

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: Sealed Power, Keith Black Ross, J-E,
SRP, Weisco

Rings: Sealed Power, C&A, Perfect Circle

Gaskets: Felpro, Cometic

Bearings: Clevite 77, Federal Mogal, ACL

Camshafts: Comp Cams, Crane Cams, Brian
Crower, 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
Shop Time \$75.90/hr

Block Services

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 - \$372.90 most

6-Cylinder - \$427.90 most

8-Cylinder - \$493.90 most

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

Install Cylinder Head OHC - Adjust Valves - \$137.50 DOHC-\$220

Install Tin - Clean Install Pan-Covers-Intake - \$165.00 Most

Crankshafts

Grind 3main crank (4-cyl)

\$95.70

Grind most 6 or 8cyl Crank

\$100.10

Grind 7 main crank (6cyl)

\$104.50

Clean Polish

\$51.70

Magnaflux

\$46.20

Weld rod/main each

\$67.10

Weld Thrust

\$62.70

Straighten

\$44.00

Engine Balancing

4-cyl

\$139.70

6-cyl inline

\$172.70

V-6 or V-8

\$205.70

Standard Flywheel & Pres Plt

\$46.20

Crank Only

\$115.50

Need: Pistons, Rods, Crank, Rings, Rod

brgs, Flywheel (with Bolts), Balancer (with

Bolts), Pulleys (with Bolts).

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Block Services

Shop Time \$75.90/hr

Tear Down

Dis-assemble short block	\$66.00
Dis-assemble long block	\$95.70
Remove cyl head(s)	\$35.20
Remove pan - covers - intake	Each \$11.00

Cleaning

Del Deg 4-cyl WO cam brgs	\$68.20
Del Deg 4-cyl W cam brgs	\$73.70
Del Deg 6-cyl WO cam brgs	\$68.20
Del Deg 6-cyl W cam brgs	\$79.20
Del Deg 8-cyl	\$84.70

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	\$73.70
Tank bare block	\$46.20
R-R cam brgs	\$11.00ea
Tin work per load	\$22.00
Clean Intake	\$40.70

Connecting Rod Work

Recondition 3 or less	\$24.20ea
Recondition 4-cyl	\$78.10
Recondition 6-cyl	\$94.60
Recondition 8-cyl	\$106.70
R - R - align pistons	\$10.45ea
R - R - size pin bshgs+PARTs	\$18.70ea
Check big end for size	\$10.45ea
Flash grind rod beams	\$13.20ea

Surface Blocks

Deck 4-cyl	\$57.20
Deck 6-cyl inline	\$68.20
Parallel deck w/mainline 6or8	\$115.50
Square deck (parallel & 90deg)	\$166.10
Above covers .015" cut	Addl \$1.20/.001"
Mock assem/check deck Ht.	\$88.00

Block Boring/Honing

Bore - power hone	\$19.25ea
Install Torque Plates	\$35.20ea
Power hone Cyls	\$11.55ea
Glaze break cylinders	\$9.90ea
Sleeve cylinder + Sleeve	\$79.20

Block Work

Line hone Mains	\$123.20
Mock assem/check clearances	\$112.20
Degree cam (must have card)	\$84.70
Race prep SB Chevy	\$132.00
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 \$75.90/hr

Basic Valve Grind

4 Cylinder	\$104.50
6 Cylinder	\$132.00
8 Cylinder	\$170.50
Multi valve	\$18.28/valve
Recessed sprg (most ohc)	\$13.48/valve
Diesel heads	\$15.40/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	\$45.10ea
Matched Pair	\$86.00
Additional charge for special setups	

Guide Work

4 cyl (bronze or cast)+guide	\$48.40
6 cyl (bronze or cast)+guide	\$68.20
8cyl (bronze or cast)+guide	\$89.10
R-R guide alum head+guide	\$13.20ea

Valves and Seats

Clean - grind valves 4 or less	\$4.95ea
Clean - grind valves 4 or more	\$4.00ea
Tri-Cut seats 4 or less	\$7.15ea
Tri-Cut seats 4 or more	\$6.50ea
Install OS valve w/bowl hog	\$13.20ea
Bowl hog 78deg	\$7.15ea

Hard Ex Seats

4 Cylinder	\$134.20
6 Cylinder	\$156.20
8 Cylinder	\$178.20
One only (cut in Type)+seat	\$40.70
Each Additional (same head)	\$24.20
R-R removable type+seat	\$20.90

Re-Surface Heads

4 Cylinder - Mill	\$45.10
4 Cylinder Surface	\$39.60
6 Cylinder Mill	\$56.10
6 Cylinder Surface	\$50.60
V-Type Mill	\$61.60
V-Type Surface	\$56.10

Above covers .015" cut Addl \$1.32/.001"

Mill Intake Side	\$38.50 ea
Surface Ex Side	\$35.20 ea
Surface Ex Manifold	\$57.20 ea
Mill V type Intake	\$84.70

O.H.C.

R-R cam/rock shafts - adjust	\$40.70ea
Surface Rocker Arms	\$7.70 ea
R-R arms from shaft/clean	\$27.50/shaft

Misc

Set Valve Stem Hts(non adj)	\$2.20ea
Cut for OS Springs	\$11.55ea
Install Studs w/shoulder+parts	\$159.50
Install Studs wo/shoulder+parts	\$123.20