

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

Pistons: Sealed Power, SRP, J-E, Icon Forged,
Weisco, Mahle, CP

Rings: Sealed Power, Perfect Circle, Hastings

Gaskets: Felpro, Cometic, Rock, Topline

Bearings: Clevite 77, Federal Mogal, ACL

Camshafts: Comp Cams, Crane Cams, Brian
Crower, Delta Cams

High Quality Engine Kits For Any Application Competitively Priced

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 Rod, and Import building
may not be the same as below

Shop Labor Sheet
Shop Time \$98.50/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 - \$399.00 most

6-Cylinder - \$469.00 most

8-Cylinder - \$499.00 most

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

Install Cylinder Head OHC - Adjust Valves - \$137.50, 2Cams-\$220, 4Cams-\$400

Install Tin - Clean Install Pan-Covers-Intake - \$275.00 Most

Crankshafts

Grind most 6 or 8cyl Crank

\$142.50

Grind 7 main crank (6cyl)

\$154.50

Clean Polish

\$51.50

Magnaflux

\$53.50

Weld rod/main each

\$75.00

Weld Thrust

\$77.50

Straighten

\$44.00

Engine Balancing

4-cyl

\$169.50

6-cyl inline

\$200.50

V-6 or V-8

\$249.50

Standard Flywheel & Pres Plt

\$36.50

Crank Only w/Bob Weights

\$125.50

Need: Pistons, Rods, Crank, Rings, Rod

brgs, Flywheel (with Bolts), Balancer (with Bolts), Pulleys (with Bolts).

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Block Services

Shop Time \$98.50/hr

Tear Down

Dis-assemble short block	\$87.00
Dis-assemble long block	\$109.50
Remove cyl head each	\$35.50
Remove pan - covers - intake	Each \$11.00

Cleaning

Del Deg 4-cyl WO cam brgs	\$78.50
Del Deg 4-cyl W cam brgs	\$83.50
Del Deg 6-cyl WO cam brgs	\$78.50
Del Deg 6-cyl W cam brgs	\$89.50
Del Deg 8-cyl	\$94.50

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	\$93.50
Tank bare block	\$46.50
R-R cam brgs	\$11.00ea
Tin work per load	\$22.00
Clean Intake	\$40.50

Connecting Rod Work

Recondition 3 or less	\$24.50ea
Recondition 4-cyl	\$88.50
Recondition 6-cyl	\$132.50
Recondition 8-cyl	\$176.50
R - R - align pistons	\$12.50ea
R - R - size pin bshgs+PARTs	\$22.50ea
Check big end for size	\$10.50ea

Surface Blocks

Deck 4-cyl	\$98.50
Deck 6-cyl inline	\$98.50
Parallel deck w/mainline 6or8	\$164.50
Square deck (parallel & 90deg)	\$198.50
Above covers .015" cut	Addl \$1.20/.001"

Mock assem/check deck **Ht.** \$88.00

Block Boring/Honing

Bore - power hone	\$25.00ea
Install Torque Plates	\$35.50ea
Power hone Cyls	\$11.50ea
Sleeve cylinder + Sleeve	\$121.50

Block Work

Line hone Mains	\$181.50
Mock assem/check clearances	\$134.50
Degree cam (must have card)	\$98.50
Race prep SBChev	\$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	\$40.50
Surface flywhl w/step or pins	\$50.00
Surface flywheel w/step & pins	\$55.00
R&R Ring Gear	\$37.50
VW Deep Step	\$60.50

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Cylinder Head Services
Shop Time \$98.50/hr

Basic Valve Grind

4 Cylinder OHV 2V per	\$104.50
6 Cylinder OHV 2V per	\$132.00
8 Cylinder	\$170.50
Recessed sprg (most ohc)	\$13.50/valve
Diesel heads	\$18.50/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	\$58.50
Matched Pair	\$96.00
Additional charge for special setups	

Guide Work

4 cyl (bronze or cast)+guide	\$61.50
6 cyl (bronze or cast)+guide	\$79.50
8cyl (bronze or cast)+guide	\$105.50
R-R guide alum head+guide	\$10.000ea

Valves and Seats

Clean - grind valves 4 or less	\$5.50ea
Clean - grind valves 4 or more	\$5.00ea
Tri-Cut seats 4 or less	\$13.50ea
Tri-Cut seats 4 or more	\$11.50ea
Install OS valve w/bowl hog	\$15.50ea
Bowl hog 78deg	\$10.50ea

Hard Ex Seats

4 Cylinder + Seats	\$99.00
6 Cylinder + Seats	\$126.50
8 Cylinder + Seats	\$149.50
One only (cut in Type)+seat	\$40.50
Each Additional (same head)	\$25.50
R-R removable type+seat	\$27.50

Re-Surface Heads

4 Cylinder - Mill	\$64.50
4 Cylinder Surface	\$39.50
6 Cylinder Mill	\$75.50
6 Cylinder Surface	\$56.50
V-Type Mill	\$93.00
V-Type Surface	\$65.50

Above covers .015" cut Addl \$2.00/.001"

Mill Intake Side	\$40.50 ea
Surface Ex Side	\$31.50 ea
Surface Ex Manifold	\$57.00 ea
Mill V type Intake	\$98.50

O.H.C.

R-R cam/rock shafts - adjust	\$40.50ea
Surface Rocker Arms	\$9.50 ea
R-R arms from shaft/clean	\$30.00/shaft

Misc

Set Valve Stem Hts(non adj)	\$2.50ea
Cut for OS Springs	\$11.50ea
Install Studs w/shoulder+parts	\$159.50
Install Studs wo/shoulder+parts	\$123.50