



# The Block Shop Engine Specialists, Ltd.

14730 - 118 Ave, Edmonton AB, T5L 2M8

Phone: (780) 452-8440

Website: [www.tbsengines.com](http://www.tbsengines.com) Email: [tbsengines@telus.net](mailto:tbsengines@telus.net)

CUSTOMER		VEHICLE			WORK ORDER ADMIN.		
The Block Shop / Crate Engines		0 Chev	Short Block		WO #	: 22370	
		Plate :			Date	: 03/25/2025	
		ODO :			Time	:	
		V.I.N.:			PO #	:	
		Unit #:			REG #	:	
B#:	H#:	Engine:	565 Cid		Tech.:	TEMP/ROB	
Qty	Hrs.	Description	Parts Ea.	Tot.Parts	Labour	Tx Total	C
		Chev 565 cid Short Block Build				GST	
		-----				GST	
		4.600 Bore x 4.250 Stroke				GST	
		6.800 Rod Length				GST	
		1.270 Comp Height /.990 Pin				GST	
		47.1cc Dome 2618 Material				GST	
		PTWC .0065 Min / .0069 Max				GST	
		Ring Pack .043 .043 3.0mm				GST	
		113cc Combustion Chamber				GST	
		.005cc Piston Below Deck				GST	
		.041 Gasket Thickness				GST	
		4.640 Gasket Bore Diameter				GST	
		.260 Piston Ring Depth				GST	
		4.560 Piston Top OD @ Ringland				GST	
		10.200 Deck Height				GST	
		<b>15.5:1cr Compression Ratio</b>				<b>GST</b>	
		-----				GST	
		2.125 + 6.800 + 1.270 = 10.195				GST	
		<b>10.195 Rotating Deck Height</b>				<b>GST</b>	
		-----				GST	
		<b>Engine Parts List</b>				<b>GST</b>	
1.00		31223654 Dart Big M Sportsman	5,725.00	5,725.00		GST	5,725.00
		Chev Big Iron Block 4.600 Bore				GST	
		10.200 Deck Height				GST	
1.00		445442526385 Eagle Forged	1,615.00	1,615.00		GST	1,615.00
		4340 Steel Crankshaft Center				GST	
		Counter Weights				GST	

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<b>Sub Tot.</b>	<b>14,357.42</b>	<b>4,601.98</b>	<b>18,959.40</b>
		<b>GST</b>	<b>947.97</b>
		<b>PST</b>	<b>0.00</b>
		<b>Deductible</b>	<b>0.00</b>
		<b>Total</b>	<b>19,907.37</b>
		<b>Amt. Paid</b>	<b>0.00</b>
		<b>Amt. Owing</b>	<b>19,907.37</b>

IN \_\_\_\_\_  
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1.00		CRS68003D2000 Eagle 4340	1,055.00	1,055.00		GST	1,055.00	
		Steel H Beam 6.800 ARP 2000				GST		
		Fasteners				GST		
1.00		930239300 Mahle PowerPak	1,410.00	1,410.00		GST	1,410.00	
		Forged Piston Kit 4.600 Bore				GST		
1.00		4605SS-043 Mahle Performance	340.00	340.00		GST	340.00	
		Series 4.600 Bore Plus .005				GST		
		File Fit Rings				GST		
8.00		CB743HXN Clevite H Rod Brgs	24.98	199.84		GST	199.84	
1.00		MS829H Clevite H Main brgs	188.98	188.98		GST	188.98	
1.00		32000022 Dart Block Kits	234.18	234.18		GST	234.18	
		Plugs,Fittings, Cam Brgs				GST		
1.00		Oil Pump				GST		
1.00		11-747-14 Comp Mech Roller	904.46	904.46		GST	904.46	
		Camshaft (Drag Race)				GST		
		Duration @ .050 286/296				GST		
		Valve Lift .748/.748 LSA 112				GST		
		4 & 7 Swap Firing Order				GST		
		5000 to 8500				GST		
		.026 IN / .028 EX Hot Lash				GST		
1.00		96819B-16 Comp Lifters	1,650.00	1,650.00		GST	1,650.00	
		Bronze Bushing Axle				GST		
1.00		2703 Race Set	72.75	72.75		GST	72.75	
2.00		17049 Felpro Head Gaskets	115.59	231.18		GST	231.18	
		4.630 Bore .039				GST		
1.00		3110KT Comp Billet Roller	360.00	360.00		GST	360.00	
		Timing Set (Hex Adjust)				GST		

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1.00		235-4113 ARP Head Studs	338.35	338.35		GST	338.35	
1.00		FKC-3HP Finishing Kit	32.68	32.68		GST	32.68	
-----								
<b>New Dart Block Work</b>								
1.00	0.50	Retorque & Measure Mainline (OK)			60.00	GST	60.00	
1.00		CNC Surface & Equelize Deck Heights			325.00	GST	325.00	
1.00		CNC Bore & Torque Plate Hone			525.00	GST	525.00	
1.00	1.50	Chamfer lower cylinder bores & Debur block			180.00	GST	180.00	
1.00	2.00	Hone Lifter Bores .002 Oil clearance			240.00	GST	240.00	
1.00	0.50	Final wash Block			60.00	GST	60.00	
1.00	1.00	Install Cam brgs & Fit Camshaft			120.00	GST	120.00	
1.00	0.50	Install Frost Plugs & Oil Gallerys			60.00	GST	60.00	
-----								
<b>Crankshaft Work</b>								
1.00	0.25	Jet wash & Clean			30.00	GST	30.00	
1.00	0.50	Measure, inspect & Check for Straight			60.00	GST	60.00	
1.00	1.00	Micro Polish Crankshaft			120.00	GST	120.00	
-----								
<b>Connecting Rod Work</b>								
8.00	1.00	Retorque & Measure Big End of			120.00	GST	120.00	

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		Con Rods (OK)				GST		
8.00	1.00	Hone Pin Bushings for .001			120.00	GST	120.00	
		Pin Clearance & Final Wash				GST		
		-----				GST		
		<b>Piston Work</b>				<b>GST</b>		
8.00	0.35	Measure & Inspect Pistons			42.00	GST	42.00	
8.00	1.00	Hone Pistons Pin Bore for			120.00	GST	120.00	
		.001 Pin Clearance & Final				GST		
		wash				GST		
8.00	1.00	Install Pistons on Con Rods			120.00	GST	120.00	
		-----				GST		
		<b>Balance Work</b>				<b>GST</b>		
1.00	5.00	Race Balance Rotating Assembly			600.00	GST	600.00	
		-----				GST		
		<b>Assembly Work</b>				<b>GST</b>		
1.00	3.00	File Fit Rings			360.00	GST	360.00	
1.00	8.00	Assembly Chev 565 cid Short			960.00	GST	960.00	
		Block Engine. Measure &				GST		
		Record all Clearances				GST		
		Shop Supplies			379.98	GST	379.98	

WO# 22370

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**PTWC .0065**  
**File Fit Rings .023 Top Rings / .028 Second Rings**  
**Main Torque 100 ft/lbs with CMD#3**

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(Main Brgs Clearance .0028) MS-829H Clevite  
Crankshaft End Play .006

Connecting Rod Fasteners 75 ft/lbs with ARP Moly (Stretch .0064-.0068) 7/16 1.800 Length ARP 2000 Cap Screw  
Rod Brg Clearance .0032 (CB743HNX)

PAID BY:...

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