

Shop Labor Sheet

Bud's Machine and Engine Shop

**12019 C Pac. Hwy. S.W.
Lakewood WA 98499
Phone: 253-588-2837
Fax: 253-588-9926**

All Engine Jobs Require 50% Deposit

All Special Orders Must Be Prepaid

Surcharge To Assemble With Customer Parts

Pistons: Silvolite, Keith Black, Sealed Power,

Ross, BRC, J-E, SRP, Weisco

Rings: Sealed Power, C&A, Perfect Circle

Gaskets: Felpro

Timing: Cloyes, Dynagear

Bearings: Clevite 77, Federal Mogal, ACL

Oil Pumps: Melling

Camshafts: Comp Cams, Crane Cams, Isky,
Lunati, Delta

High Quality Engine Kits For Any Application Competitively Priced

We Also Can Get Budget Mail Order Type Kits - Please Ask

No Personal Checks

Cash - Visa - Mastercard - Certified Checks

Prices Subject to change without notice

All Jobs Subject To EPA Surcharge

Pricing on vintage restoring & hot import building may not be the same as below

Shop Labor Sheet

Block Services

Shop Time \$69.00/hr

Short Block Labor

**You Must Purchase A Complete Short Block Labor
For Any Warranty**

Disassemble Short Block - Remove Crank, Rods, Pistons, Cam and Timing

Deluxe Degrease - Jet Wash, R-R Cam Brgs, Freeze Plugs, Oil Galley Plugs, and Magnaflux for Cracks

Bore - Rottler Bar - Bore For Your Size Pistons 45deg & Parallel To Mainline

Hone - Sunnen Power Hone Finished For Your Rings

Resize Rods - Sunnen Rod Machine W/New Nuts

Balance Rods And Pistons - Hines Computerized Balancer

Assemble Short Block - Install Crank - Pistons and Rods - Camshaft And Timing

4-Cylinder - \$339 most

6-Cylinder - \$389 most

8-Cylinder - \$449 most

Install Cylinder Head(s) - Adjust Valves - \$100.00 Most

Install Cylinder Head OHC - Adjust Valves - \$125.00 DOHC-\$200

Install Tin - Clean Install Pan-Covers-Intake - \$150.00 Most

Crankshafts

Grind 3main crank (4-cyl)

\$87.00

Grind most 6 or 8cyl Crank

\$91.00

Grind 7 main crank (6cyl)

\$95.00

Clean Polish

\$47.00

Magnaflux

\$42.00

Weld rod/main each

\$61.00

Weld Thrust

\$57.00

Straighten

\$40.00

Engine Balancing

4-cyl

\$127.00

6-cyl inline

\$157.00

V-6 or V-8

\$187.00

Standard Flywheel & Pres Plt

\$42.00

Crank Only

\$105.00

Need: Pistons, Rods, Crank, Rings, Rod

brgs, Flywheel (with Bolts), Balancer (with

Bolts), Pulleys (with Bolts).

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Block Services

Shop Time \$69.00/hr

Tear Down

Dis-assemble short block	\$60.00
Dis-assemble long block	\$87.00
Remove cyl head(s)	\$32.00
Remove pan - covers - intake	Each \$10.00

Cleaning

Del Deg 4-cyl WO cam brgs	\$62.00
Del Deg 4-cyl W cam brgs	\$67.00
Del Deg 6-cyl WO cam brgs	\$62.00
Del Deg 6-cyl W cam brgs	\$72.00
Del Deg 8-cyl	\$77.00

Deluxe Degrease: Remove cam brgs, core plugs, oil galley plugs, jet wash, magnaflux, install cam brgs, core plugs, oil galley plugs plus parts

De-rust block	\$67.00
Tank bare block	\$42.00
R-R cam brgs	\$10.00ea
Tin work per load	\$20.00
Clean Intake	\$37.00

Connecting Rod Work

Recondition 3 or less	\$22.00ea
Recondition 4-cyl	\$71.00
Recondition 6-cyl	\$86.00
Recondition 8-cyl	\$97.00
R - R - align pistons	\$9.50ea
R - R - size pin bshgs+PARTs	\$17.00ea
Check big end for size	\$9.50ea
Flash grind rod beams	\$12.00ea

Surface Blocks

Deck 4-cyl	\$52.00
Deck 6-cyl inline	\$62.00
Parallel deck w/mainline 6or8	\$105.00
Square deck (parallel & 90deg)	\$151.00
Above covers .015" cut	Addl \$1.20/.001"

Mock assem/check deck **Ht.** \$80.00

Block Boring/Honing

Bore - power hone	\$17.50ea
Install Torque Plates	\$32.00ea
Power hone Cyls	\$10.50ea
Glaze break cylinders	\$9.00ea
Sleeve cylinder + Sleeve	\$72.00

Block Work

Line hone Mains	\$112.00
Mock assem/check clearances	\$102.00
Degree cam (must have card)	\$77.00
Race prep SB Chevy	\$120.00
Race prep: Relieves oil galleys, tap front Plugs, internally restrict (solid only, relieve oil returns, supply oil to cam thrust, improved cooling	

Flywheels

Surface flywheel flat	\$40.00
Surface flywhl w/step or pins	\$50.00
Surface flywheel w/step & pins	\$55.00

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Cylinder Head Services
Shop Time \$69.00/hr

Basic Valve Grind

4 Cylinder	\$95.00
6 Cylinder	\$120.00
8 Cylinder	\$155.00
Multi valve	\$10.25/valve
Recessed sprg (rabbit etc)	\$12.25/valve
Diesel heads	\$14.00/valve

Basic Valve Grind: dis-assemble - clean head(s) inspect, magnaflux, or dye test heads, inspect guides, springs, and valves. Grind valves, tri cut seats, assemble, and vacuum test for leak down

Pressure Test

Cylinder head	\$41.00ea
Matched Pair	\$76.00
Additional charge for special setups	

Guide Work

4 cyl (bronze or cast)+guide	\$44.00
6 cyl (bronze or cast)+guide	\$62.00
8cyl (bronze or cast)+guide	\$81.00
R-R guide alum head+guide	\$12.00ea

Valves and Seats

Clean - grind valves 4 or less	\$4.50ea
Clean - grind valves 4 or more	\$4.00ea
Tri-Cut seats 4 or less	\$6.50ea
Tri-Cut seats 4 or more	\$6.50ea
Install OS valve w/bowl hog	\$12.00ea
Bowl hog 78deg	\$6.50ea

Hard Ex Seats

4 Cylinder	\$122.00
6 Cylinder	\$142.00
8 Cylinder	\$162.00
One only (cut in Type)+seat	\$37.00
Each Additional (same head)	\$22.00
R-R removable type+seat	\$19.00

Re-Surface Heads

4 Cylinder - Mill	\$41.00
4 Cylinder Surface	\$36.00
6 Cylinder Mill	\$51.00
6 Cylinder Surface	\$46.00
V-Type Mill	\$56.00
V-Type Surface	\$51.00

Above covers .015" cut Addl \$1.20/.001"

Mill Intake Side	\$35.00 ea
Surface Ex Side	\$32.00 ea
Surface Ex Manifold	\$52.00 ea
Mill V type Intake	\$77.00

O.H.C.

R-R cam/rock shafts - adjust	\$37.00ea
Surface Rocker Arms	\$7.00 ea
R-R arms from shaft/clean	\$25.00/shaft

Misc

Set Valve Stem Hts(non adj)	\$2.00ea
Cut for OS Springs	\$10.50ea
Install Studs w/shoulder+parts	\$145.00
Install Studs wo/shoulder+parts	\$112.00