

Table of Contents

Chapter 1: The Flathead Ford– An Overview

- Summary 1-1
- The Purpose of This Book 1-2
- Flathead Ford Defined 1-2
- Flathead Ford Significance & Popularity 1-2
- Rebuilder Resources 1-5
- The Flathead Ford - Part Numbers 1-6
- Flathead Evolution - Three Generations of Ford Flatheads 1-8
- Doing Our Homework : Buy the Book Before the Rebuild 1-8
- Engine Rebuild Cost 1-9
- A Preview of Major Points in This Book 1-10

Chapter 2: Flathead Evolution

- Summary 2-1
- The Flathead Evolution 2-2
- First Generation Ford Flatheads – 1932 to 1937 2-3
- Second Generation Ford Flatheads – 1938 to 1948 2-8
- Third Generation Ford Flatheads – 1949 to 1953 2-11

Chapter 3: Block and Main Cap Assemblies

- Summary 3-1
- Blocks - General 3-2
- Blocks - Evolution & Identification 3-3
- Blocks - Sleeving 3-8
- Blocks - Cleaning, Inspection, & Rebuilding 3-8
- Blocks - Replacement 3-10
- Rear Main Bearing Caps and Seals 3-12
- Main Bearings 3-13
- Cam Bearings 3-13
- Fuel Pump Push Rod Bearing 3-13

Chapter 4: Crankshaft & Related Parts

- Summary 4-1
- Crankshaft - Evolution & Identification 4-2
- Crankshaft - Cleaning, Inspection & Rebuilding 4-6
- Crankshaft - Aftermarket Replacement 4-7
- Flywheel and Ring Gear Assemblies 4-10

| | |
|---|------|
| Chapter 5: Piston & Connecting Rod Assembly | |
| • Summary | 5-1 |
| • Piston Evolution and Identification | 5-2 |
| • Piston Replacement | 5-6 |
| • Piston Rings | 5-9 |
| • Connecting Rod Evolution and Identification | 5-12 |
| • Rod and Rod Bearing Inspection, Reconditioning, and Replacement | 5-13 |
| | |
| Chapter 6: Camshaft & Valve Train | |
| • Summary | 6-1 |
| • Camshaft | 6-2 |
| • Tappets (Lifters) | 6-4 |
| • Aftermarket Tappet Problems | 6-4 |
| • Valve and Valve Spring Retainers | 6-7 |
| • Valve Guides and Seals | 6-7 |
| • Valve Springs | 6-9 |
| • Hardened Valve Seats in the Block | 6-10 |
| • Timing Gear and Other Cam Mounted Gears | 6-11 |
| • Selecting a Camshaft for Road Applications | 6-12 |
| | |
| Chapter 7: Heads, Head Gaskets, and Sparkplugs | |
| • Summary | 7-1 |
| • First Generation Ford Flathead Heads - 1932 to 1937 | 7-2 |
| • Combustion Chamber Shape | 7-6 |
| • Second Generation Ford Flathead Heads - 1938 to 1948 | 7-8 |
| • Third Generation Ford Flathead Heads - 1949 to 1953 | 7-9 |
| • Markings on Third Generation Heads | 7-10 |
| • Head Gaskets | 7-12 |
| • Head and Gasket Cooling Passages | 7-12 |
| • Sparkplugs | 7-13 |
| | |
| Chapter 8: Flathead Ford Oil Pumps, Oil Pans & Filters | |
| • Summary | 8-1 |
| • Flathead Ford Oil Pumps - 1932 to 1953 | 8-2 |
| • Flathead Ford Oil Pans - 1932 to 1953 | 8-4 |
| • Flathead Ford Oil Filters | 8-8 |
| • Additional Notes/Cautions - Full Flow Oil Filter Conversion Systems | 8-10 |
| | |
| Chapter 9: Flathead Ford Specifications & Rebuilder's Tips | |
| • Summary | 9-1 |
| • Engine Machining & Assembly | 9-2 |
| • Boring and Honing Using Deck Plates | 9-2 |
| • Boring and Honing General Recommendations | 9-2 |

Chapter 9: Flathead Ford Specifications & Rebuilder's Tips (continued)

- Engine Geometry & Machining Datums 9-4
- Engine Inspection, Measuring & Gauging 9-4
 - First and Second Generation Engines Fit and Clearance Specifications 9-4
 - Third Generation Engine Fit and Clearance Specifications 9-4
 - Measuring vs. Gauging for Checking Clearances and Fits 9-4
 - Balancing 9-4
 - Dynamometer Testing 9-5
- Fasteners 9-5
 - Flathead Ford Torque Specifications Summary 9-5
 - Ford Head Bolts 9-5
 - Stainless Steel & Aluminum Threaded Parts Installation 9-5
 - Threaded Parts Specifications 9-6
 - Lock Washers 9-6
 - Flat Washers 9-6
- Gaskets and Seals 9-6
 - Head & Head Gasket Installation 9-6
 - Rope-type Crankshaft Front Seals 9-7
 - One-Piece Elastomeric Crankshaft Front Seals 9-8
 - Rope-type Crankshaft Rear Seals 9-8
- General 9-8
 - Valve Seats 9-8
 - Retaining Flathead Water Pump Pulleys 9-9
 - Exhaust Dividers 9-9
 - High Volume Oil Pumps 9-9
 - Oil Filters 9-10
 - Motor Oil for the Flathead 9-10
 - Air Filters 9-11
 - Electric Fuel Pumps 9-11

Chapter 10: Wrap Up

- Summary 10-1
- Major Points in this Book 10-2
- Engine Bolt-ons 10-2
 - Carburetors and Intake Manifolds 10-2
 - Distributors 10-2
 - Starters and Generators 10-2
 - Exhaust Manifolds 10-2
 - Water Pumps 10-2
- Engine Tune-up 10-3
- Engine Performance Modifications 10-4
 - Dual Exhaust 10-4
 - Higher Compression 10-4

Chapter 10: Wrap Up (continued)

- Larger Displacement 10-4
- Additional Carburetion 10-4
- High Performance Camshaft 10-4
- Porting and Relieving 10-5
- Supercharging 10-5
- Combinations of Stock Parts 10-5
- What to Expect From Your Flathead 10-5
- My Favorite Flathead 10-6
- Is Your Vehicle Constipated? 10-8

Appendix A – References & Resources

- Major References Used for this Book A-2
- Information, Parts, and Services Directory A-3

Appendix B – Second Generation Engine Rebuilder Information

Appendix C – Third Generation Engine Rebuilder Information

Appendix D – Sir Harry Ricardo and the Ricardo Head

- Who was Sir Harry, and Why Do We Care? D-1
- Calculating Flathead Compression Ratio D-4

Appendix E – Flathead Cooling

- Cooling - General E-1
- Cooling - Late Heads vs. Early Heads E-3
- Cooling - Later vs. Early Water Pumps E-4
- Cooling - Radiator Pressure Caps E-4