

14 December 2008

It is hard to believe that 2008 is coming to a close. To all of my current customers, I would like to personally thank you for being so patient and understanding. I realize that it is difficult but believe me when I say "the engine you will finally receive will be better than the one you ordered"! This is to say, there have been some significant changes that were not foreseeable in the original design and were not evident until I had accumulated several hours of running on the engine. If you have been following my weekly updates, then you are very familiar with the numerous changes and modifications.

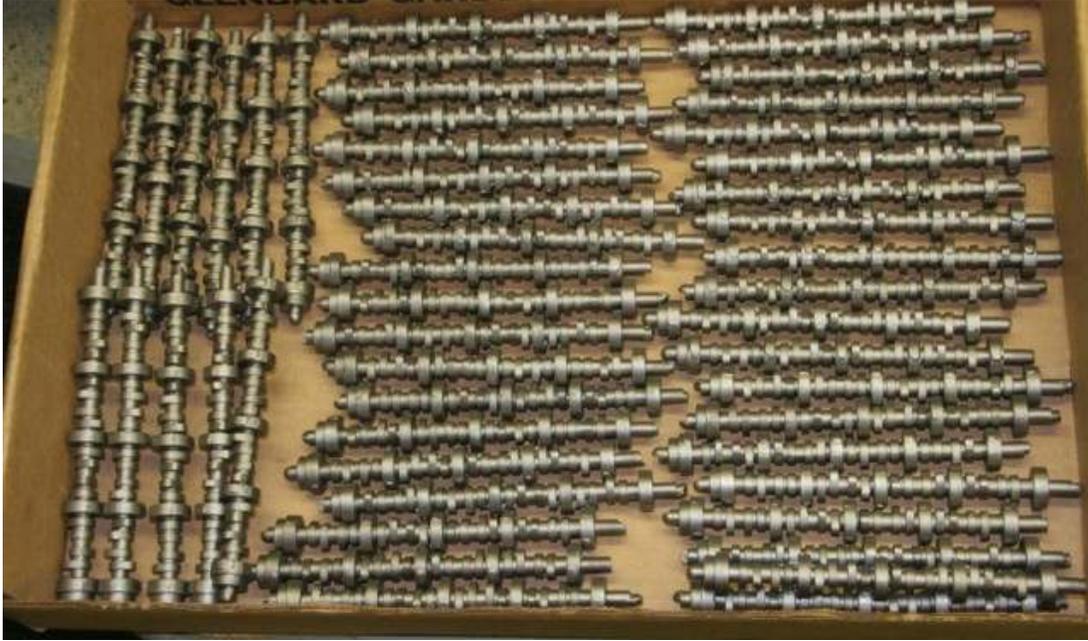
The delivery of cast camshafts just arrived! (Picture #1) It is nice to have them in stock and the initial machining process has already started. By the end of next week they will be sent to heat treat. This procedure normally takes about three days and will harden the camshafts to about a 60 Rockwell, which is about as hard as a shop file. Once returned, the final grinding process can begin.

Picture #2 shows the before and after shots of the right cylinder bank. Once again, this is a very critical process. The placement of the cylinder bores must be exact. If it is off by only .010 then when rotated the opposite bank of cylinders is off by .010 for a total .020. If this were to happen then the rod placement on the crankshaft would not be in the exact location. This also applies to the camshaft lobe centers. If they are off, then the camshaft lobes would not be aligned with the lifters. Also, because the engine is a 90 degree V, if the deck height is not correct then the intake manifold will not be in the exact position. Just the thickness of the gaskets will make a big difference. The machining process for each bank of cylinders take about 24 minutes. If you look closely you can see the lifter holes, oil return holes, and cylinder placement holes. All of the head bolt holes are also drilled and tapped during this operation.

On a completely different note, I would like to say to anyone who is contemplating the purchase of an engine, the base price will be going up in the not too distant future. I have held the original price of \$5,295.00 for almost three years. For all of you who have placed a deposit on an engine the price will remain the same as will any options that you may want on your engine. At the present time delivery is running about one year and a deposit is required to get your name in "Q". Just something to think about!

I would personally like to wish everyone a wonderful holiday season and a great New Year!

Picture #1



Picture #2



Picture #3

