



D.A.R.T INTERNATIONAL



6116 Davies Road, Edmonton, Alberta, Canada T6E 4M9
Phone: (780) 485-0619 * Cell: (780) 903-4780 * Fax: (780) 466-7300

YEAR	ENGINE SIZE	MAKE	MODEL	VIN CODE
1985	302 FORD			

PARTS	PART NUMBERS	PRICE	
PISTONS	KEITH BLACK 115 .030	425-	
RINGS	SEALED POWER MOLY	100-	
ROD BEARINGS	CB 634 P .010	80-	
MAIN BEARINGS	MS 540 P .010	100-	
CAM BEARINGS	CL77-5105	45-	
CAM SHAFT	COMP XE 262 H-10	180-	
LIFTERS	COMP 947-16 LIFTERS	120-	
TIMING SET	SA GRAR TRUR ROLLER	45-	
OIL PUMP	M77 HV	85-	
OIL PUMP SHAFT	ARP	15-	
OIL PUMP PICK-UP	MELLING	40-	
PUSH RODS	COMP 7634-16	100-	
ROCKER ARMS	CRANE 44746-16 ROLLER 1.7	300-	*
AUX. BEARINGS	CARB SPACER 1"	25-	*
PIN BUSHINGS	GM 1 WIRE CHROME ALT	175-	*
ROD BOLTS	ARP 743-7014	60-	
FROST KIT	PIONEER 302	20-	
CYLINDER HEADS	FORD EFI "T" HEAD	200-	*
GASKET SET	MR. GASKET	60-	
INTAKE PAN	CUSTOM PULLEY SYSTEM + TENSIONER	100-	*
HEAD BOLTS	ALT BELT	20-	*
VALVES	TAYLOR PLUG WIRING + LOOM	150-	*
VALVE SPRINGS	COMP GT 40	80-	*
VALVE SEALS	AUTO LINK DIST	100-	*
RETAINERS	PERTRONICS CDE + COIL	140-	*
KEEPERS	② OIL CAPS	20-	*
MISC.	PCV VALVE	5-	*
MISC.	FUEL LINK + HOSE FITTINGS	50-	*
MISC.	60 15W40 ROTELLA "T"	30-	*
MISC.	GM EOS	10-	*
MISC.	ENGINE PAINT	50-	
TOTAL PARTS PRICE	302 ENGINE BLOCK	300	*

* 1725. NOT IN
ORIGINAL QUOTE

TOTAL 6268.50

part 4000.00
Jan 9109

3230 - PARTS
2740 - LABOUR
5970 -
298.50 GST



D.A.R.T. INTERNATIONAL



6116 Davies Road, Edmonton, Alberta, Canada T6E 4M9
Phone: (780) 485-0619 * Cell: (780) 903-4780 * Fax: (780) 466-7300

Page 2

LABOUR	PRICE
HOT TANK CLEAN & MAG. PARTS (2 BLOCKS 4 HEADS)	200 -
BORE & HONE BLOCK	200 -
TORQUE PLATE BLOCK	120 -
GRIND CRANKSHAFT	100 -
REBUILD CYLINDER HEADS	150 -
RE-SIZE CON RODS	100 -
INSTALL ROD BOLTS	
INSTALL & PIN FIT ROD BUSHINGS	
INSTALL PISTONS ON RODS	50
INSTALL CAM BEARINGS & FROST KIT	75 -
INSTALL AUX. SHAFT BEARINGS	
ALIGN BORE BLOCK	
BALANCE ENGINE ASSEMBLY	350 -
CLEARANCE ROTATING ASSEMBLY	
DECK ENGINE BLOCK	120 -
FILE FIT RINGS	75 -
ASSEMBLE ENGINE + R+R	1200 -
INSTALL VALVE SEATS	
REMOVE BROKEN BOLTS AND HELI COIL	2740 -
MISC.	
MISC.	
MISC.	
MISC.	
MISC.	
TOTAL LABOUR PRICE	

TOTAL PARTS AND LABOUR COST	
-----------------------------	--

ADDITIONAL COMMENTS

D.A.R.T INTERNATIONAL

6116 Davies Road, Edmonton, Alberta, Canada T6E 4M9
Phone: (780) 485-0619 * Cell: (780) 903-4780 * Fax: (780) 466-7300

Work Order No. _____
Customer _____
Engine _____
Date _____
Machinist _____

BLUE-PRINT SHEET

BLOCK:

Bore Oversize 4.030 Bore Finish EX FINE MOLY
Piston Clearance .002 Piston No. ALL
Full Float ☐ Press Fit ☒
Ring Type & No. moly End Gap Top: .035 .035
Oil Ring Tension: STD ☒ Low ☐ Ultra ☐ 2nd: .040

CRANK:

Mains .010 Throws .010 Cast ☒ Steel ☐
Rod Clearance Main Clearance
1 .002 2 .002 3 .002 4 .002 1 .003 2 .003 3 .003
5 .002 6 .002 7 .002 8 .002 4 .003 5 .004 6 _____
Side Clearance .020 Thrust .008

CAM AND SPRINGS

Manufacturer No. _____ Lift Intake _____ Exhaust _____
Cam Type _____ Duration at .050 _____
Spring Type & No. _____ Assembled Pressure: Open _____ Closed _____
Installed Height _____ Installed at _____ ° Lash: Intake _____ Exhaust _____
Deck Height
1 _____ 2 _____ 3 _____ 4 _____
5 _____ 6 _____ 7 _____ 8 _____

HEADS:

Valve Diameter: Intake 1.90 Exhaust 1.50 Head Casting No. "T"
Amount Machined Off Deck .020 Amount Machined Off Head(s) 0
Head Gasket Thickness .059 Valve to Piston Clearance: Intake .250 Exhaust .250
Oil Pressure at Time of Test 70 Lbs.

Assembled By: _____

COMMENTS

HEAD 64cc CR 10.83/1
GASK 10 cc
PIST 10 cc
SWEEP 629cc