

BIG BLOCK CHEVROLET MERLIN INTAKE MANIFOLDS

Because World Products specializes in large displacement engines, it would stand to reason that the company would develop intake manifolds designed for big-inch motors. This is certainly the case with the Merlin family of intakes, of which several models are intended for use on 500 cubic inch and larger big block Chevy engines. In fact, an extensive manifold dyno test on a 632 c.i.d. engine showed the Merlin (p/n 063040) to produce 35 more horsepower than the competition!

In addition to out-powering the competition, it's important to note that these single plane manifolds are designed to operate most efficiently in the

2500 to 7500 RPM range (or 3500-8500), and have excellent low-end throttle response. They are also equipped with bosses to accommodate installing nitrous oxide port nozzles.

Models that accommodate a 4150-style carb and those for a 4500-style "Dominator" are offered for both standard and tall deck applications, as are manifolds specially machined for EFI setups.

World also offers a complete line of Merlin intake manifolds for marine applications. They feature an integral brass water jacket to eliminate corrosion when in a saltwater environment.



Part #	Marine	Flange	Deck	NOS Bosses	EFI	Plenum	RPM Range	OAH	Notes
063020		4150	9.800"	No	No	Dual	1500 - 6500	6.000"	
063030		4150	9.800"	Yes	No	Single	2500 - 7500	6.000"	
063030-EFI		4150	9.800"	Yes	Yes	Single	2500 - 7500	6.000"	C
063031		4150	10.200"	Yes	No	Single	2500 - 7500	6.375"	
063032		4500	9.800"	Yes	No	Single	2500 - 7500	8.125"	
063033		4500	10.200"	Yes	No	Single	2500 - 7500	8.250"	
063040		4500	9.800"	Yes	No	Single	3500 - 8500	6.125"	B
063040-EFI		4500	9.800"	Yes	Yes	Single	3500 - 8500	6.125"	B, C
063041		4500	10.200"	Yes	No	Single	3500 - 8500	6.375"	B
063034	Yes	4150	9.800"	Yes	No	Single	2500 - 7500	6.000"	A
063035	Yes	4150	10.200"	Yes	No	Single	2500 - 7500	6.375"	A
063036	Yes	4500	9.800"	Yes	No	Single	2500 - 7500	8.125"	A
063037	Yes	4500	10.200"	Yes	No	Single	2500 - 7500	8.250"	A
063042	Yes	4500	9.800"	Yes	No	Single	3500 - 8500	6.125"	A, B
063043	Yes	4500	10.200"	Yes	No	Single	3500 - 8500	6.375"	A, B

Notes:
 A = Integral brass water jacket cast in place (Marine version) B = Recommended for larger cubic inch engines such as a 500" and up C = Machined for Accel EFI unit

Available options:
 polishing (6 to 8 weeks lead time)

Accessories:
 832922 Stainless steel intake manifold bolt kit (hex head)
 - Fits 9.800" deck only

Contact your World sales representative for details.

BBC VALVE COVERS

Dress up your engine with the valve covers of your choice. New displacement-focused World polished aluminum covers let you show that size does matter.

Part #	DESCRIPTION
070742	MERLIN short chromed steel
070850S	LIMITED EDITION 632 polished aluminum
07093-509W	509 WORLD polished aluminum
07093-540W	540 WORLD polished aluminum
07093-572W	572 WORLD polished aluminum
07093-632W	632 WORLD polished aluminum
07093-M	MERLIN polished aluminum
07093-W	WORLD polished aluminum

Accessories:
 832920 Stainless steel valve cover bolt kit (hex head)
 - Fits stamped steel and aluminum covers



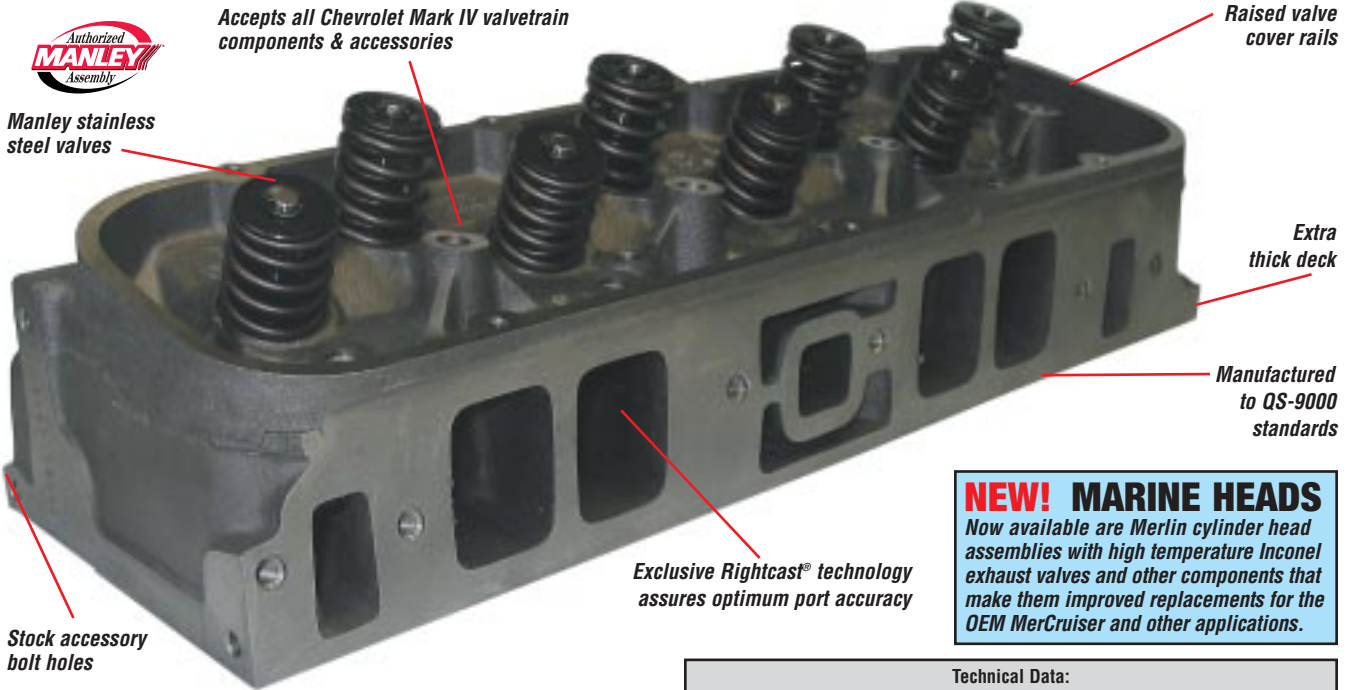
MERLIN OVAL & RECTANGULAR PORT CAST IRON CYLINDER HEADS

BIG BLOCK CHEVROLET

World's Merlin series has earned a reputation as the performance industry standard for Big Block Chevy power. The cast iron Merlins are available in both oval and rectangular port designs, with intake ports offered in 269, 320 and 345cc configurations. Choose the port size that will provide the optimum balance of flow and velocity for your engine combination. They are

available bare, or in complete assemblies that feature multi-angle valve jobs, Manley stainless steel valves and valve springs matched to camshaft requirements

New this year are special Marine heads with ultra high temperature Inconel exhaust valves and other special components.



NEW! MARINE HEADS
 Now available are Merlin cylinder head assemblies with high temperature Inconel exhaust valves and other components that make them improved replacements for the OEM MerCruiser and other applications.



Choice of 269cc oval port or 320cc and 345cc rectangular intakes



119cc combustion chamber with 2.300" intake and 1.880" exhaust

Technical Data:	
Casting ID Number: WOR-043D (269cc), WOR-043C (320cc), WOR-043B (345cc)	Rocker Arms: Standard
Material: High density cast iron	Intake Runner: Standard port location
Valve Seats: Intake (integral), exhaust (hardened insert)	Exhaust Ports: Standard location
Valve Guides: Integral cast iron	Spark Plug: 14mm 5/8" .460" reach tapered style
Spring Seats: Machined for 1.560" (can machine to 1.625")	Valve Job: Multi-angle intake and radiused exhaust
Valves: Manley stainless steel valves in assemblies	Valve Cover Rail: Raised
Guide Plates: Stock (for best fit use World #830465)	Valve Angle: Stock 24°
Rocker Arm Studs: Screw-in style	Accessory Bolt Holes: Stock
	Chamber Design: Open
	Flow Numbers: Log on to worldcastings.com for detailed information.

Part #	Type	Runners	Chamber	Valves	Plug	Spring	Spring Spec	Max Lift	Notes
Oval Port									
030040	Bare	269 In / 137 Ex	119	2.300/1.880 11/32	Std				
030040-1	Assembly	269 In / 137 Ex	119	2.300/1.880 11/32	Std	1.550 D	125lb @ 1.980 300lb @ 1.380 CB @ 1.160	.750"	C
030040-2	Assembly	269 In / 137 Ex	119	2.300/1.880 11/32	Std	1.550 D	150lb @ 1.910 350lb @ 1.260 CB @ 1.210	.650"	C
Rectangular Port									
030620	Bare	320 In / 137 Ex	119	2.300/1.880 11/32	Std				
030620-2	Assembly	320 In / 137 Ex	119	2.300/1.880 11/32	Std	1.550 D	150lb @ 1.910 350lb @ 1.260 CB @ 1.210	.650"	C
030620-3	Assembly	320 In / 137 Ex	119	2.300/1.880 11/32	Std	1.550 D	225lb @ 1.910 520lb @ 1.210 CB @ 1.160	.700"	E
030620-4	Assembly	320 In / 137 Ex	119	2.300/1.880 11/32	Std	1.640 D	275lb @ 2.000 600lb @ 1.200 CB @ 1.050	.900"	F
030630	Bare	345 In / 137 Ex	119	2.300/1.880 11/32	Std				
030630-2	Assembly	345 In / 137 Ex	119	2.300/1.880 11/32	Std	1.550 D	150lb @ 1.910 350lb @ 1.260 CB @ 1.210	.650"	C
030630-3	Assembly	345 In / 137 Ex	119	2.300/1.880 11/32	Std	1.550 D	225lb @ 1.910 520lb @ 1.210 CB @ 1.160	.700"	E
030630-4	Assembly	345 In / 137 Ex	119	2.300/1.880 11/32	Std	1.640 D	275lb @ 2.000 600lb @ 1.200 CB @ 1.050	.900"	F
Marine - NEW!!!									
030040M-1	Assembly	269 In / 137 Ex	119	2.300/1.880 11/32	Std	1.550 D	125lb @ 1.980 300lb @ 1.380 CB @ 1.160	.750"	D
030620M-2	Assembly	320 In / 137 Ex	119	2.300/1.880 11/32	Std	1.550 D	150lb @ 1.910 350lb @ 1.260 CB @ 1.210	.650"	D
030630M-2	Assembly	345 In / 137 Ex	119	2.300/1.880 11/32	Std	1.550 D	150lb @ 1.910 350lb @ 1.260 CB @ 1.210	.650"	D

Assembly Includes: Head, valves, seals, springs, retainers, locks, rocker studs and guide plates

Notes:

- C = 7° Stamped heat treated steel valve locks, Manley 4140 chrome moly retainers and Nitrile umbrella seals
- D = 10° machined steel valve locks, Manley 4140 chrome moly retainers, Nitrile umbrella seals and Manley Inconel exhaust valves
- E = 10° machined steel valve locks, Manley 4140 chrome moly retainers, Teflon seals and Manley Severe Duty valves

MERLIN III ALUMINUM CYLINDER HEADS

This highly evolved, race-proven cylinder head is capable of supporting in excess of 800 horsepower in "as cast" form. World's Merlin III aluminum heads are available with 310cc or 350cc intake runners. The exhaust ports are 132cc. For those seeking more power, World now offers Merlin III heads with

CNC-ported combustion chambers and ports. This raises the bar to a choice of 345 or 380cc intake runners. The port designs were developed by noted NMCA, NHRA, NMRA horsepower merchant, Kuntz & Company, and have proven their effectiveness on the track.

MERLIN III

Raised valve cover rails

Accepts all Chevrolet Mark IV valvetrain components & accessories

Valve spring packages available for various camshaft requirements



Manley stainless steel valves

Exhaust port bolt bosses raised 1" for unrestricted air flow

Extra thick deck

Exclusive Rightcast® technology assures optimum port accuracy

Stock accessory bolt holes

Manufactured to QS-9000 standards

NOW AVAILABLE CNC-PORTED FOR MORE FLOW ...GOOD FOR 30 HORSEPOWER OVER "AS CAST" MERLIN III CYLINDER HEADS!

Now available fully polished from the World Custom Shop



World's Merlin III Aluminum Heads are now available with CNC-machined combustion chambers, bowls, intake and exhaust ports. The designs are by Kuntz & Co.—a highly regarded builder of racing engines used in NHRA, NMCA & NMRA competition.

SEE COMPLETE LISTING OF MERLIN III BARE, ASSEMBLED AND CNC-PORTED CYLINDER HEADS ON FOLLOWING PAGE



CNC-ported intakes are offered in both 345cc and 380cc sizes, with the exhaust ports also enlarged beyond the "as cast" 132cc port size. Heads are available bare or in complete assemblies.

Technical Data:

Casting ID Number: WOR-070C

(310cc), WOR-070B (350cc)

Material: 355-T6 alloy high density aluminum

Valve Seats: Intake (hardened), exhaust (hardened inserts)

Valve Guides: Manganese bronze

Spring Seats: Machined for 1.560" (can be machined for 1.625")

Valves: Manley stainless steel valves in assemblies

Guide Plates: Stock (for best fit use World #830466)

Rocker Arm Studs: Screw-in style

Rocker Arms: Standard

Intake Runner: Standard port location

Exhaust Ports: Standard location

Spark Plug: 14mm .750" reach gasket style

Valve Job: Multi-angle intake and radiused exhaust

Valve Cover Rail: Raised

Valve Angle: Stock 24°

Accessory Bolt Holes: Stock

Open Chamber Design

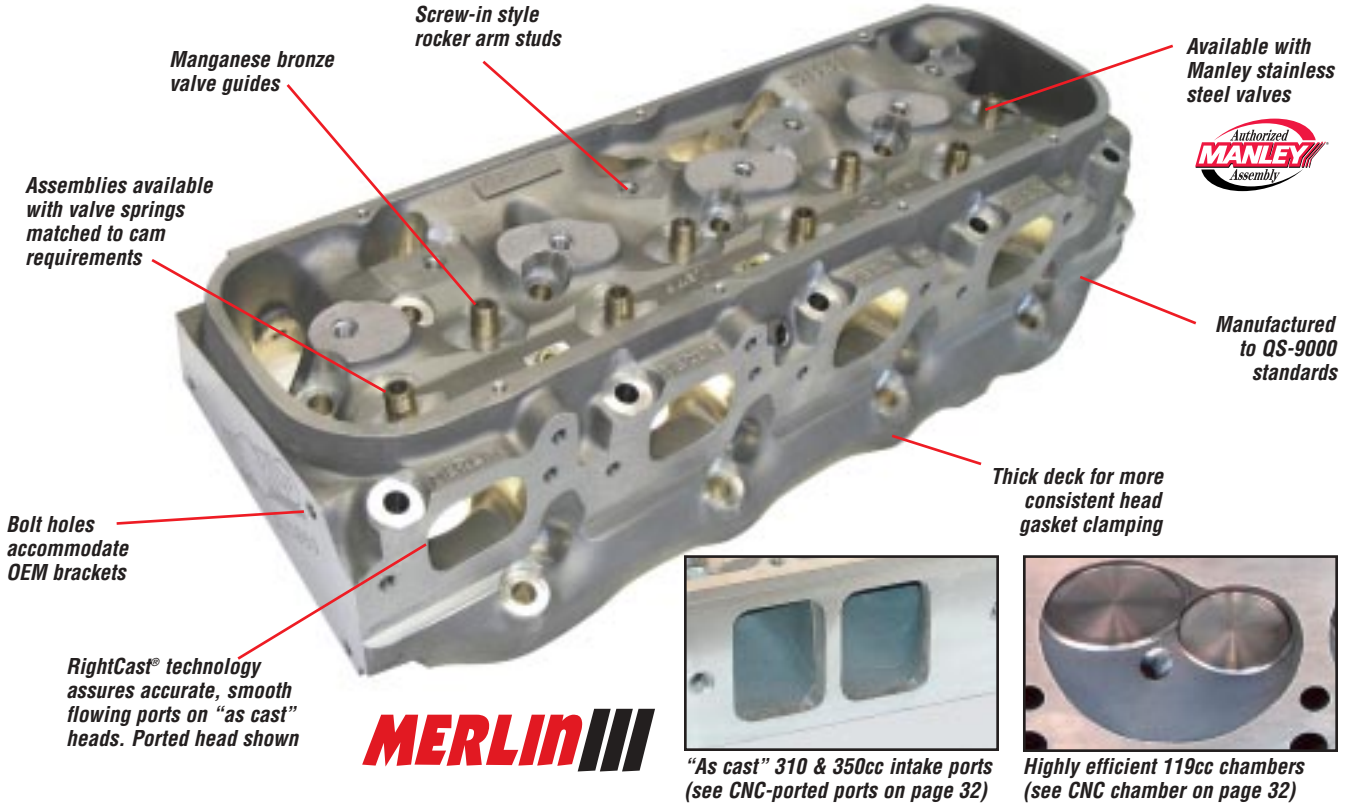
Flow Numbers: Log on to worldcastings.com for detailed information.

MERLIN III ALUMINUM CYLINDER HEADS

We've taken our popular Merlin III design and CNC-ported the combustion chambers and ports. The net result is a head that combines excellent flow and

velocity and has been proven to produce 40 horsepower more than the as-cast Merlin on a 572 C.I.D. engine. It's also a great value!

BIG BLOCK CHEVROLET



Part #	Type	Runners	Chamber	Valves	Plug	Spring	Spring Spec	Max Lift	Notes
020650	Bare	310 In / 132 Ex	119	2.300/1.880 11/32	Std				
020650-2	Assembly	310 In / 132 Ex	119	2.300/1.880 11/32	Std	1.550 D	150lb @ 1.910 350lb @ 1.260 CB @ 1.210	.650"	C
020650-3	Assembly	310 In / 132 Ex	119	2.300/1.880 11/32	Std	1.550 D	225lb @ 1.910 520lb @ 1.210 CB @ 1.160	.700"	E
020650-4	Assembly	310 In / 132 Ex	119	2.300/1.880 11/32	Std	1.640 D	275lb @ 2.000 600lb @ 1.200 CB @ 1.050	.900"	F
020660	Bare	350 In / 132 Ex	119	2.300/1.880 11/32	Std				
020660-2	Assembly	350 In / 132 Ex	119	2.300/1.880 11/32	Std	1.550 D	150lb @ 1.910 350lb @ 1.260 CB @ 1.210	.650"	C
020660-3	Assembly	350 In / 132 Ex	119	2.300/1.880 11/32	Std	1.550 D	225lb @ 1.910 520lb @ 1.210 CB @ 1.160	.700"	E
020660-4	Assembly	350 In / 132 Ex	119	2.300/1.880 11/32	Std	1.640 D	275lb @ 2.000 600lb @ 1.200 CB @ 1.050	.900"	F

CNC Ported (Ports designed by Kuntz & Co.)									Max
Part #	Type	Runners	Chamber	Valves	Plug	Spring	Spring Spec	Lift	Notes
CNC Ported (Ports designed by kuntz & co.)									
020650C	Bare	350 In/ 135 Ex	125*	2.300/1.880 11/32	Std				
020650C-2	Assembly	350 In/ 135 Ex	125*	2.300/1.880 11/32	Std	1.550 D	150lb @ 1.910 350lb @ 1.260 CB @ 1.210	.650"	C
020650C-3	Assembly	350 In/ 135 Ex	125*	2.300/1.880 11/32	Std	1.550 D	225lb @ 1.910 520lb @ 1.210 CB @ 1.160	.700"	E
020650C-4	Assembly	350 In/ 135 Ex	125*	2.300/1.880 11/32	Std	1.640 D	275lb @ 2.000 600lb @ 1.200 CB @ 1.050	.900"	F
020660C	Bare	370 In/ 135 Ex	125*	2.300/1.880 11/32	Std				
020660C-2	Assembly	370 In/ 135 Ex	125*	2.300/1.880 11/32	Std	1.550 D	150lb @ 1.910 350lb @ 1.260 CB @ 1.210	.650"	C
020660C-3	Assembly	370 In/ 135 Ex	125*	2.300/1.880 11/32	Std	1.550 D	225lb @ 1.910 520lb @ 1.210 CB @ 1.160	.700"	E
020660C-4	Assembly	370 In/ 135 Ex	125*	2.300/1.880 11/32	Std	1.640 D	275lb @ 2.000 600lb @ 1.200 CB @ 1.050	.900"	F

Marine									Max
Part #	Type	Runners	Chamber	Valves	Plug	Spring	Spring Spec	Lift	Notes
CNC Ported (Ports designed by kuntz & co.)									
020650M-2	Assembly	310 In / 132 Ex	119	2.300/1.880 11/32	Std	1.550 D	150lb @ 1.910 350lb @ 1.260 CB @ 1.210	.650"	D
020660M-2	Assembly	350 In / 132 Ex	119	2.300/1.880 11/32	Std	1.550 D	150lb @ 1.910 350lb @ 1.260 CB @ 1.210	.650"	D
020650CM-2	Assembly	350 In/ 135 Ex	125*	2.300/1.880 11/32	Std	1.550 D	150lb @ 1.910 350lb @ 1.260 CB @ 1.210	.650"	D
020660CM-2	Assembly	350 In/ 135 Ex	125*	2.300/1.880 11/32	Std	1.550 D	150lb @ 1.910 350lb @ 1.260 CB @ 1.210	.650"	D

Assembly Includes: Head, valves, seals, springs, retainers, locks, rocker studs and guide plates * Can be milled to desired compression

Notes:
 C = 7° Stamped heat treated steel valve locks, Manley 4140 chrome-moly retainers and Nitrile umbrella seals
 D = 10° machined steel valve locks, Manley 4140 chrome-moly retainers, Nitrile umbrella seals and Inconel exhaust valves (Marine version)
 E = 10° machined steel valve locks, Manley 4140 chrome-moly retainers, Perfect Circle Teflon seals and Manley Race Master valves
 F = 10° machined steel valve locks, Manley titanium retainers, Teflon seals, Manley Nextek springs and Manley Severe Duty valves

Recommended Installation Items:	
Head Gaskets: Felpro #1017-1	Exhaust Gasket: Felpro #1410
Intake Gasket: Felpro #1211 Mr. Gasket #121	Spark Plugs: 14mm .750" reach gasket seat (Accel 416)

MERLIN X BBC ALUMINUM BLOCK

MERLIN X

Precision CNC machined in two positions to cut down on stacked tolerances

100% compatible with OEM parts

Indexed lifter bores

Made of 357-T aluminum (strongest available)

Expanded water jackets for maximum cooling

Siamese bores

Blind tapped head bolt holes

Uses stock BBC cam bearings

Accepts stock mechanical fuel pump

Priority main oiling system for optimum reliability with cross feed lines to oil left and right side lifter banks

1/2" ARP® and ring dowels used to locate main caps firmly into position (not antiquated standard OEM outside registers)

Solid oil pan rails with stock spacing and cleared for large stroke cranks

1045 billet steel main caps utilized on Race blocks (unlike competitors' softer 1020)

Side ribs for extra strength and cooling

Manufactured to QS-9000 standards

Accessories:

- 832660-2** - Oil restrictors for Merlin BBC cast iron engine block
- 832518** - Freeze plug and pipe plug kit for Merlin BBC aluminum engine block
- 832523** - Dowel pin kit for Merlin BBC engine block
- 832545** - Head stud kit for Merlin BBC cylinder head/Merlin BBC aluminum engine block
- 841104-DF** - Replacement sleeve for Merlin 9.800/10.200" BBC aluminum engine block (4.250" bore)
- 841105-DF** - Replacement sleeve for Merlin 9.800/10.200" BBC aluminum engine block (4.500" bore)
- 832912** - Stainless steel timing cover bolt kit (hex head)

832921 - Stainless steel oil pan bolt kit (hex head)

Options Available:

- Available options:
- Cylinder boring
 - Lifter bushings
 - 55mm cam bearings
 - O-ring head decks
 - Polishing (6 to 8 weeks lead time)
- Contact your World sales representative for details.

Technical Data

- Casting ID Number:** WOR-016B (9.800"), WOR-016A (10.200")
- Material:** 357-T6 Aluminum (absolute strongest available)
- Deck Thickness:** .600" minimum
- Cam Bearings:** Standard big block Chevrolet (can machine to 55mm)
- Cam Location:** Standard big block Chevy
- Maximum Bore:** 4.530"
- Cylinder Sleeves:** Centrifugally Cast Ductile Iron Dry Sleeves
- Cylinder Wall Thickness:** .100" dry sleeve w/.300" aluminum wall support @ 4.155"
- Water Jackets:** Expanded capacity
- Lubrication:** Priority main oiling system
- Filtration:** Integral mount for spin-on filter
- Oil Pan Rails:** Solid (stock width)
- Main Cap Material:** Sportsman block

- caps are made from nodular iron, Race blocks are made from 1045 billet steel (unlike competitors' softer 1020)
- Main Caps:** Sportsman and Race blocks have splayed 4-bolt caps (2, 3, 4) and straight 4-bolt caps (1, 5)
- Main Cap Hardware:** 1/2" ARP and ring dowels used to locate main caps firmly into position (not antiquated standard OEM outside registers)
- Rear Main Seal:** Two piece
- Fuel Pump:** Stock location
- Motor Mounts:** Dual (front and side)
- Cylinder Head Bolt Holes:** Blind tapped to prevent water leaks
- Lifters Bosses:** Cleared for vertical bar lifters (can use standard ht.lifters)
- Clutch linkage:** Standard mounts
- Starter Mount:** Stock location
- Weight:** Approximately 140lbs

MERLIN X BBC ALUMINUM BLOCK

BIG BLOCK CHEVROLET

In the highly refined "Merlin X" aluminum block, World Products has incorporated a significant number of key technical features that set it apart from the competition. And because it's been designed specifically for the street, marine and "Super" drag class market, the price of the "Merlin X" is very competitive. Dollar for dollar, you won't find a better value in big block technology. It's manufactured to QS-9000 quality control standards.

One easy-to-spot difference between the "Merlin X" block and others is the use of horizontal ribs. Not only do they look cool, but they also serve to

improve engine cooling and reinforce the cylinder bores.

Total bottom-end dependability is achieved through use of 1045 alloy steel billet splayed 4-bolt mains (much stronger than commonly-used 1020 steel) with genuine ARP main studs and bolts.

The "Merlin III" is compatible with all GMC Gen IV components (cam location is standard), and is the best foundation for building a large displacement Big Block Chevy with total reliability. Factor in pricing that's more than competitive, and you've got a winner!

EXCLUSIVE HORIZONTAL REINFORCING RIBS



World's ribbed Merlin X block provides extra cooling and outstanding cylinder stability. It also gives the Merlin X a distinctive look.

SUPERIOR BOTTOM-END DEPENDABILITY



With 4-bolt splayed 1045 alloy billet steel main caps and 200,000 psi ARP® main studs and bolts, superior reliability is assured.

DESIGNED FOR VALVE TRAIN STABILITY



Reinforcing ribs provide improved bank-to-bank stability and indexed lifter bores assure optimum valve train operating efficiency.

MANY WORLD "CUSTOM SHOP" OPTIONS



Merlin X blocks are available fully polished through World's "Custom Shop," as are a number of other popular special order options.

Part #	Series	Type	Deck	Bore	Mains	Lifters	Main Caps	Max Stroke
085500	Race	Bare	9.800"	4.240"	.8437"	1045 Billet Steel Splayed 4-Bolt	1045 Billet Steel Splayed 4-Bolt	4.375
085500-4250	Race	Prepped	9.800"	4.250"	.8437"	1045 Billet Steel Splayed 4-Bolt	1045 Billet Steel Splayed 4-Bolt	4.375
085500-4280	Race	Prepped	9.800"	4.280"	.8437"	1045 Billet Steel Splayed 4-Bolt	1045 Billet Steel Splayed 4-Bolt	4.375
085501	Race	Bare	9.800"	4.490"	.8437"	1045 Billet Steel Splayed 4-Bolt	1045 Billet Steel Splayed 4-Bolt	4.375
085501-4500	Race	Prepped	9.800"	4.500"	.8437"	1045 Billet Steel Splayed 4-Bolt	1045 Billet Steel Splayed 4-Bolt	4.375
085501-4530	Race	Prepped	9.800"	4.530"	.8437"	1045 Billet Steel Splayed 4-Bolt	1045 Billet Steel Splayed 4-Bolt	4.375
085510	Race	Bare	10.200"	4.240"	.8437"	1045 Billet Steel Splayed 4-Bolt	1045 Billet Steel Splayed 4-Bolt	4.750
085510-4250	Race	Prepped	10.200"	4.250"	.8437"	1045 Billet Steel Splayed 4-Bolt	1045 Billet Steel Splayed 4-Bolt	4.750
085510-4280	Race	Prepped	10.200"	4.280"	.8437"	1045 Billet Steel Splayed 4-Bolt	1045 Billet Steel Splayed 4-Bolt	4.750
085511	Race	Bare	10.200"	4.490"	.8437"	1045 Billet Steel Splayed 4-Bolt	1045 Billet Steel Splayed 4-Bolt	4.750
085511-4500	Race	Prepped	10.200"	4.500"	.8437"	1045 Billet Steel Splayed 4-Bolt	1045 Billet Steel Splayed 4-Bolt	4.750
085511-4530	Race	Prepped	10.200"	4.530"	.8437"	1045 Billet Steel Splayed 4-Bolt	1045 Billet Steel Splayed 4-Bolt	4.750

Bare Blocks Include: Screw-in freeze plugs, cam plugs and dowel pin kit

Prepped Blocks Include: Decks milled +/- .005", honed main journals +/- .0004", plate honed cylinder bores .001" O.S. +/- .0005", honed lifter bores +/- .0005", hot tanked, cam bearings, freeze plugs, dowel pins and all pipe plugs are installed, deburred sprayed w/ rust inhibitor and wrapped

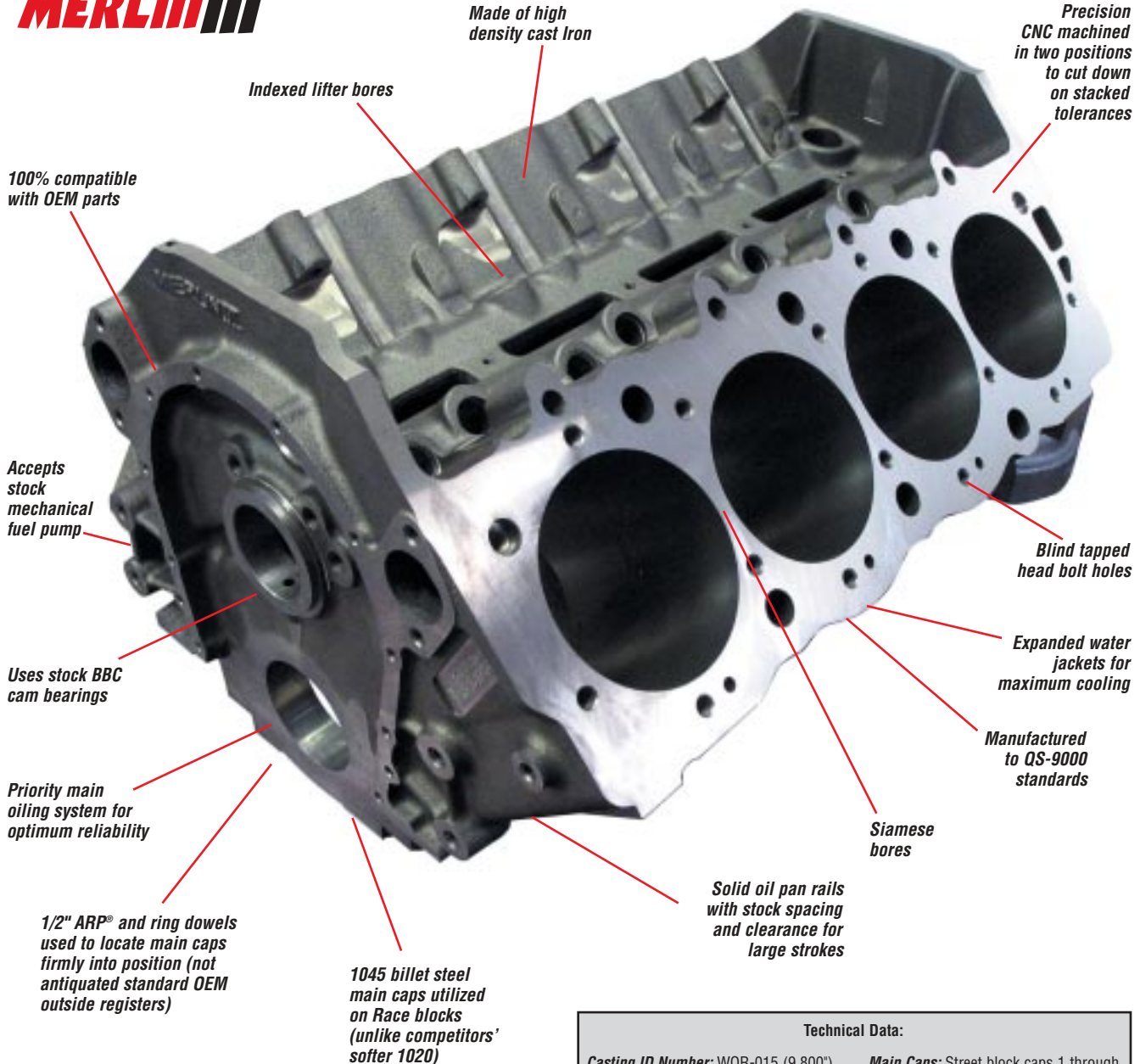
Important Note: Due to varying engine builder preferences, the sleeves in an aluminum prepped block are not flush-milled with the deck and may vary.

Merlin III BBC CAST IRON BLOCK

Now in its third iteration, World's continually-upgraded Merlin III cast iron block is the perfect foundation for any Big Block Chevrolet engine assembly. Made of a high density iron and manufactured to QS-9000 specs on just two fixtures (eliminates tolerance stacking common to production lines), the Merlin

III can be bored to 4.625" maximum and is clearanced for a 4.750" crank (10.2" deck). With a reinforced bottom end featuring optional 4-bolt splayed billet steel main caps, the Merlin III block can handle serious horsepower with complete reliability. It's an excellent all-around value, too!

MERLIN III



100% compatible with OEM parts

Indexed lifter bores

Made of high density cast iron

Precision CNC machined in two positions to cut down on stacked tolerances

Accepts stock mechanical fuel pump

Blind tapped head bolt holes

Uses stock BBC cam bearings

Expanded water jackets for maximum cooling

Priority main oiling system for optimum reliability

Manufactured to QS-9000 standards

1/2" ARP® and ring dowels used to locate main caps firmly into position (not antiquated standard OEM outside registers)

1045 billet steel main caps utilized on Race blocks (unlike competitors' softer 1020)

Siamese bores

Solid oil pan rails with stock spacing and clearance for large strokes

ALL WORLD PRODUCTS BLOCKS ARE AVAILABLE BARE OR RACE-PREPARED FOR YOUR ADDED CONVENIENCE

- Plate honed to the desired bore size
- Block thoroughly washed
- Painted
- Cam bearings & freeze plugs installed
- Machined surfaces protected with oil

Technical Data:	
Casting ID Number: WOR-015 (9.800"), WOR-017 (10.200")	Main Caps: Street block caps 1 through 5 have 4 bolts, Sportsman and Race blocks have splayed 4-bolt caps (2, 3, 4) and straight 4-bolt caps (1, 5)
Material: High density cast Iron	Main Cap Hardware: 1/2" ARP® and ring dowels used to locate main caps firmly into position (not antiquated standard OEM outside registers)
Cam Bearings: Standard big block Chevrolet (can machine to 55mm)	Rear Main Seal: Two piece
Cam Location: Standard big block Chevy	Fuel Pump: Stock location
Maximum Bore: 4.625"	Motor Mounts: Dual (front and side)
Cylinder Wall Thickness: .250" @ 4.600"	Cylinder Head Bolt Holes: Blind tapped to prevent water leaks
Water Jackets: Expanded for better cooling	Lifters Bosses: Clearanced for vertical bar lifters (can use standard height lifters)
Lubrication: Priority main oiling system	Clutch linkage: Standard mounts
Filtration: Integral mount for spin-on filter	Starter Mount: Stock location
Oil Pan Rails: Solid (stock width)	Weight: Approximately 270lbs
Main Cap Material: Street and Sportsman block caps are made from nodular iron, Race blocks are made from 1045 billet steel (unlike competitors' softer 1020)	

Merlin III BBC CAST IRON BLOCK

BIG BLOCK CHEVROLET



Part #	Series	Type	Deck	Bore	Lifters	Main Caps	max Stroke
085005	Street	Bare	9.800"	4.240"	.8437"	Straight 4-Bolt	4.375
085005-4250	Street	Prepped	9.800"	4.250"	.8437"	Straight 4-Bolt	4.375
085005-4280	Street	Prepped	9.800"	4.280"	.8437"	Straight 4-Bolt	4.375
085035	Street	Bare	10.200"	4.240"	.8437"	Straight 4-Bolt	4.750
085035-4250	Street	Prepped	10.200"	4.250"	.8437"	Straight 4-Bolt	4.750
085035-4280	Street	Prepped	10.200"	4.280"	.8437"	Straight 4-Bolt	4.750
081100	Sportsman	Bare	9.800"	4.240"	.8437"	Nodular Splayed 4-Bolt	4.375
081100-4250	Sportsman	Prepped	9.800"	4.250"	.8437"	Nodular Splayed 4-Bolt	4.375
081100-4280	Sportsman	Prepped	9.800"	4.280"	.8437"	Nodular Splayed 4-Bolt	4.375
081101	Sportsman	Bare	9.800"	4.490"	.8437"	Nodular Splayed 4-Bolt	4.375
081101-4500	Sportsman	Prepped	9.800"	4.500"	.8437"	Nodular Splayed 4-Bolt	4.375
081101-4530	Sportsman	Prepped	9.800"	4.530"	.8437"	Nodular Splayed 4-Bolt	4.375
081102	Sportsman	Bare	9.800"	4.590"	.8437"	Nodular Splayed 4-Bolt	4.375
081102-4600	Sportsman	Prepped	9.800"	4.600"	.8437"	Nodular Splayed 4-Bolt	4.375
081110	Sportsman	Bare	10.200"	4.240"	.8437"	Nodular Splayed 4-Bolt	4.750
081110-4250	Sportsman	Prepped	10.200"	4.250"	.8437"	Nodular Splayed 4-Bolt	4.750
081110-4280	Sportsman	Prepped	10.200"	4.280"	.8437"	Nodular Splayed 4-Bolt	4.750
081111	Sportsman	Bare	10.200"	4.490"	.8437"	Nodular Splayed 4-Bolt	4.750
081111-4500	Sportsman	Prepped	10.200"	4.500"	.8437"	Nodular Splayed 4-Bolt	4.750
081111-4530	Sportsman	Prepped	10.200"	4.530"	.8437"	Nodular Splayed 4-Bolt	4.750
081112	Sportsman	Bare	10.200"	4.590"	.8437"	Nodular Splayed 4-Bolt	4.750
081112-4600	Sportsman	Prepped	10.200"	4.600"	.8437"	Nodular Splayed 4-Bolt	4.750

Part #	Series	Type	Deck	Bore	Lifters	Main Caps	max Stroke
085000	Race	Bare	9.800"	4.240"	.8437"	1045 Billet Steel Splayed 4-Bolt	4.375
085000-4250	Race	Prepped	9.800"	4.250"	.8437"	1045 Billet Steel Splayed 4-Bolt	4.375
085000-4280	Race	Prepped	9.800"	4.280"	.8437"	1045 Billet Steel Splayed 4-Bolt	4.375
085010	Race	Bare	9.800"	4.490"	.8437"	1045 Billet Steel Splayed 4-Bolt	4.375
085010-4500	Race	Prepped	9.800"	4.500"	.8437"	1045 Billet Steel Splayed 4-Bolt	4.375
085010-4530	Race	Prepped	9.800"	4.530"	.8437"	1045 Billet Steel Splayed 4-Bolt	4.375
085012	Race	Bare	9.800"	4.590"	.8437"	1045 Billet Steel Splayed 4-Bolt	4.375
085012-4600	Race	Prepped	9.800"	4.600"	.8437"	1045 Billet Steel Splayed 4-Bolt	4.375
085100	Race	Bare	10.200"	4.240"	.8437"	1045 Billet Steel Splayed 4-Bolt	4.750
085100-4250	Race	Prepped	10.200"	4.250"	.8437"	1045 Billet Steel Splayed 4-Bolt	4.750
085100-4280	Race	Prepped	10.200"	4.280"	.8437"	1045 Billet Steel Splayed 4-Bolt	4.750
085110	Race	Bare	10.200"	4.490"	.8437"	1045 Billet Steel Splayed 4-Bolt	4.750
085110-4500	Race	Prepped	10.200"	4.500"	.8437"	1045 Billet Steel Splayed 4-Bolt	4.750
085110-4530	Race	Prepped	10.200"	4.530"	.8437"	1045 Billet Steel Splayed 4-Bolt	4.750
085112	Race	Bare	10.200"	4.590"	.8437"	1045 Billet Steel Splayed 4-Bolt	4.750
085112-4600	Race	Prepped	10.200"	4.600"	.8437"	1045 Billet Steel Splayed 4-Bolt	4.750

Bare Blocks Include: Decks milled +/- .005", honed main journals +/- .0004", plate honed cylinder bores .001" O.S. +/- .0005", honed lifter bores +/- .0005" hot tanked, cam bearings, freeze plugs, dowel pins and all pipe plugs are installed, deburred paint inside and out, sprayed w/ rust prohibitor and wrapped

Accessories:	
832660-2	Oil restrictors for Merlin BBC cast iron engine block
832532	Freeze plug and pipe plug kit for Merlin BBC cast iron engine block
832523	Dowel pin kit for Merlin BBC engine block
832580	Head bolt kit for Merlin BBC cast iron head
832581	Head bolt kit for Merlin BBC aluminum head
832015-8	Head bolts (long outers for Merlin cylinder head)
832546	Head stud kit for Merlin BBC cylinder head/Merlin BBC cast iron engine block
832912	Stainless steel timing cover bolt kit (hex head)
832921	Stainless steel oil pan bolt kit (hex head)
Options Available:	
	Cylinder boring
	Lifter bushings
	55mm cam bearings
	O-ring head decks
	Contact your World sales representative for details.

MERLIN 509 CID BBC STAGE 1 PARTIAL ENGINE

World Products has developed this package for the performance enthusiast who is faced with rebuilding a 396, 427, 454 or 502-inch Big Block Chevy and would like to gain some serious displacement at virtually no extra cost! This 509 c.i.d. engine will also make a great foundation for any engine swap project. Just add an intake, exhaust and ignition system (plus oil pan, pick-up and damper) and

you're on your way to a 500-plus HP engine combination with stump-pulling torque. It features a new Merlin II cast iron block, a digitally balanced rotating assembly consisting of a 4340 forged steel crank, 4340 steel H-beam rods, forged aluminum pistons and high performance rings. The heads have Manley stainless steel valves and are topped with aluminum roller rocker arms.



Genuine Manley stainless steel valves

Aluminum roller rocker arms

High velocity 269cc intake oval port heads



Multi-angle valve job w/radiused exhausts

Equipped with 4340 alloy forged steel crank, 4340 forged H-beam connecting rods and forged pistons

9.8" deck Merlin III cast iron engine block

Internally balanced rotating assembly

Get Increased Displacement At Absolutely No Extra Cost!

Technical Data:	
Casting ID Number: WOR-015 Engine Block: Merlin III cast iron	Connecting Rods: 4340 Eagle
Deck Height: 9.800"	Pistons: Mahle
Bore/Stroke: 4.500" x 4.000"	Gaskets: Fel-Pro
Main Caps: 4-bolt nodular splayed	Internal Hardware: ARP®
Cylinder Heads: Merlin Oval Port 269cc cast iron	External Hardware: Totally Stainless
Valves: Manley stainless steel	Valve Cover: World aluminum
Timing Chain: Double roller	The following parts are not included:
Crankshaft: 4340 Eagle internally balanced	Carburetor, intake manifold, ignition (distributor, coil, wires and spark plugs), damper, oil pan and pick-up

396 + 113 "Free Inches" = 509"
427 + 82 "Free Inches" = 509"
454 + 55 "Free Inches" = 509"

Part #	C.i.d.	Heads	Application	Type	Compression	Camshaft	Induction	Dome
Partial Engine								
130031	509	Cast Iron	Street	Partial	9.5:1	Hydraulic Flat Tappet	None	12cc

Individualize With Custom Shop Options!

Now you can make a good thing even better, thanks to the options that are available through World's Custom Shop. You can obtain engines with increased power through ordering them equipped with CNC-ported cylinder heads. This is a conservative 30 horsepower increase. From an appearance standpoint, you can get an aluminum block, intake manifold and cylinder heads beautifully polished to a mirror-like finish. The 572 c.i.d. motor pictured here is equipped with a Merlin X aluminum block, Merlin III aluminum heads and a Merlin intake manifold—all of which have been polished. If you want to use a supercharger, the engine can be ordered as a partial with pistons and camshaft matched to your requirements. Have it your way with World Products!

Polished Merlin intake manifold

Optional CNC porting adds 30 HP

Polished Merlin X aluminum block

Polished Merlin III aluminum cylinder heads

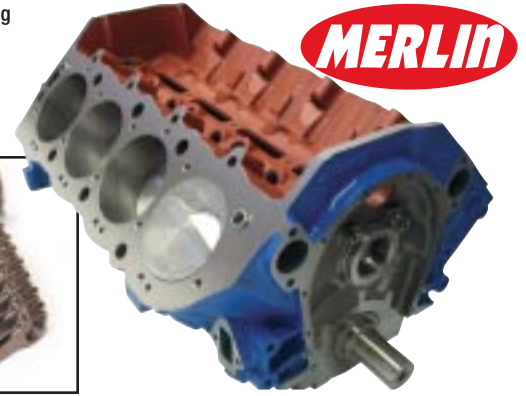
Optional custom oil filter



MERLIN THE KING OF BIG BLOCK CHEVY ENGINES!

BIG BLOCK CHEVROLET

The name "Merlin" has become synonymous with Big Block Chevy power and World keeps adding to the legend. Now you can get everything from a "partial" engine to a do-it-yourself kit with a race-prepped block and fully balanced rotating assembly. Only top quality components are used, such as a 4340 forged steel crank (Eagle or Callies), 4340 forged steel H-beam rods, forged aluminum pistons (Manley or Mahle) and high performance rings (Mahle or Total Seal). Special low compression partial engines, short blocks and rotating kits available for use with superchargers and turbochargers.



GROUND-THUMPING HP AND TORQUE IS YOURS THE EASY WAY WITH A BIG-INCH MERLIN SHORT BLOCK, KIT OR PARTIAL



Part #	C.I.D.	Heads	Application	Compression	Camshaft	Induction	Dome	Notes
Partial Engine (Stage 2)								
130032	509	Merlin III alum.	Street	9.5:1	Hydraulic Roller	None	12cc	A
130132	509	Merlin III alum.	For Power Adders	8.6:1	Hydraulic Roller	None	Flat Top	A
130034	540	Merlin III alum.	Street	9.5:1	Hydraulic Roller	None	5cc	A
130134	540	Merlin III alum.	For Power Adders	8.4:1	Hydraulic Roller	None	-15cc	A
130036	572	Merlin III alum.	Street	10.8:1	Hydraulic Roller	None	15cc	A
130136	572	Merlin III alum.	For Power Adders	8.6:1	Hydraulic Roller	None	-20cc	A
130038	632	Merlin III alum.	Street	10.4:1	Hydraulic Roller	None	-6cc	B
Short Block Assembly								
108225	509		Street	9.5:1	None	None	12cc	A
108224	509		For Power Adders	8.6:1	None	None	Flat Top	A
108250	540		Street	9.5:1	None	None	5cc	A
108249	540		For Power Adders	8.4:1	None	None	-15cc	A
108252	540		Race	13.5:1	None	None	46cc	A
108260	572		Street	10.8:1	None	None	15cc	A
108259	572		For Power Adders	8.6:1	None	None	-20cc	A
108262	572		Race	13.7:1	None	None	42cc	A
108270	632		Street	10.4:1	None	None	-6cc	B
108272	632		Race	14.1:1	None	None	33cc	B
Short Block Kit								
108325	509		Street	9.5:1	None	None	12cc	A
108324	509		For Power Adders	8.6:1	None	None	Flat Top	A
108350	540		Street	9.5:1	None	None	5cc	A
108349	540		For Power Adders	8.4:1	None	None	-15cc	A
108352	540		Race	13.5:1	None	None	46cc	A
108360	572		Street	10.8:1	None	None	15cc	A
108359	572		For Power Adders	8.6:1	None	None	-20cc	A
108362	572		Race	13.7:1	None	None	42cc	A
108370	632		Street	10.4:1	None	None	-6cc	B
108372	632		Race	14.1:1	None	None	33cc	B
Rotating Kit								
108100	509		Street	9.5:1	None	None	12cc	A
108101	509		For Power Adders	8.6:1	None	None	Flat Top	A
108150	540		Street	9.5:1	None	None	5cc	A
108149	540		For Power Adders	8.4:1	None	None	-15cc	A
108153	540		Race	13.5:1	None	None	46cc	A
108160	572		Street	10.8:1	None	None	15cc	A
108159	572		For Power Adders	8.6:1	None	None	-20cc	A
108162	572		Race	13.7:1	None	None	42cc	A
108170	632		Street	10.4:1	None	None	-6cc	B
108173	632		Race	14.1:1	None	None	33cc	B

Partial Engine Includes: All the same premium components as the complete engines, less intake manifold, induction system, ignition system and damper
Short Blocks Include: Decks milled +/- .005", honed main journals +/- .0004", plate honed cylinder bores .001" O.S. +/- .0005", honed lifter bores +/- .0005", hot tanked, cam bearings, freeze plugs, dowel pins and all pipe plugs are installed, deburred sprayed w/ rust prohibitor and wrapped, digitally internal balanced crank, pistons and connecting rods balanced within 2grms
Short Block Kits Includes: Prepped block and balanced rotating kit

Notes:
 A = Compression for 509, 540 & 572 calculated with a 119cc head, .020" deck, and a Fel-Pro 1017 gasket. Dome volumes as specified above.
 B = Compression for 632 calculated with a 119cc head, .005" deck, and a Fel-Pro 1057 gasket. Dome volumes as specified above.

Available options: Aluminum engine block Polished aluminum engine block, cylinder heads and intake manifold (6 to 8 weeks lead time) Polished cylinder heads and intake manifold (6 to 8 weeks lead time)	CNC head porting (add 30 hp) Cast iron cylinder heads 1 year/12,000 mile limited warranty (includes dyno break-in) Partial engine only Contact your World sales representative for details.
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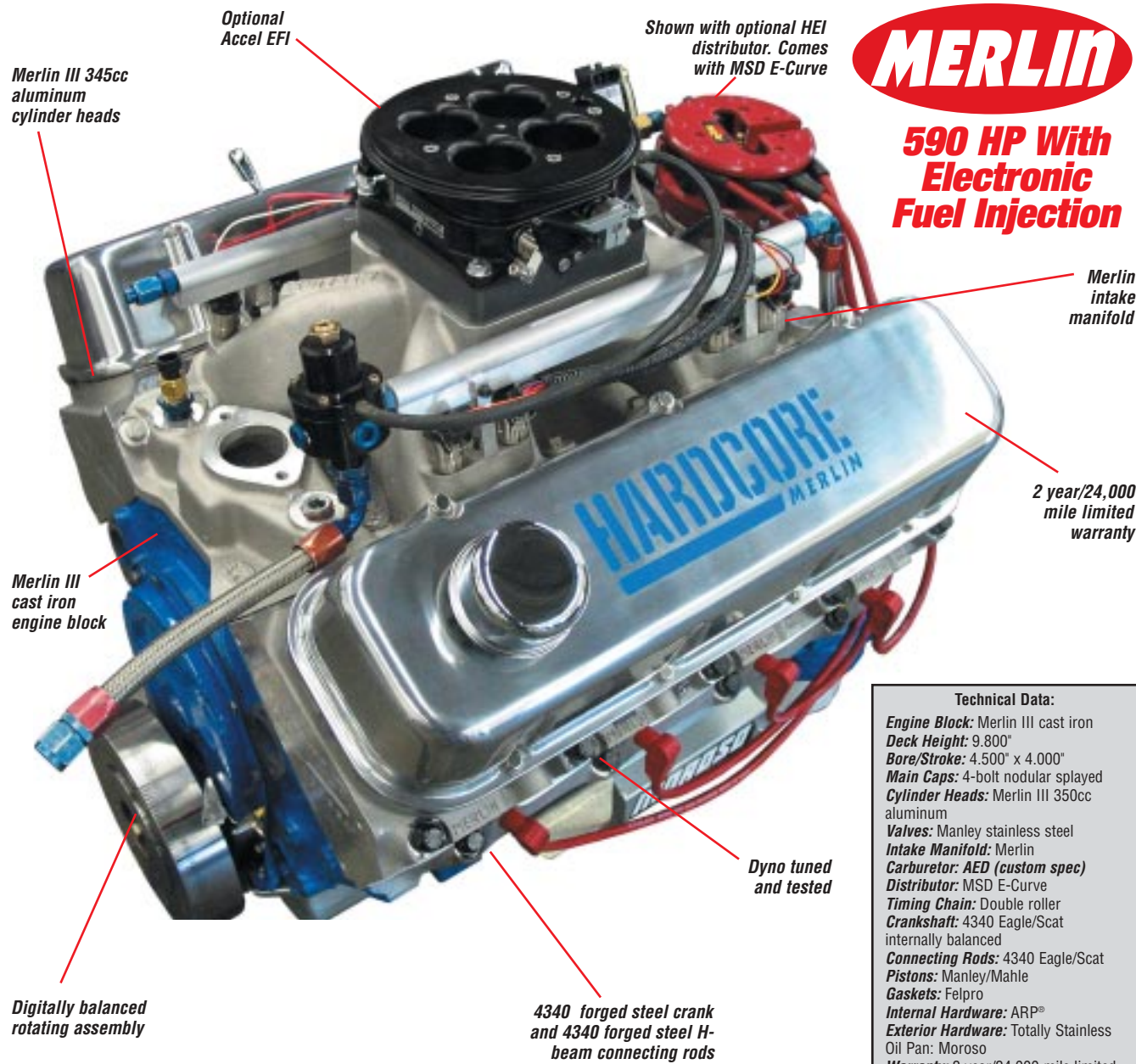
BIG BLOCK CHEVROLET MERLIN 509 CID BBC ENGINE

Here's an interesting engine package that's perfect for many street rods and street machines. With 509 cubic inches, it's got plenty of torque, and yet with a hydraulic roller (or hydraulic flat tappet) cam and 9.5:1 compression, it's a low-maintenance combination that's designed for optimum reliability. Of

course, with 590 dyno-tested horsepower for the hydraulic roller cammed models, there's an abundance of performance. The engine features a World Merlin III cast iron block and Merlin III aluminum heads, 4340 forged steel crank and H-beam connecting rods, forged aluminum pistons and all the good stuff!



590 HP With Electronic Fuel Injection



Technical Data:

Engine Block: Merlin III cast iron
Deck Height: 9.800"
Bore/Stroke: 4.500" x 4.000"
Main Caps: 4-bolt nodular splayed
Cylinder Heads: Merlin III 350cc aluminum
Valves: Manley stainless steel
Intake Manifold: Merlin
Carburetor: AED (custom spec)
Distributor: MSD E-Curve
Timing Chain: Double roller
Crankshaft: 4340 Eagle/Scat internally balanced
Connecting Rods: 4340 Eagle/Scat
Pistons: Manley/Mahle
Gaskets: Felpro
Internal Hardware: ARP®
Exterior Hardware: Totally Stainless
Oil Pan: Moroso
Warranty: 2 year/24,000 mile limited (Street Series only)

Part #	C.I.D.	HP	Heads	Application	Compression	Camshaft	Induction	Dome	Notes
Complete Engine									
130232	509	590	Aluminum	Street	9.5:1	Hydraulic Roller	4150 870cfm	12cc	A
130332	509	590	Aluminum	Street	9.5:1	Hydraulic Roller	EFI	12cc	A
108000	509	540	Cast Iron	Street	9.5:1	Hydraulic Flat Tappet	4150 870cfm	12cc	B
108001	509	560	Aluminum	Street	9.5:1	Hydraulic Flat Tappet	4150 870cfm	12cc	A

Complete Engine Includes: Pan to carb (or EFI), fully assembled, dyno tuned and tested and comes with a 2 year/24 month warranty (does not include starter, water pump or flywheel)

Notes:

A = Compression calculated with a 119cc head, .020" deck, 12cc piston and a .041" gasket

Available options:	
Aluminum engine block	Cast iron cylinder heads (except 10800)
Polished aluminum engine block, cylinder heads and intake manifold (6 to 8 weeks lead time)	
Polished cylinder heads and intake manifold (6 to 8 weeks lead time)	Contact your World sales representative for details.
CNC head porting (add 30 hp)	

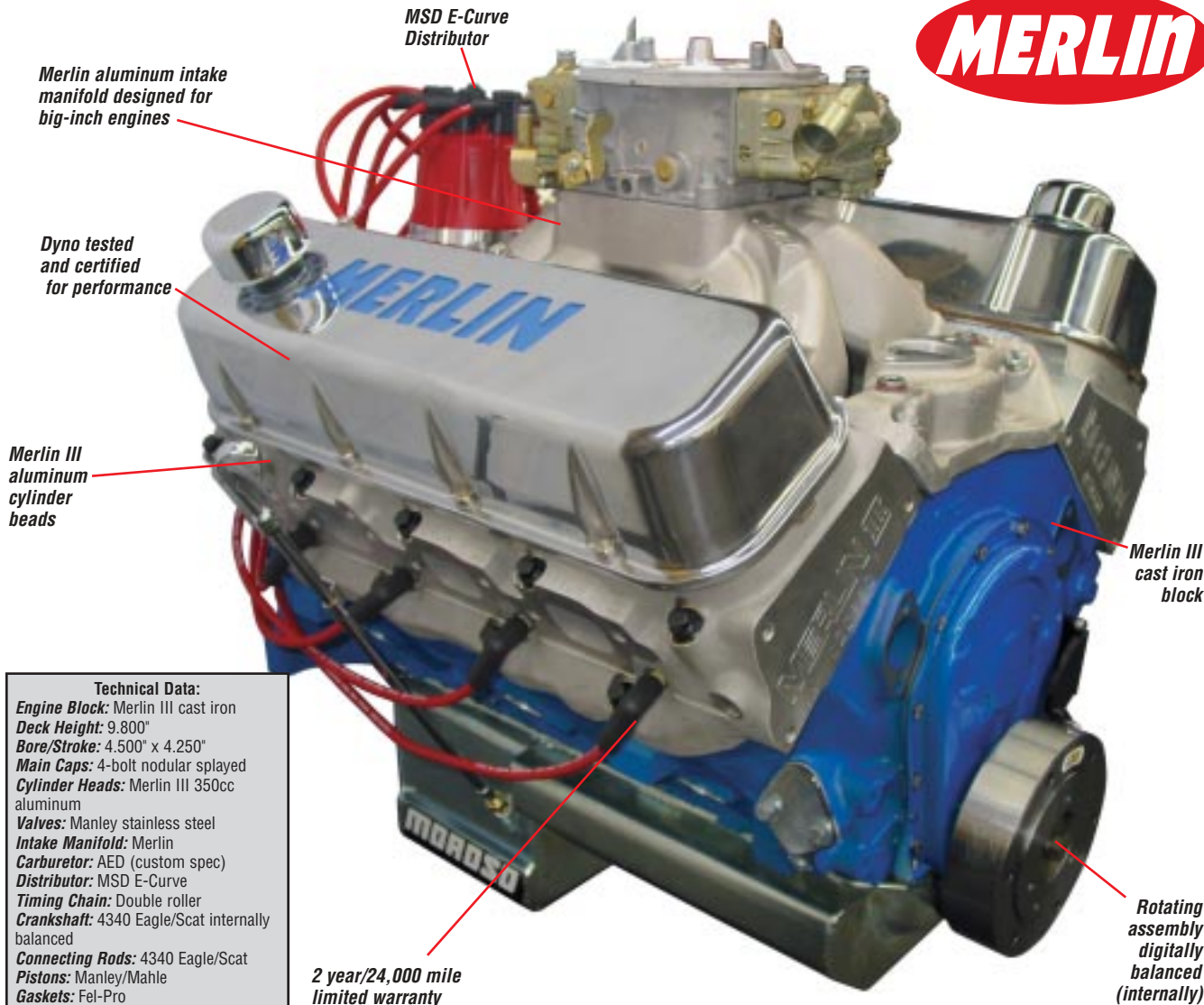


MERLIN 540 CID BBC ENGINE

BIG BLOCK CHEVROLET

Even though they're "only" 540 cubic inches, these Merlins are a step above factory 572-inch crate motors. Factors like the Merlin III cast iron block, Merlin III aluminum heads, and a full compliment of premium grade internal components from leading aftermarket manufacturers make the difference. Add

to the fact that each engine is dyno-tested and certified to meet published performance standards and backed by a 2-year/24,000-mile warranty and you can see why the advantage goes to World Products. Also available in a racing version that puts out 825 horsepower.



Merlin aluminum intake manifold designed for big-inch engines

MSD E-Curve Distributor

Dyno tested and certified for performance

Merlin III aluminum cylinder heads

Merlin III cast iron block

Rotating assembly digitally balanced (internally)

2 year/24,000 mile limited warranty

Technical Data:
Engine Block: Merlin III cast iron
Deck Height: 9.800"
Bore/Stroke: 4.500" x 4.250"
Main Caps: 4-bolt nodular splayed
Cylinder Heads: Merlin III 350cc aluminum
Valves: Manley stainless steel
Intake Manifold: Merlin
Carburetor: AED (custom spec)
Distributor: MSD E-Curve
Timing Chain: Double roller
Crankshaft: 4340 Eagle/Scat internally balanced
Connecting Rods: 4340 Eagle/Scat
Pistons: Manley/Mahle
Gaskets: Fel-Pro
Internal Hardware: ARP®
Exterior Hardware: Totally Stainless
Oil Pan: Moroso
Warranty: 2 year/24,000 mile limited (Street Series only)

World's Merlin 540 Out-Performs GM Crate 572s!

Part #	C.I.D.	HP	Application	Compression	Camshaft	Induction	Dome	Notes
Complete Engine								
130234	540	650	Street	9.5:1	Hydraulic Roller	4150 870cfm	5cc	A
130334	540	650	Street	9.5:1	Hydraulic Roller	EFI	5cc	A
108050	540	580	Street	9.5:1	Hydraulic Flat Tappet	4150 870cfm	5cc	A
108051	540	600	Street	9.5:1	Hydraulic Flat Tappet	4150 870cfm	5cc	A
108081	540	825	Race	13.5:1	Solid Roller	4500 1050cfm	46cc	B

Complete Engine Includes: Pan to carb (or EFI), fully assembled, dyno tuned and tested and comes with a 2 year/24 month warranty (does not include starter, water pump or flywheel)

Notes:

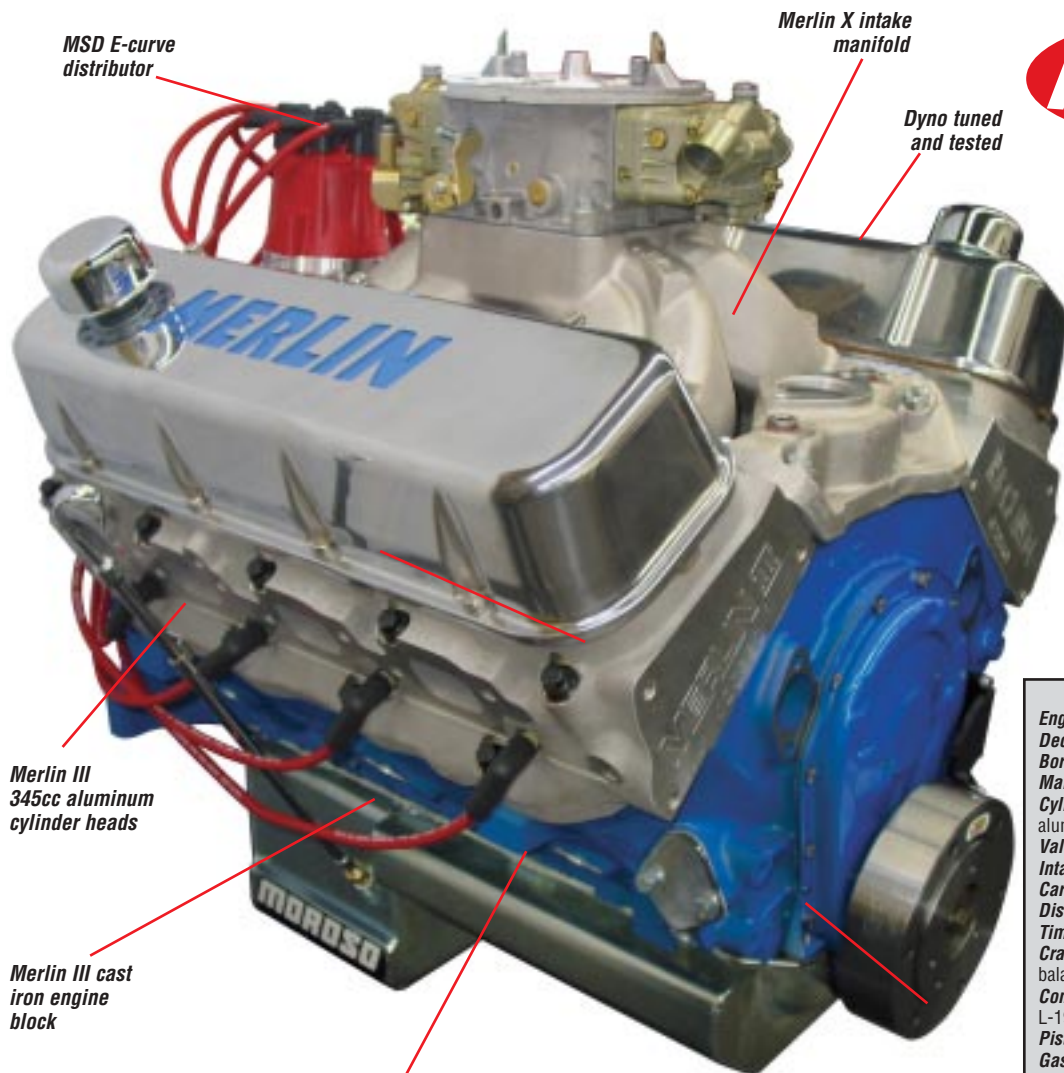
A = Compression calculated with a 119cc head, .020" deck, 5cc piston and a .041" gasket
 B = Compression calculated with a 119cc head, .020" deck, 46cc piston and a .041" gasket

Available options:	
Aluminum engine block	Cast iron cylinder heads
Polished aluminum engine block, cylinder heads and intake manifold (6 to 8 weeks lead time)	1 year/12,000 mile limited warranty (includes dyno break-in) Partial engine only
Polished cylinder heads and intake manifold (6 to 8 weeks lead time)	Contact your World sales representative for details.
CNC head porting (add 30 hp)	

BIG BLOCK CHEVROLET MERLIN 572 CID BBC ENGINE

The 572 c.i.d. Merlin is one of the most popular engines in the entire World Products lineup. And it's easy to see why. Most performance enthusiasts who seek serious horsepower appreciate the benefits of a 572 c.i.d. engine. And when they compare what they get in a Merlin, as opposed to a factory "crate motor" of the same displacement, World wins hands-down! Consider that World and GM are similar as they are manufacturers who produce the engine block, cylinder heads and intake manifold. But where the big difference lies is that

World sources its internal components from the aftermarket and the OEMs use many stock parts. The bottom line is that World engines contain premium grade components from the likes of ARP, Clevite, Eagle, Fel-Pro, Mahle, Manley, Moroso and MSD, Each Merlin is assembled by experienced, professional engine builders, carefully broken in, and dyno-tested to assure that it meets published performance standards. The engine (except the racing version) are backed by a 2-year/24,000 mile warranty. Now you know why World has the best values!



**Dyno-Proven
735 HP Output
On Pump Gas
And Backed
With A 2-Year
24,000-Mile
Warranty.
Compare This
To GM Crates!**

MSD E-curve distributor

Merlin X intake manifold

Dyno tuned and tested

Merlin III 345cc aluminum cylinder heads

Merlin III cast iron engine block

2 year/24,000 mile limited warranty

Digitally balanced rotating assembly (internally)

Technical Data:

Engine Block: Merlin III cast iron
Deck Height: 10.200"
Bore/Stroke: 4.500" x 4.500"
Main Caps: 4-bolt nodular splayed
Cylinder Heads: Merlin III 345cc aluminum
Valves: Manley stainless steel
Intake Manifold: Merlin X
Carburetor: AED (custom spec)
Distributor: MSD E-Curve
Timing Chain: Double roller
Crankshaft: 4340 Eagle/Scat internally balanced
Connecting Rods: 4340 Eagle/Scat with L-19 rod bolts
Pistons: Manley/Mahle
Gaskets: Felpro
Internal Hardware: ARP®
Exterior Hardware: Totally Stainless
Oil Pan: Moroso
Warranty: 2 year/24,000 mile limited (Street Series only)

Part #	C.I.D.	HP	Application	Compression	Camshaft	Induction	Dome	Notes
Complete Engine								
130236	572	735	Street	10.8:1	Hydraulic Roller	4500 1050cfm	15cc	A
130336	572	735	Street	10.8:1	Hydraulic Roller	EFI	15cc	A
108056	572/	700	Street	10.8:1	Solid Flat Tappet	4500 1050cfm	15cc	A
108086	572	850	Race	13.7:1	Solid Roller	4500 1050cfm	42cc	B

Complete Engine Includes: Pan to carb (or EFI), fully assembled, dyno tuned and tested and comes with a 2 year/24 month warranty (does not include starter, water pump or flywheel)

Notes:

A = Compression calculated with a 119cc head, .020" deck, 15cc piston and a .041" gasket
 B = Compression calculated with a 119cc head, .020" deck, 42cc piston and a .041" gasket

Available options:

Aluminum engine block
 Polished aluminum engine block, cylinder heads and intake manifold (6 to 8 weeks lead time)
 Polished cylinder heads and intake manifold (6 to 8 weeks lead time)
 CNC head porting (add 30 hp)

Cast iron cylinder heads

Contact your World sales representative for details.



MERLIN 632 CID BBC ENGINE

The old adage of "there's no substitute for cubic inches" certainly holds true in the form of World's 632 c.i.d. Merlin Big Block Chevy. Increasing the displacement of an engine is a sure-fire way to add horsepower and torque without placing undue strain on the rotating assembly or valve train. And it is

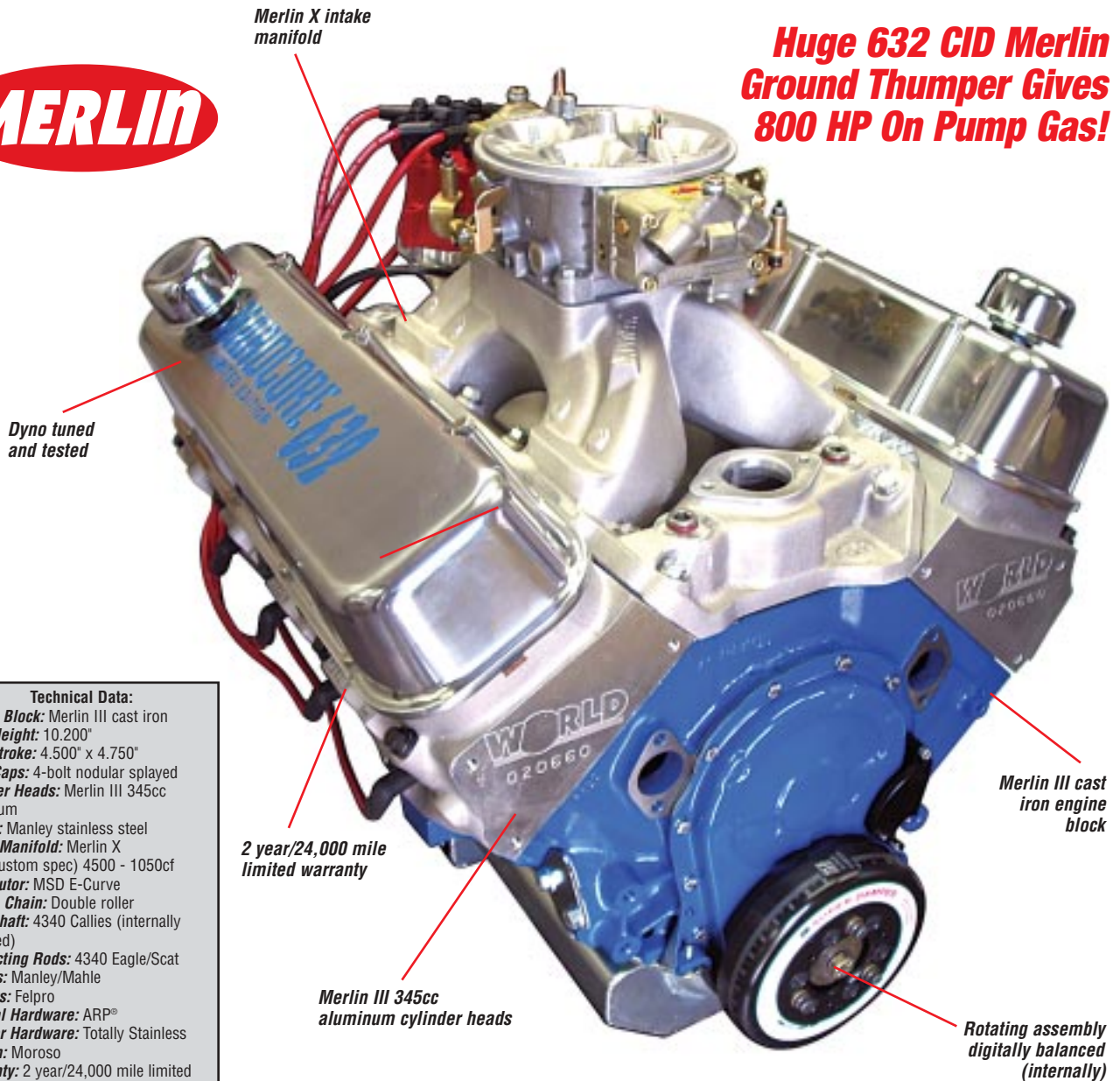
for the reason that World Products can back an 800 horsepower engine with a 2-year/24,000-mile warranty.

World Products also offers this 632-inch behemoth in a Race engine form with an output of 900 horsepower using racing gas. It's awesome!

BIG BLOCK CHEVROLET



Huge 632 CID Merlin Ground Thumper Gives 800 HP On Pump Gas!



Technical Data:
Engine Block: Merlin III cast iron
Deck Height: 10.200"
Bore/Stroke: 4.500" x 4.750"
Main Caps: 4-bolt nodular splayed
Cylinder Heads: Merlin III 345cc aluminum
Valves: Manley stainless steel
Intake Manifold: Merlin X AED (custom spec) 4500 - 1050cf
Distributor: MSD E-Curve
Timing Chain: Double roller
Crankshaft: 4340 Callies (internally balanced)
Connecting Rods: 4340 Eagle/Scat
Pistons: Manley/Mahle
Gaskets: Felpro
Internal Hardware: ARP®
Exterior Hardware: Totally Stainless
Oil Pan: Moroso
Warranty: 2 year/24,000 mile limited (Street Series only)

Part #	C.I.D.	HP	Application	Compression	Camshaft	Induction	Dome	Notes
Complete Engine								
130238	632	800	Street	10.4:1	Hydraulic Roller	4500 1050cfm	-6cc	A
130338	632	800	Street	10.4:1	Hydraulic Roller	EFI	-6cc	A
108090	632	900	Race	14.1:1	Solid Roller	4500 1050cfm	33cc	B

Complete Engine Includes: Pan to carb (or EFI), fully assembled, dyno tuned and tested and comes with a 2 year/24 month warranty (does not include starter, water pump or flywheel)

Notes:

A = Compression calculated with a 119cc head, .005" deck, -6cc piston and a .039" gasket
 B = Compression calculated with a 119cc head, .005" deck, 33cc piston and a .039" gasket

Available options:	
Aluminum engine block	Cast iron cylinder heads
Polished aluminum engine block, cylinder heads and intake manifold (6 to 8 weeks lead time)	1 year/12,000 mile limited warranty (includes dyno break-in) Partial engine only
Polished cylinder heads and intake manifold (6 to 8 weeks lead time)	Contact your World sales representative for details.
CNC head porting (add 30 hp)	