFT		Exhaust Face Angle (degrees)	45
Material	Cast iron	Exhaust Guides	Press-in/reamed for oversize valve stem
Camshaft Type	New, flat tappet	Exhaust Head Diameter (inches)	1.72
Cam Bearings	New - bored to OE spec	Exhaust Lift (inches)	0.39829
Number of Bearings	5	Exhaust Duration (degrees)	224
Type of Drive	Single-row roller chain	OIL PUMP	
CRANKSHAFT		Type	New - Melling assembly (with screen)
Material	Cast nodular iron	Oil Pressure	Stock
Crankshaft Remanufacturing	Ground undersize (.020" Max.) protecting undercut fillets for maximum strength/micro-polished	Volume	Stock
Main Bearings	Federal Mogul	NOTES	
Number of Bearings	5	Camshaft for engine 12491352 is 3963544.	
Rear Main Seal	1 pc.	Customer must transfer oil pan and valve covers from old engine or purchase new.	
CONNECTING RODS			
Material	Forged steel		
Connecting Rod Remanufacturing	Bores and beam gauged/big-end resized if necessary		
Length (center to center, inches)	6.135 (stock)		
Rod Bearings	Federal Mogul		
PISTONS			
Material	Graphite-coated hypereutectic		
PISTON RINGS			
Material	Federal Mogul ("Premium Rings")		