

# Machine Shop Service

## Turning Expensive Repair Problems Into Economical Repair Solutions

1  
Clothing  
Helmets  
Gloves  
Mitts

### Cylinder Boring

We bore and finish hone worn cylinders to exact clearances, chamfer ports, and relieve exhaust bridges where necessary. Remove all cylinder studs and gaskets before shipping.

2  
Accessories  
Grips  
Skidplates

### Crankshaft Rebuilding

We specialize in rebuilding cranks. Include cases when sending in your crank. The price is for labour only, parts are extra.

3  
Electrical  
Plugs  
Batteries  
CDI's

### Resleeving of Cylinder or Cylinder Block

We do ATV's, commercial, marine, motorcycle and snowmobile engines. This includes matching the sleeves exactly in gasket areas and ports will be matched and angled perfectly.

4  
Belts  
Chains  
Clutches  
Sprockets

### Engine Rebuilding

We specialize in rebuilding complete engines. Most engines when used for a couple of years should have the cranks checked, seals and gaskets installed, and pistons checked. We charge \$42.00 per hour. Parts are extra. PRICE QUOTES are available upon request.

### Shipping Instructions

Follow the instructions to make sure the engine parts are shipped to Sun & Snow Enterprises Ltd. with no shipping damage.

5  
Tracks  
&  
Rear  
Suspension

1. Use two heavy boxes (large box and small box) for *each cylinder*. Wrap cylinder(s) using plenty of packing in one box. Place this box into a larger box with additional packing between the boxes. **NOTE:** Fins on cylinders are easily broken during shipment unless the package is wrapped with great care.
2. Send the package by Purocollect, insured mail, or bus. These are the best methods. Use the courier services if they provide good service for your needs.
3. Provide instructions regarding work to be done with the box. Place the instructions in a visible place inside or outside the box. Please tell us so we know what needs to be done.
4. Cylinder or cylinder blocks; Send us your pistons, for best clearance adjustment. Send without rings if not supplied by us. Please advise if a specific clearance is required.

6  
Brakes  
&  
Cables

### Boring of Cylinder or Cylinder Block (E)

7  
Carburetion  
Filters  
Gas Caps  
Fuel Pumps

Job No.	Boring of Cylinder or Cylinder Block	Suggested Retail Price
SS-028	All models with cylinder and cylinder head in one piece (example: Yamaha Bravo or Rotax 277, etc.)	\$58.00
SS-029	All other diameters - .001" to .040" * - 2 cycle engines	\$42.00
SS-030	- .041" and up * - 2 cycle engines	\$48.00
SS-031	All other cast iron or aluminium cylinders - 4 cycle engines (example: Briggs & Stratton, Tecumseh, Kohler, etc.)	\$45.00

8  
Windshields

\* Includes chamfering ports and cleaning up.

9  
Steering  
&  
Skis

### Resleeving of Cylinder or Cylinder Block

10  
Rewind  
Starters

Job No.	Sleeve Installation Labour Only (Sleeve Extra)	Suggested Retail Price
SS-032	Fit exhaust valve, (i.e. Suzuki), 2 cycle	\$18.00
SS-033	* Sleeve cylinder 5-9 ports	\$130.00
SS-034	* Sleeve 2 cycle cylinder 10+ ports & blind hole	\$140.00
SS-035	Replacement Sleeves which do not require boring of cylinder to install sleeve	\$68.00
SS-036	Most 4 cycle Sleeves such as Briggs & Stratton, Kohler, Tecumseh, and some motorcycles and ATV cylinders	\$105.00
SS-039	Charge added to remove head studs or other parts. <b>We do not assume responsibility for damages incurred from removing such parts.</b>	\$20.00

11  
Traction

\* Includes professional installation of sleeve, bead blasting of cylinder where applicable, boring cylinder to match piston, chamfer all ports and relieve exhaust bridge.

12  
Tools  
&  
Oil

13  
Exhaust  
Reeds

14  
Engine  
Components

# Machine Shop Service (E)

## Pinned Crankshaft Service

We can repair most pinned crankshafts that we can purchase parts for. The labour to dismantle, inspect, replace needed parts, reassemble and align crankshaft is as follows:

<u>Job No.</u>	<u>Crankshaft Type and Application</u>	<u>Suggested Retail Price</u>
SS-132	Single Crankshaft	\$ 48.00
SS-133	Twin Crankshaft	\$110.00
SS-134	Triple Crankshaft - up to 580 cc	\$175.00
SS-136	Triple Crankshaft - 600 cc and over	\$195.00
SS-135	Minor Repairs such as: changing outer bearings, etc.	\$48.00
SS-102	Assembling of Crankshaft in Crankcase	\$48.00
	<b>IMPORTANT:</b> The following parts are requested for the assembling: crankcases, crankshafts, screws, washers, lockwashers, nuts and seals.	
SS-103	Assembling of Short Block	\$ 120.00
	<b>IMPORTANT:</b> The following parts are requested for the assembling: crankcases, crankshafts, screws, cylinders, lockwashers, nuts, seals, cylinder heads, pistons with rings, wrist pin bearings, piston pins, gaskets, intake and exhaust manifolds.	

## Cylinder Block - Marine

<u>Job No.</u>	<u>Boring of Cylinder - all makes and models (V-Engines included)</u>	<u>Suggested Retail Price (per hole)</u>
SS-124	Bore cylinder block through hole	\$48.00
SS-125	Bore cylinder block, blind hole	\$58.00

NOTE: The above prices are per cylinder.

## Resleeving of Cylinder or Cylinder Block - Marine

<u>Job No.</u>	<u>Cylinder Sleevng</u>	<u>Suggested Retail Price</u>
SS-128	1, 2 cylinder block	\$140.00
SS-129	3, 4, 6 cylinder block	\$140.00
SS-130	V-4 cylinder block	\$140.00
SS-131	V-6 cylinder block	\$160.00

NOTE: The above prices are per cylinder. Sleeve is extra.

NOTE: A charge of \$63.00 NET will be added for cutting ports in a blank sleeve.

## Shock Repair

<u>MSL No.</u>	<u>Shock Repair</u>	<u>Suggested Retail Price</u>
	Front forks (motorcycle)	\$60.00/hr plus oil + parts
SHOCK-1	Rear shock complete rebuild, ATV, motorcycle: includes oil and nitrogen but no other parts	\$80.00 + parts
SHOCK-OIL	Change oil - includes oil and nitrogen. (i.e. rear ATV, motorcycle Fox shocks)	\$48.00
SHOCK-FOX	Rebuild Fox shocks - complete rebuild	\$70.00 + parts

## Thread Repair

<u>Job No.</u>	<u>Thread Repair</u>	<u>Suggested Retail Price</u>
SS-104	Install Heli coil	\$12.00



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Mitts

2  
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CDI's

4  
Belts  
Chains  
Clutches  
Sprockets

5  
Tracks  
&  
Rear  
Suspension

6  
Brakes  
&  
Cables

7  
Carburetion  
Filters  
Gas Caps  
Fuel Pumps

8  
Windshields

9  
Steering  
&  
Skis

10  
Rewind  
Starters

11  
Traction

12  
Tools  
&  
Oil

13  
Exhaust  
Reeds

14  
Engine  
Components