

CIRCLE PERFORMANCE MACHINE
69 LOCUST STREET
BERKLEY MA 02779
PH 1-508-580-5844, ja@circleperformance.com

CUSTOMER

ADDRESS

DISCRIPTION	Focus Midget Engine Long Block
TOTAL PARTS	\$ 2,617.00
LABOR	\$ 3,000.00
TOTAL SUBLET	\$ -
TAX	\$ 163.56
GRAND TOTAL	\$ 5,780.56

NOTES:

INTAKE CAM INSTALLED AT 110 LC
EXHAUST CAM INSTALLED AT -110 LC
INTAKE LIFT AT TDC WITH .007 LASH = .075 in
EXHAUST LIFT AT TDC WITH .007 LASH = .055 in
ARP HEAD FASTNERS TORQUE VALUE WITH ARP ASSEMBLY LUBE = 55#
VOC MAINS = .0026 in. MINIMUM
VOC RODS = .0024 in. MINIMUM
ACTUAL BORE SIZE = 3.3475 in. 85.02mm, less than .010 over
ACTUAL DISPLACEMNT 121.8 CID \ 1997 cc

HEAD PARTS	TIME/PN	LABOR	PARTS	SUBLET
16 VALVE STEM SEALS	EOK		\$ 32.00	
2 CAM FRONT SEALS	VICTOR		\$ 15.00	
LOWER CONVERSION GASKET SET	VICTOR		\$ 125.00	
CUSTOM INTAKE CAM, 278	CPM		\$ 250.00	
CUSTOM EXHASUT CAM , 267	CPM		\$ 250.00	
16 VALVE SPRINGS	SBI		\$ 80.00	
HEAD GASKET	VICTOR		\$ 50.00	
TIMING BELT	MELLING		\$ 25.00	
HEAD STUD KIT, ARP	ARP		\$ 175.00	
FIXED IDLER PULLLY	CLOYES		\$ 30.00	
BELT ADJUSTER PULLEY	CLOYES		\$ 40.00	

HEAD LABOR

DISMANTLE CYLINDER HEAD	HEAD LABOR # 1
REMOVE OIL GALLY PLUGS IN HEAD	HEAD LABOR # 1
HAND SCRAPE SEALANTS AND GASKETS	HEAD LABOR # 1
SPRAY WASH CYLINDER HEAD	HEAD LABOR # 1
INSPECT CAM BORE CONDITION	HEAD LABOR # 1
INSPECT VALVE GUIDE CONDIDTION	HEAD LABOR # 1
INSPECT VALVES, BLAST AND GRIND 45	HEAD LABOR # 1
SODA BLAST CYLINDER HEAD	HEAD LABOR # 1
REMOVE AVDEL OIL PLUG AND TAP 1\4 NC	HEAD LABOR # 1
SPRAY WASH AND PREP FOR VALVE JOB	HEAD LABOR # 1

TOTAL HOURS HEAD LABOR # 1

VALVE JOB \ 4 VALVE PER CYLNDER	HEAD LABOR # 2
MEASURE CHAMBER SIZE CYLINDER HEAD	HEAD LABOR # 2
MACHINE HEAD TO RESULT 10.5 CR	HEAD LABOR # 2

TOTAL HOURS HEAD LABOR # 2

MEASURE ALL INSTALLED SPRING HEIGHTS	HEAD LABOR # 3
DETERMINE AMOUNT TO MACHINE EACH SPRING PAD	HEAD LABOR # 3
MACHINE SPRING PADS PER REQUIREMENT	HEAD LABOR # 3

TOTAL HOURS HEAD LABOR # 3

ASSEMBLE CYLINDER HEAD LESS SPRINGS	HEAD LABOR # 4
SET VALVE LASH BY GRINDING TIPS OF VALVES	HEAD LABOR # 4
FINAL WASH AND ASSEMBLE CYLINDER HEAD	HEAD LABOR # 4
RE-CHECK LASH AND FINE ADJUST AS NESSISARY	HEAD LABOR # 4

TOTAL HOURS HEAD LABOR # 4

BLOCK PARTS	TIME/PN	LABOR	PARTS	SUBLET
ENGINE CORE			\$ 400.00	
ROD BEARINGS	CLEVITE 77		\$ 30.00	
MAIN BEARINGS	CLEVITE 77		\$ 40.00	
PISTON SET, FORGED w\ 3.5cc DOME	JE or BETTER		\$ 650.00	
PISTON RING SET	INC WITH PISTON			
WRIST PIN & WIRE LOCKS	INC WITH PISTON			
CONNECTING RODS, BILLET H BEAM	IMPORT		\$ 425.00	

BLOCK LABOR

REMOVE CYLINDER HEAD	BLOCK LABOR # 1
DISSASSEMBLE SHORT BLOCK	BLOCK LABOR # 1
HAND SCRAPE SEALANTS AND GASKETS	BLOCK LABOR # 1
REMOVE SCALE AND RUST FROM SIDES OF BLOCK	BLOCK LABOR # 1
REMOVE OIL GALLEY PLUGS	BLOCK LABOR # 1
CHASE ALL GALLEY PLUG THREADS	BLOCK LABOR # 1
TAP OIL DIPSTICK HOLE	BLOCK LABOR # 1
SPRAY WASH BLOCK FOR INSPECTION	BLOCK LABOR # 1

TOTAL HOURS BLOCK LABOR # 1

TORQUE UP MAINS	BORE AND HONE
INSTALL DECK PLATE AND TORQUE UP	BORE AND HONE
MEASURE MAIN BEARING HOUSING BORE	BORE AND HONE
BORE ENGINE NEXT OVERSIZE	BORE AND HONE
HONE BORES TO RUNNING CLEARANCE	BORE AND HONE

TOTAL HOURS BORE AND HONE

ADJUST PIN CLARANCE RODS TO .0010	OIL CLEARANCE
CLEAN CONNECTING RODS	OIL CLEARANCE
VERIFY BIG END CORECT SIZE	OIL CLEARANCE
TORQUE MAIN BEARINGS, CALC. OIL CLEARANCE	OIL CLEARANCE
TORQUE ROD BEARINGS, CALC. OIL CLEARANCE	OIL CLEARANCE
POLISH CRANKSHAFT	OIL CLEARANCE
MEASURE CRANKSHAFT	OIL CLEARANCE
FINAL WASH CRANKSHAFT	OIL CLEARANCE

ASSEMBLE SHORT BLOCK	ASSEMBLE
OIL PUMP, DISMANTLE, CLEAN AND REASSEMBLE	ASSEMBLE
INSTALL CYLINDER HEAD	ASSEMBLE
FILE FIT PISTON RINGS	ASSEMBLE
DEGREE IN CAMSHAFTS	ASSEMBLE

TOTAL HOURS LABOR PACKAGE ASSEMBLE