

Table 1

LUMSDEN 100S engine	LABOR		PARTS			
	disassemble 2 engines, first block was cracked	\$800.00	2 motor mounts	\$30.00		
	unpack & check parts (distributor was wrong)		2 transmission mounts	\$20.00		
	mock assemble block/head/manifolds		2 XKE exhaust mounts	\$12.00		
	install in chassis for modifications	\$800.00	5 Healey monts	\$17.50		
	make custom exhaust, modify chassis to		BJ8 hangers and bolts	\$40.00		
	fit the larger pipes	\$800.00	2 used BJ8 intermediate pipes	\$40.00		
	make throttle cross link (left hand drive)		2 1 3/4" mufflers	\$80.00		
	make carb fuel system (see fuel page)		2 flex sections	\$50.00		
	disassemble all	\$600.00	nylon throttle bushings	\$12.00		
	grind, file drill new parts to fit	\$400.00	100-4 flex fuel line	\$42.00		
	find parts for fuel,oil, carbs, linkage, choke,		brass fittings	\$20.00		
	generator and mounts	\$600.00	miscellaneous pipe plugs	\$30.00		
	make generator moon and adjuster, modify		supply small generator - exchange	N/C		
	front engine plate, make side cover breather		BSF hardware	\$250.00		
	work on distributor stand	\$800.00	1969 XKE pressure plate	\$270.00		
	make 100S valve cover	\$800.00	1969 XKE clutch disc	\$125.00		
	gap rings, assemble pistons and rods		BJ8 release bearing	\$90.00		
	plastic gauge and assemble short block	\$800.00	pair HD8 Jaguar carbs used	\$400.00		
	assemble engine	\$1100.00	6 cylinder balancer used	\$220.00		
	clean, prep and paint engine & accessories	\$800.00	rebuilt OE water pump upcharge	\$190.00		
	assemble head studs and torque	\$200.00	.030 main bearings	\$65.00		
	assemble rocker shaft, refinish rockers make alignment bolt, assemble lifters, pushrods, set valves, side cover, modify & install distributor drive	\$800.00	.020 rod bearings	\$70.00		
	assemble ancillaries, distributor, generator, fan belt, water tube and bracket	\$800.00	88mm forged pistons - Denis Welch	\$650.00		

			custom push rods	\$170.00		
	make dipstick tube 100S style, TDC pointer prep for paint	\$600.00	custom made connecting rods	\$1,840.00		
	paint dipstick tube set up	\$40.00	conversion set	\$45.00		
			new steel oil pan	\$550.00		
	MACHINE SHOP WORK		new oil pump	\$400.00		
	strip & clean block	\$110.00	oil pump tach drive by Denis Welch	\$815.00		
	wash all tin; intake manifold, flywheel, harmonic damper, connecting rods, crank shaft & fasteners & brackets	\$125.00	oil temp gauge & fitting for pan	\$210.00		
	clean & jet wash cylinder head	\$35.00	timing chain	\$55.00		
	pressure test inline block, 1st block created,2nd block OK, test block after freeze plugs installed	\$325.00	cam lock tab	\$5.00		
	tap for threaded oil & coolant galley plus	\$115.00	front cover modified for seal	\$75.00		
	install cam bearings, freeze plugs & galley plugs	\$110.00	custom gaskets	\$200.00		
	align hone block	\$230.00	front seal	\$6.50		
	bore & hone block	\$185.00	cam bearings	\$60.00		
	deck inline 4 cylinder	\$150.00	8 quarts oil	\$32.00		
	hone lifter bore for clean up	\$80.00	oil filter	\$11.00		
	check crankshaft for size	\$45.00	spin on oil filter adaptor	\$60.00		
	check crankshaft for straightness	\$38.00	oil pressure relief valve	\$13.00		
	magnaflux crankshaft	\$95.00	cam & lifters DW	\$702.00		
	grind crankshaft	\$170.00	cylinder head DW	\$4,910.00		
	align rear crank seal & install dowel pins	\$130.00	rocker shaft DW	\$250.00		
	install new valve guides - supply valve spring shims	\$155.00	rocker stand kit DW	\$90.00		
	size valve guides	\$95.00	head studs & nut	\$115.00		
	regular valve job	\$130.00	distributor Welch clockwise	\$535.00		
	surfaace head	\$75.00	distributor drive stand DW	\$750.00		

	R&R ring gear and weld	\$80.00	water rail DW	\$2,709.00		
	drill, tap & plug all coolant and head bolt holesm- relocate head bolt holes & coolant holes (convert 100-4 to 100S block) mill side for generator bracket, drill & tap holes	\$3000.00	balance tube DW	\$205.00		
	balance inline 4 cylinder	\$325.00	headers DW	\$1,920.00		
			stud kit DW	\$157.00		
			intake manifolds DW	\$830.00		
			side cover DW	\$40.00		
			pilot bush	\$4.00		
			oil flex line	\$22.00		
			light flywheel DW	\$450.00		
			ring gear	\$50.00		
			water tube DW	\$150.00		
			plastic fan blade DW	\$65.00		
			fan belt	\$20.00		
			water pump pulley DW	\$125.00		
			bendy dip stick (due to headers)	\$30.00		
			overhaul generator supply pulley	\$240.00		
			100S Head Gasket DW	\$275.00		
			100S Manifold to head gasket DW	\$32.00		
			steel rocker pedestal & spacer set DW	\$210.00		
			freight & customs Welch order	\$890.00		
		\$16543.00		\$23,047.00		
			ENGINE TOTAL — \$39,590.00			