

Description				Engine @£40/h	
Clean head and paint block. Assemble pistons, rods and piston rings, fit into block. Install (had to machine cam gear to achieve correct cam end float) cam, crank with rear seal (machine rear main cap to clear sump), torque up mains (replace stripped stud!!) . Fit block onto crankcase, fit rods onto crank etc. Check oil pump and fit, make up new oil pipe from block to pump, clean and fit.				24	
Machine new mag drive shaft, assemble. Order lip seal for front of cam. Paint parts. Measure up and machine up spacers for valve springs. Lap in valves and assemble head. Fit head. Assemble rocker gear, offer up and measure for pushrods, make pushrods to length. Assemble rocker gear. Mod oil feed castin supplied to fit in tappet chest area and fit.				25	
Total hours				49.00	
Materials		Remove old guides, fit new and ream. Machine out and fit 4 x ex seats, cut all seats. Reface head	credit for wrong hourly rate	-180.00	
cam credited on inv 3689			8 x valves @ cost	240.00	
Balance crank assembly	80.00		8 x valve guides @ cost	200.00	
Oil pump pipe unions etc	12.00	Head gasket	1 x set valves springs	120.00	
		Timing gear oil feed + banjo bolt	2 x tappet chest cover plates	78.00	
Crank seal (split) + cam seal	20.00	Various nuts and bolts (sump etc)	1 x set valve caps and collets	80.00	
		Rocker studs	1 x set pushrods	144.00	
Enviro: waste/cleaning			Total Materials	£1,479.50	
VAT No 733 6384 25				MATERIALS + LABOUR	£3,439.50
Bank Details HSBC Sort code 40-47-09 Acc no 61394282				VAT @ 20 %	£687.90
TERMS – 14 days from invoice date.				TOTAL INVOICE	£ 4,127.40