

To give an estimate using this **2022 guide**, you must know all the individual operations necessary to complete each job. If you need help, please call we will be glad to assist you.

Example #1

VALVE JOB ON PAIR OF V8 ALUMINUM HEADS

Jet Wash Head (X 2)	CLE-2A	40.00
Glass Bead Head (X 2)	CLE-2B	56.00
Pressure Test Head (X 2)	PRE-1	104.00
Surface Head (X 2)	SUR-2	120.00
8 Cylinder Valve Job	CHR-VJ8	160.00
	===	===
Total Labor for Pair of V8 Heads		\$480.00
(Plus any parts or additional labor operations necessary)		

Example #2

4 CYL SOHC ALUMINUM 16 VALVE HEAD

Jet Wash Head	CLE-2A	20.00
Glass Bead Head	CLE-2B	28.00
Pressure Test Head	PRE-1	52.00
4 Cylinder OHC Valve Job	CHR-VJ5	125.00
Add charge for 4 Valves Per Cyl	CHR-4V	100.00
Surface Head	SUR-2	60.00
	===	===
Total		\$385.00

ALL PARTS MUST BE CLEANED PRIOR TO MACHINING

PARTS CLEANING

Degrease Block	CLE-1	110.00
Shot Blast Block	CLE-1A	110.00
Clean Cylinder Head	CLE-2	30.00
Jet Wash Head	CLE-2A	20.00
Glass Bead Head	CLE-2B	28.00
Clean 6 Cylinder Head	CLE-3	36.00
Degrease Connecting Rods	CLE-4	6.00
Degrease Crankshaft	CLE-5	24.00
Clean Intake Manifold	CLE-6	54.00
Clean Diesel Intake Manifold	CLE-6A	120.00
Clean Oil Pan	CLE-OP	25.00
Clean Valve Cover	CLE-VC	8.00
Soda Blast Cleaning	CLE-SODA	per ¼ hour
Misc. Cleaning	CLE-MIS	per ¼ hour

MAGNAFLUXING

Magnaflux Block	MAG-1	100.00
Magnaflux Head (most)	MAG-2	27.00
Magnaflux Connecting Rods	MAG-3	15.00
Magnaflux Crankshaft	MAG-4	44.00
Magnaflux Axle	MAG-5	30.00
Magnaflux Heavy Duty Head	MAG-6	58.00
Misc. Magnafluxing	MAG-MIS	per ¼ hour

PRESSURE TESTING

Pressure Test Head (most)	PRE-1	52.00
Pressure Test "L" Block	PRE-2	70.00
Pressure Test ½ "V" Block	PRE-3	64.00
Pressure Test 6 Cylinder Head	PRE-6	60.00
Misc. Pressure Testing	PRE-MIS	per ¼ hour

CYLINDER HEAD RECONDITIONING

Disassemble & Estimate (per hd)	CHR-EST	32.00
8 Cylinder Valve Job	CHR-VJ8	160.00
6 Cylinder Valve Job	CHR-VJ6	115.00
4 Cylinder Valve Job	CHR-VJ4	92.00
4 Cylinder OHC Valve Job	CHR-VJ5	125.00
3 Cylinder Valve Job	CHR-VJ3	70.00
Competition Valve Job	CHR-COMP	225.00
Reseat Jet Valve	CHR-JET	15.00
Additional for 3 Valves per cyl (ea)	CHR-3V	10.00
Additional for 4 Valves per cyl (ea)	CHR-4V	25.00
Additional for 5 Valves per cyl (ea)	CHR-5V	32.00
Adjust Valves – Bucket Type (ea)	CHR-1	10.00
Adjust Valves – Screw Type (ea)	CHR-1A	5.00
Knurl Guides (ea)	CHR-2	6.00
Bore & Install Valve Guide	CHR-3	25.00
Install 3 or more Guides in same hd	CHR-3A	18.00
Install Guide Liners	CHR-3B	8.00
Replace Press In Guide	CHR-4	10.00
Replace Seat	CHR-5	32.00
Replace 2 or more Seats in same hd	CHR-5A	20.00
Remove & Replace Camshaft	CHR-6	27.00
Reface Valve	CHR-7	9.00
Replace Press In Stud	CHR-8	20.00
Install Screw In Stud	CHR-9	16.00
Replace Expansion Plug	CHR-10	4.00
Machine Guides for Seals	CHR-11	6.00
Cut Spring Pockets	CHR-12	8.00
Assemble Spring Heights	CHR-13	5.00
Reface Seat	CHR-15	12.00
Vacuum Test Valve	CHR-16	3.00
Enlarge Throat Area	CHR-17	12.00
Swap Parts to NEW Head	CHR-20	70.00
Change Valve Stem Seals (ea)	CHR-VS	4.00
Misc. Cylinder Head Work	CHR-MIS	per ¼ hour

ALUMINUM & CAST HEAD REPAIR

Weld Aluminum Head (per ½ hr)	AHR-1	60.00
Straighten Aluminum Head	AHR-2	74.00
Align Bore Camshaft Bores	AHR-3	170.00
Align Hone Camshaft Bores	AHR-4	88.00
Bore & Install Cam Bearing	AHR-5	97.00
Crack Repair Cast Iron (per ½ hr)	AHR-6	64.00
Misc. Head Repair	AHR-MIS	per ¼ hour

HEAD AND BLOCK SURFACING

Surface Cast Iron Head	SUR-1	60.00
Surface Aluminum Head	SUR-2	60.00
Surface 6 Cyl Cast Iron Head	SUR-3	76.00
Surface 6 Cyl Aluminum Head	SUR-4	76.00
Surface Diesel Head w/Pre-Cups	SUR-5	140.00
Surface Block, per Cylinder	SUR-6	24.00
Surface Head for Compression	SUR-7	96.00
Surface Intake Manifold (per side)	SUR-8	52.00
Surface 4 Cyl Exhaust Manifold	SUR-9	72.00
Surface 6 Cyl Exhaust Manifold	SUR-10	88.00
Surface Flat Head (on parallels)	SUR-11	75.00
Square Deck to Set Dimensions	SUR-12	280.00
Misc. Surfacing	SUR-MIS	per ¼ hour

Misc. Labor Billed at \$96.00 per hour



BLOCK WORK

Install Cam Bearings	BLO-1	12.00
Deridge Cylinder	BLO-2	11.00
Hone Cylinder to Size	BLO-3	12.00
Ball Hone (Deglaze) Cylinder	BLO-3A	8.00
Hone Cylinder to Size (No Bore)	BLO-3C	25.00
Replace Expansion Plugs	BLO-4	32.00
Align Hone Block	BLO-7	375.00
Prep Block (final wash)	BLO-8	45.00
Misc. Block Work	BLO-MIS	per ¼ hour

BLOCK BORING

Bore Cylinder	BOR-1	24.00
Bore & Hone 1 Cyl Engine	BOR-2	85.00
Sleeve One Cylinder	BOR-3	130.00
Bore Blind Hole (per cyl)	BOR-B1	68.00
Misc. Boring	BOR-MIS	per ¼ hour

PISTON AND ROD WORK

Press Piston Pins	PIS-1	24.00
Press Piston (2 or more)	PIS-1A	10.00
Align Rods to Piston	PIS-2	3.00
Check Rods for Roundness	PIS-3	5.00
Touch Up Rod Bore	PIS-3A	9.00
Recondition Rod	PIS-4	32.00
Recondition Rod, 3 or more	PIS-4A	22.00
Bore & Install Bushing in Rod	PIS-5	30.00
Install & Fit Pin Bushing	PIS-7	20.00
Misc. Piston/Rod Work	PIS-MIS	per ¼ hour

CRANKSHAFT WORK

Passenger Car & Light Truck Only, All Others By Quote

Regrind Small Eng Crank (most)	CRA-1	65.00
Regrind 2 Journal Crankshaft	CRA-2	90.00
Regrind 7 Journal Crankshaft	CRA-3	136.00
Regrind 10 Journal Crankshaft	CRA-4	168.00
Regrind 9 Journal Crankshaft	CRA-5	165.00
Regrind 13 Journal Crankshaft	CRA-7	190.00
Cross Drill Crankshaft	CRA-8	91.00
Shot Blast Crankshaft	CRA-9	28.00
Check & Polish Crankshaft	CRA-10	45.00
Balance Assembly (most)	CRA-11	350.00
Misc. Crankshaft Work	CRA-MIS	per ¼ hour

ENGINE ASSEMBLY

Disassemble Engine (most)	ENG-DIS	125.00
Assemble 4 Cylinder Engine	ENG-ASS4	525.00
Assemble 6 Cylinder Engine	ENG-ASS6	575.00
Assemble 8 Cylinder Engine	ENG-ASS8	650.00
Assemble 4 Cylinder Short Block	ENG-ASS4SB	400.00
Assemble 6 Cylinder Short Block	ENG-ASS6SB	450.00
Assemble 8 Cylinder Short Block	ENG-ASS8SB	650.00

Example #3 CHECK: 4 CYLINDER OHV HEAD

Jet Wash Head	CLE-2A	20.00
Pressure Test Head	PRE-1	52.00
Vacuum Test Valve (X 8)	CHR-16	24.00
Surface Cylinder Head	SUR-2	60.00
		==,==
		\$156.00

Example #4 PRESSING PISTONS (set of 8)

Degrease Rod (X 8)	CLE-4	48.00
Press Piston Pins (X8)	PIS-1A	80.00
Align Rods to Pistons (X8)	PIS-2	24.00
		==,==
		152.00

Example #5 BORE AN 8 CYLINDER BLOCK

Degrease Block	CLE-1	110.00
Bore Cylinder (X8)	BOR-1	192.00
Hone Cylinder to size (X8)	BLO-3	96.00
Prep Block (final wash)	BLO-8	45.00
Replace Cam Bearings (X5)	BLO-1	60.00
Replace Expansion Plugs	BLO-4	32.00
		==,==
		\$535.00

(This is labor only, any parts used are additional)

FLYWHEEL SURFACING

Resurface Flywheel	FLY-1	42.00
Resurface Flywheel over 12"	FLY-2	46.00
Resurface Stepped Flywheel	FLY-3	60.00
Resurface M.D. Truck Flywheel	FLY-4	64.00
Resurface VW/Horizon Flywheel	FLY-5	90.00
Resurface H.D. Truck Flywheel	FLY-6	96.00
Resurface Dual Mass Flywheel	FLY-7	125.00
Remove Alignment Pin	FLY-PIN	4.00
Misc. Flywheel Surfacing	FLY-MIS	per ¼ hour

HYDRAULIC PRESS WORK

Rebuild CV Joint (most)	HYD-1	110.00
Press Axle Bearing (most)	HYD-2	46.00
Press Axle Brng w/Backing Plate	HYD-2A	125.00
Press FWD Bearing in Hub	HYD-3	48.00
Press Universal Joint	HYD-4	40.00
Install Flywheel Ring Gear	HYD-5	40.00
Press Cam Gear	HYD-6	28.00
Misc. Press Work	HYD-MIS	per ¼ hour

KING PINS

Install & Fit Bushings to 1"	PIN-1	74.00
Install & Fit Bushings (1 spindle)	PIN-1A	50.00
Install & Fit Bushings to 1.5"	PIN-2	90.00
Install & Fit Bushings over 1.5"	PIN-3	100.00
Misc. Pin & Spindle Work	PIN-MIS	per ¼ hour

THREAD REPAIR

Install Helicoil	THR-1	24.00
Install Helicoil, 2 or more	THR-2	12.00
Remove Broken Bolt / Stud (most)	THR-3	36.00
Remove Stud	THR-4	3.00
Install Spark Plug Helicoil	THR-SP	36.00
Misc. Thread Repair	THR-MIS	per ¼ hour

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