

CLEANING	Time (hr.)	Rate
Clean Head (Jet Spray Wash) or Small Parts	0.50	\$ 80.00
Clean Block (Jet Spray Wash) <i>(Includes remove all plugs, clean oil galleys)</i>	1.00	\$ 160.00
Clean for Overhaul <i>(Includes: Block, Crankshaft, Rods, and all engine sheet metal and small parts, charged when doing full engine build)</i>	2.60	\$ 416.00
Shot-Peen Block	0.80	\$ 128.00
Shot-Peen Head or Parts	0.50	\$ 80.00
Media Blast Parts	0.50	\$ 80.00
Measure and Inspect <i>(Includes measuring bore, crank, rods, etc. This charge is waived if further machine work is performed)</i>	1.00	\$ 160.00

BORING AND HONING	Time (hr.)	Rate
1 to 3 Cylinders	1.00	\$ 160.00
4 Cylinders	2.00	\$ 320.00
6 Cylinders	2.20	\$ 352.00
8 Cylinders	2.50	\$ 400.00
10 Cylinders	2.70	\$ 432.00

ALIGN HONING AND LINE BORING	Time (hr.)	Rate
Align Hone Block <i>(Includes machining for cutting caps, measuring, and actual align hone process to correct main bore)</i>	2.00	\$ 320.00
Line Bore Block <i>(Used when replacement caps are fitted, or new babbit bearings are being machined)</i>	3.00	\$ 480.00

RESURFACING	Time (hr.)	Rate
Resurface Cylinder Head (Car/Light Truck)	0.54	\$ 86.40
Resurface Cylinder Head (Diesel or Large Truck)	1	\$ 160.00
Resurface/Deck Block (Inline)	0.71	\$ 113.60
Resurface/Deck Block (V Block)	1.5	\$ 240.00

PRESSURE TESTING	Time (hr.)	Rate
Car and Light Truck		
Pressure Test Head	0.54	\$ 86.40
Pressure Test Block (Inline)	1.14	\$ 182.40
Pressure Test Block (V Block)	1.34	\$ 214.40
Large Truck/Diesel		
Pressure Test Head	1	\$ 160.00

VALVE JOBS	Time (hr.)	Rate
<i>(Includes media blast combustion chambers and runners, clean valves machine valves, measure and check guides, and machine valve seats)</i>		
2 Valves	0.5	\$ 80.00
4 Valves	0.71	\$ 113.60
6 Valves	0.85	\$ 136.00
8 Valves	0.9	\$ 144.00
12 Valves	1.34	\$ 214.40
16 Valves	1.65	\$ 264.00
18 Valves	1.85	\$ 296.00
20 Valves	1.89	\$ 302.40
24 Valves	2.12	\$ 339.20
32 Valves	2.5	\$ 400.00
Remove Camshaft to Machine	0.4	\$ 64.00
Adjust Valves w/ lash adjusters	0.5	\$ 80.00
Adjust Valves w/ cups and shims	1	\$ 160.00

(Master Price List Continued)

CRANKSHAFTS	Time (hr.)	Rate
Polish Crankshaft	0.63 \$	100.80
Machine Crankshaft (Auto/Light Truck)	2.23 \$	356.80
Machine Crankshaft (Large Truck/Tractor)	3.13 \$	500.80
Straighten Crankshaft	0.45 \$	72.00
Magnaflux Crankshaft	0.31 \$	49.60

ENGINE TEAR DOWN

Tear Down Complete Engine	4.00 \$	640.00
<i>(Charged when fully dressed engine with accessories, sheet metal components, brackets, etc.)</i>		
Tear Down Short Block	1.50 \$	240.00
<i>(Block with Crank, Rods, and Pistons assembled-ONLY)</i>		
Tear Down Long Block	3.00 \$	480.00
<i>(Full engine with all sheet metal and accessories removed)</i>		

ENGINE ASSEMBLY

Assemble Short Block	3.00 \$	480.00
<i>(Includes install/assemble JUST crank, rods, and pistons and measure and check all clearances)</i>		
Assemble Long Block	8.00 \$	1,280.00
<i>(Includes short block plus cam, timing, and heads. Does NOT include any sheet metal (i.e. valve covers or oil pan)</i>		
Assemble Complete Engine	10.00 \$	1,600.00
<i>(Full assembly, including all sheet metal components, accessories and full dress)</i>		
Install Expansion ("Freeze") Plugs	0.25 \$	40.00
Replace Camshaft Bearings	1.00 \$	160.00
File-Fit Piston Rings	1.00 \$	160.00

VALVE SEAT AND GUIDE

	Time (hr.)	Rate
Replace Valve Guide	0.1 \$	16.00 ea.
Replace Valve Seat	0.1 \$	16.00 ea.
<i>(Cost of guide or seat additional)</i>		
Cut for Positive Valve Seats	0.035 \$	5.60 ea.

FLYWHEELS

Car and Light Truck	0.63 \$	100.80
Large Truck/Tractor	1.25 \$	200.00

BALANCING

Balance Rotating Assembly	2.86 \$	457.60
Add Heavy Metal	0.5 \$	80.00 ea.
<i>(Cost of Heavy Metal additional)</i>		

O-RING AND FIRE RING

Machine/Install O-Rings in Head or Inline Block	1.79 \$	286.40
Machine/Install O-Rings in V Block	2.01 \$	321.60

CYLINDER SLEEVING

Machine/Install Straight or Flanged Sleeve	1.34 \$	214.40
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CONNECTING RODS

Resize/Recondition Connecting Rod	0.3 \$	48.00
Hang Pistons (Heated/Press-Fit)	1 \$	160.00
Replace Rod Bolts	0.5 \$	80.00

For service not listed above, please contact us at 540-338-1001, or email:
info@classicmotormachine.com