

BBE

BILLBUNE ENTERPRISES



PRICELIST



BORING

(Includes port chamfers & hone to finish size)	-	2 - CYCLE	4 - CYCLE
EACH CYLINDER (w/ customer piston)	each	\$80	\$80
EACH CYLINDER	each	\$75	\$75
V-FOURS (minimum)	each	\$100	\$100
OUTBOARD (Merc) (blind hole)	each	\$100	\$100
OUTBOARD (Johnson inline)	each	\$100	\$100
OUTBOARD (V-Four)	each	\$100	\$100
OUTBOARD (V-Six)	each	\$100	\$100
60 Degree (V-Six)	each	\$100	\$100
KOHLER, BRIGGS, etc.	each	\$80	\$80
HARLEY DAVIDSON	each	\$80	\$80
HARLEY Bore & Hone with torque plate	each		\$150
885 TO 1200 BIG BORE (w/ torque plates)	pair		\$350
OFFSET BORING	add	\$20	\$20
BLIND HOLE	add	\$20	\$20
TAPER OR CHOKE BORE	add	\$20	\$20
.010" to .030" (each cylinder)		\$75	\$75
.031" to .060" (each cylinder)		\$80	\$80
over .060"		\$85	\$85
Add'l cut of .040" or less		\$10	\$10



Mon - Fri (8:30am - 5:30pm)



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BILLBUNE ENTERPRISES

FOUR CYLINDER

DECK CYLINDER ONLY	-	\$175	\$175
INSTALL BIG BORE SLEEVES	-	\$400	\$400
INSTALL BIG BORE SLEEVES & DECK CYLINDER	-	\$575	\$575
BORE CASE FOR BIG SLEEVES		\$300	\$300
<i>LABOR ONLY (Prices will be quoted upon examination)</i>			

SLEEVING

Customers Parts Add \$50 (Head Studs & Manifolds must be removed)	-	-	-
SLEEVE & BORE STANDARD 2 CYCLE	-	\$250	-
SLEEVE WITH HEAVY WALL EXTRA	add	\$50	min.
SLEEVE CYLINDER WITH EXHAUST VALVES	add	\$50	min.
REMOVE & REPLACE EXHAUST COMPONENTS		\$50	min.
MATCH SLEEVE TO PORTED CYLINDER		\$150	min.
BIG BORE SLEEVE	add	\$50	min.
BORE CASE FOR BIG BORE SLEEVE		\$100	-
SLEEVE FOUR CYCLE (drop in sleeve)		\$200	-
SLEEVE FOUR CYCLE (cast in sleeve)		\$250	-
SLEEVE OUTBOARD (with ports cut)		\$300	min.
SLEEVE OUTBOARD (with no pre-cut ports)		\$400	-
SLEEVE KOHLER, BRIGGS, etc.		\$250	-
REPLATING CYLINDER	each	\$395	\$395
REPLATE & WELD	each	\$395	\$395
REMOVE & REPLACE VALVES 2 CYCLE	each	\$50	min.
REPLATE MONO BLOCK		\$650	
<i>Special Sleeves made to your specs, (prices will be quoted upon examination).</i>			



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HONING

HONE NIKASIL (Diamond)	each	\$50
DEGLAZE HONE	each	\$20
RIDGED HONE	each	\$30
RIDGED HONE LARGE KOHLER OR BRIGGS	each	\$30
HONE .001" TO .003" MATERIAL	each	\$50
HONE .003" TO .010" MATERIAL	each	\$75
EXTRA FINE 600 GRIT FINISH	each	add \$20
EXTRA FINE 400 GRIT FINISH	each	add \$20
CHEMICAL REMOVAL OF ALUMINUM FROM BORE		\$50
*STUD AND MANIFOLD REMOVAL	each	\$5
*GASKET REMOVAL PER CYLINDER		\$10
* Extra charge for gasket, stud & manifold removal		
* Rush charge \$50.00 minimum per cylinder		

PRICE LISTED ARE LABOR ONLY

CRANKSHAFT REBUILDING & TRUE

	-	2-CYCLE	4-CYCLE
1 CYLINDER CRANK	-	\$125	\$150
1 CYLINDER CRANK	heavy weight	\$150	\$175
*2 CYLINDER CRANK	-	\$300	\$300
*2 CYLINDER CRANK	heavy weight	\$350	\$350
**3 CYLINDER CRANK	light weight	\$400	\$400
**3 CYLINDER CRANK	heavy weight	\$450	\$450
***4 CYLINDER CRANK	-	\$600	\$600
***4 CYLINDER CRANK		\$600	
SUZUKI GT125, 150, 185, 250		\$300	
SUZUKI T500		\$350	
SUZUKI GT380 / GT550		\$400	
SUZUKI GT750		\$450	
HONDA CR'S WITH FACTORY STUFFER		\$175	



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CRANKSHAFT TRUING

	-	2-CYCLE	4-CYCLE
1 CYLINDER		\$50	\$50
2 CYLINDERS	min	\$100	\$100
2 CYLINDER TRUE & WELD (GOOD CRANK)	min	\$175	\$175
3 CYLINDERS	min	\$150	\$150
3 CYLINDER TRUE & WELD (GOOD CRANK)	min	\$200	\$200
4 CYLINDERS	-	\$200	\$200
4 CYLINDER TRUE & WELD (GOOD CRANK)		\$250	\$250

CRANKSHAFT WELDING

		2-CYCLE	4-CYCLE
1 CYLINDER		\$40	\$40
2 CYLINDER		\$75	\$75
3 CYLINDER		\$100	\$100
4 CYLINDER		\$150	\$150

* Extra charge for making one good crank from two or more bad cranks (minimum) \$40

* Extra charge for rebuilding previously welded crank (per weld) \$20

** R&R one complete crank journal or more same as complete rebuild

*** R&R on one crank (end) only (min + true) \$80



REINDEXING CRANKSHAFT

FOR REINDEXING OF CRANKSHAFT, ADD TO REBUILD CHARGE:			
	2 CYL/40.00	3 CYL/75.00	4 CYL/100.00
	CHECK INDEX	2 CYL/30.00	3 CYL/45.00
REMOVE SPUN OR SEIZED BEARING add 40.00 minimum			
PULL CLUTCH			\$40
PULL MAG. (FLYWHEEL)			\$40

ROD WORK

STRAIGHTEN RODS		each	\$40
SIZE RODS (per end)		each	\$40
BALANCE RODS (match weight)		each	\$40
700/800 POLARIS CRANK & CASE UPDATE Includes Bearings			\$175
<i>PRICE LISTED ARE LABOR ONLY</i>			

2-CYCLE HEAD WORK

MILL HEAD

1 CYLINDER	-	\$80
1 CYLINDER (OFFSET OR ANGLED PLUG)	min	\$100
2 CYLINDER SINGLE CASTING	min	\$125
3 CYLINDER SINGLE CASTING	min	\$150
*Add for removal of more than .030"	min	\$20
SURFACE ANY HEAD .001" OR LESS (per cyl)	each	\$40
MILL CYLINDER BASE (SINGLE)	min	\$90
MILL CYLINDER BASE (TWIN)	min	\$125
MILL CYLINDER BASE (TRIPLE)	min	\$175
DECK CYLINDER (SINGLE)	min	\$80
DECK CYLINDER WITH OFFSET PLUG (TWIN)	min	\$90
DECK CYLINDER SINGLE CASTING (3 & 4 CYL)	min	\$150
*Remove More than .020"	add	\$20
OPEN CHAMBER FOR BIG BORE	each	\$80
RECUT SQUISH BAND	min	\$80
RECUT DOME	each	\$90
WELD AND MACHINE NEW SQUISH BAND	min	\$175
MILL SINGLE HEAD AND RECUT SQUISH (One Setup)	each	\$175



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MILL TWIN & CUT 2 SQUISH (One Setup)	-	\$250
MILL TWIN & CUT 2 SQUISH (Two Setups)	-	\$300
MILL 3 CYLINDERS & CUT 3 SQUISH	-	\$350
POLISH COMBUSTION CHAMBER		\$50
CHECK CC VOLUME (per chamber)	(per hour)	\$100
SET cc VOLUME	(per hour)	\$100
ALL PRICES: MINIMUM		
<i>PRICE LISTED ARE LABOR ONLY</i>		



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4-CYCLE HEAD WORK

STANDARD VALVE JOBS

2 VALVES	-	\$150
4 VALVES	-	\$220
5 VALVES		\$250
6 VALVES		\$300
8 VALVES		\$350
16 VALVES		\$400
20 VALVES		\$450
24 VALVES		\$500
HARLEY DAVIDSON, BMW, ETC.	pair	\$300
BRIGGS & KOHLER		\$100
SET VALVE LASH / RE-SHIM	per hour	\$100
EXTRA CHARGE FOR DISASSEMBLY (ROCKERS/CAMS, E		

VALVES

GRIND VALVES ONLY	each	\$20
LIGHTEN AND POLISH	each	\$30
INSTALL OVERSIZE VALVE	each	\$50
BACK CUT VALVE	each	\$25



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GRIND VALVE SEAT 3 ANGLE	each	\$75
GRIND VALVE SEAT 1 ANGLE	each	\$50

GUIDES

SUZUKI GUIDES	add per guide	\$35
REMOVE AND REPLACE	each	\$25
MAKE OVERSIZE GUIDE	per hour	\$100
REAM GUIDES TO SIZE	each	\$25

HEAD WORK

MEASURE CHAMBERS cc VOLUME	per hour	\$100
ADJUST CHAMBER cc VOLUME	per hour	\$100

HEAD MILLING (SINGLE CASTING)

1 CYLINDER		\$125
2 CYLINDER		\$150
3 CYLINDER		\$175
4 CYLINDER		\$200
*Over .020" stock removal (addl)		\$20

*EXTRA CHARGE FOR DISASSEMBLY (ROCKERS/CAMS, ETC) ALL PRICES :
 MINIMUM PRICES LISTED ARE LABOR ONLY*

PORTING

TWO CYCLE

SINGLE CYLINDER	min	\$350
MONO BLOCK	min	\$600
TRIPLE CYLINDER	min	\$750
PORTING TO CUSTOMER SPECS	per cylinder	\$350
MATCH MANIFOLD ONLY	min each	\$75
POLISH EXHAUST ONLY	min each	\$75

4 - CYCLE

LABOR ONLY EACH CYLINDER	min	\$350
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BILLBUNE ENTERPRISES

PISTONS

DRILL FOR LUBE & COOLING	per hour	\$100
CERAMIC HEAT BARRIER	each	\$75
MOLY COAT	each	\$75
MOLY COAT AND HEAT BARRIER	each	\$100
GLASS BEAD AND DECARBON	each	\$40
CUT SKIRT	1-3 pistons	\$50/each
CUT BOOST PORT		\$100
MATCH PISTON WEIGHTS (MINIMUM)	each	\$50
LIGHTEN AND MATCH	each	\$50
DRILL FOR EXHAUST BRIDGE	each	\$50
GAS PORT	per hour	\$100
CUT OR RESHAPE DOME	per hour	\$100
RELIEVE FOR EXPANSION	per hour	\$100
OPEN PIN BOSSES	per hour	\$100

ENGINE LABOR/LOWER END

DIRTBIKE/ATV: 2-Cycle

	49cc - 125cc		\$600
	175cc - 500cc		\$700
	w/out Transmission		\$500-\$700

ALL 4-CYCLE

	Requires Quote		\$400-\$900
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SNOWMOBILE & WATERCRAFT

	TWINS	min	\$600
	TRIPLES	min	\$750
Top End 2-Cycle		per cyl	\$200
Top End 4-Cycle		per cyl	\$400

PROTECTIVE COATINGS

PISTON COATINGS

MOLY COAT (PISTON SKIRT)	each	\$75
THERMO BARRIER COAT (PISTON DOME)	each	\$75
MOLY & THERMO COAT	-	\$100
COAT USED PISTONS	add	\$25
THERMO COAT CHAMBERS	per hour	\$100
THERMO COAT VALVES	per hour	\$100

FORK TUBES

STRAIGHTEN FORK TUBE (DISASSEMBLED)	each	\$75
STRAIGHTEN FORK TUBE (ASSEMBLED OFF BIKE)	per hour	\$100
STRAIGHTEN FORK TUBE WITH KINK (ADD)	each	\$40
STRAIGHTEN TRIPLE TREE AND/OR STEERING STEM	per hour	\$100
STRAIGHTEN TOP CLAMP	per hour	\$100
STRAIGHTEN AXLE	-	\$75
CHECK FORK TUBE FOR STRAIGHT (ASSEMBLED)	-	\$40
INSTALL FORK SEALS (ONLY NO TRUING)	each	\$100
INSTALL FORK SEALS WITH TRUING	each	\$150

All prices minimum PRICES LISTED ARE LABOR ONLY

THREAD REPAIR

	-	2-CYCLE	4-CYCLE
SPARK PLUG 10 TO 18 mm	HELICOIL	\$75	\$75
SPARK PLUG 10 TO 18 mm	TIMESERT	\$75	\$75
ALL THREAD REPAIR (6-10 mm & 1/4 to 3/8 inch)	each		\$40

HELICOIL INSERTS

6 mm - 10 mm	\$5		
12 mm - 18 mm	\$5		
1/4 - 3/8	\$5		
7/16 - 9/16	\$5		

TIMESERTS

6 mm - 10 mm	\$5		
12 mm - 18 mm	\$5		
1/4 - 3/8	\$5		
7/16 - 9/16	\$5		
BIG SERTS	\$10		

FOR REMOVAL OF BROKEN STUDS SEE (CASE REPAIR) | PRICES LISTED ARE LABOR ONLY | All Prices are Minimum



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REMOVE BROKEN STUD (MINIMUM)

REMOVE BROKEN STUD (MINIMUM)	per hour	\$100
REMOVE BROKEN STUD REQUIRING WELDING (MINIMUM)	per hour	\$100
REMOVE BROKEN STUD W/ BROKEN DRILL BITS, ETC (WELDING EXTRA) MINIMUM	per hour	\$100
REMOVE AND REPLACE STUDS	each	\$5
REMOVE AND REPLACE HEAD STUDS, CHASE THREADS	each	\$10
REMOVE AND REPLACE CASE STUDS,	each	\$20
ADD COST OF NEW STUDS IF NECESSARY		
For repair of broken or cracked cases requiring welding or machining, bring in for examination and a quote.		
Cost of helicoils must be added (See thread repair)		
<i>All prices minimum</i> LABOR ONLY		



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Harley Davidson Engine Work

BORE CYLINDER	each	\$80
BORE & HONE CYL WITH TORQUE PLATE	each	\$150
SLEEVE BORE AND FINISH HONE	each	\$300
HONE CYLINDER (rigid hone)	each	\$40
HONE CYLINDER (deglaze)	each	\$25
STANDARD VALVE JOB	each head	\$150
GRIND SEAT ONLY (3 ANGLE)	each	\$75
REFACE VALVE	each	\$30
MODIFY GUIDES FOR OIL SEALS	per hour	\$100



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OTHER SERVICES

CARBURETOR BORING	Disassembled	\$80
CARBURETOR BORING	Assembled + Sonic Clean Carbs	\$150
	Disassembled	\$100
ATC AXEL STRAIGHTENING	Minimum	\$100
CLUTCH TRUING	Disassembled	\$150
BALANCE PRIMARY CLUTCH	-	\$75
BALANCE SECONDARY CLUTCH	-	\$75
TRUE & BALANCE CLUTCH	-	\$300
DISASSEMBLE PRIMARY	-	\$75
DISASSEMBLY SECONDARY	-	\$75
PULL CLUTCH OR MAG	Minimum	\$40
CLUTCH REBUILDING	Minimum	\$250
CHARGE SHOCK	-	\$40
TRUE DRIVERS	4 Wheels	\$150
TRUE DRIVERS	2 Wheels	\$125
MACHINE HEAD FOR DUAL PLUGS	per hour	\$100
PROP SHAFT STRAIGHTENING	Minimum	\$75
R & R DRIVERS (2) SNOWMOBILE	-	\$80
R & R DRIVERS (4)	-	\$100



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HELI-ARC WELDING

ALUMINUM
MAGNESIUM
STAINLESS STEEL
CHROMOLY STEEL
MILD STEEL
SILVER SOLDERING
WIRE FEED WELDING

MACHINE SHOP SERVICES - \$100.00/HR

MILLING - LATHE - DRILLING - BORING - PRESS WORK
BENDING - STRAIGHTENING - METAL SAWING & CUTTING



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