

Invoice #	Date
82224	6/30/2022

Bill To
Paul Phillips 70 Valdez Avenue San Francisco CA 94112



**153 Pennsylvania Avenue  
Malvern, PA 19355  
610-970-7800**

Year	Make	Model	Vin #	Mileage	
1970 (series 2)	Jaguar	XKE	TR13486	76,031	
Description			Qty	Cost	Amount
Continue from Inv.82204 Rear caliper repair. Removed road wheels and rear section of exhaust. Removed parking brake linkage, driveshaft and brake line. Removed rear lower control arm bolts and rear subframe mounting bolts. Removed rear axle/subframe assembly from vehicle. Removed rear steel brake lines, parking brake assembly and caliper safety wire and bolts. Removed rear calipers and prepared for shipping Noted new caliper / piston cross over lines obstructing bolt holes Changed bends in caliper lines to allow bolts to be installed Installed LR & RR calipers Installed parking brake bolts and plate Bent plate fingers over bolts Installed new rear brake pads Installed safety wires on rear caliper bolts Cleaned out metal brake lines 3 way union Installed rear metal brake lines Installed parking brake clevis pins and 2 new cotter pins Installed rear axle/subframe assembly into vehicle Installed rear subframe mounting bolts Installed rear driveshaft Installed parking brake cable  Drilled safety wire holes in 2 new rear lower arm bolts Chased threads in body Installed rear lower arm bolts and set torque to 46 ftlbs. Installed 4 lower bracket bolts Safety wired lower arm bolts Installed rear rubber brake hose Installed front rubber brake hoses					

<b>Subtotal</b>
<b>Sales Tax (6.0%)</b>
<b>Payments/Credits</b>
<b>Balance Due</b>

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1970 (series 2)	Jaguar	XKE	TR13486	76,031	
Description			Qty	Cost	Amount
Bled brake system - used 2 pts of brake fluid Installed exhaust Installed road wheels  Installed tachometer and tested Found tachometer operating as normal Removed distributor to inspect wobble Found burr on end on oil pump Cleaned off burr and installed distributor Found wobble not present Set ignition timing to 10 degrees BTDC Set idle speed and sync carburetors Installed choke cables Removed clutch master cylinder Replaced clutch master cylinder and installed 1 new cotter pin Found engine no longer dieseling Found clutch return spring broken Rec replace clutch pedal return spring Rewired tachometer Removed clutch slave cylinder Bead blasted slave hardware Cleaned and chased rigid metal line Installed clutch slave Bleed clutch slave using 1 pint of dot 3-4 brake fluid Adjusted clutch pushrod Found clutch frozen on flywheel Installed air cleaned assembly Replaced 2 vacuum lines					

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1970 (series 2)	Jaguar	XKE	TR13486	76,031	
Description			Qty	Cost	Amount
<p>* Noted clutch disc seized on pressure plate Attempted to free disc from pressure plate Found disc unable to break free</p> <p>Removed engine and transmission assembly to access clutch disc Found shifter knob seized on shifter Additional time required to remove knob Found exhaust welds interfering with downpipe nuts Additional time required to remove exhaust manifold nuts Found engine mounts tore during removal</p> <p>Rec replace motor and transmission mounts, oil filter and seal, torsion bar bolts, resurface flywheel, exhaust manifold gaskets, bonnet nylon bushings@pivot point,oil breather hose.</p> <p>Installed resurfaced flywheel Installed 2 new dowel pins for 10" pressure plate (original 9.5") Installed 6 new bolts and split washers Installed new clutch disc, pressure plate and throwout bearing Installed transmission on engine Installed engine and transmission in vehicle Installed radiator, driveshaft, throttle linkage, transmission wiring, rewired dist with bullet connectors for removal, front balancer pulley.</p>					

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Year	Make	Model	Vin #	Mileage	
1970 (series 2)	Jaguar	XKE	TR13486	76,031	
Description			Qty	Cost	Amount
Installed 3 motor mounts Installed 1 transmission mount Installed dash pad Installed drivers seat (note: seat track broken REC replace seat track) Installed bonnet Chased exhaust manifold studs and installed exhaust Installed front torsion bars to bracket Found heater wiring cut. Rec diag and repair wiring Repaired radio wiring Installed wiring harness to brake lamp light Found lamp illuminated Performed diag of brake lamp Found handbrake switch broken and taped together under carpet Disconnected broken handbrake switch and tested system found operational Rec replace handbrake switch and rewire Installed console Found shift boot leather torn and new boot in vehicle Installed new shift boot leather Mount & balance tires on new wheels. Run engine up to temp and burp cooling system as needed. Check for proper clutch operation. Add 2.5 gal. fuel for minor road test.					
Rear brake calipers rebuilt			2	185.00	370.00T
New crossover line			2	65.00	130.00T
Broken bleeder repair			1	15.25	15.25T

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Year	Make	Model	Vin #	Mileage	
1970 (series 2)	Jaguar	XKE	TR13486	76,031	
Description			Qty	Cost	Amount
Brake fluid			2	11.94	23.88T
Brake pad set			1	24.99	24.99T
Brake pad set			1	35.99	35.99T
Master cylinder clutch			1	44.99	44.99T
Slave cylinder			1	39.99	39.99T
Pedal box kit			1	58.99	58.99T
Chrome wire wheels			4	459.00	1,836.00T
205/70R-15 Vredestein Sprint Classic SL			4	268.00	1,072.00T
Clutch kit			1	364.25	364.25T
Motor Mount			1	79.15	79.15T
Engine stabilizer bushing			1	17.95	17.95T
Kit stud and nut			1	26.35	26.35T
Gasket exhaust manifold			2	4.62	9.24T
Hose sump to filter			1	7.45	7.45T
Bush hinge bonnet			4	2.45	9.80T
Gearbox bushings			1	3.95	3.95T
Transmission spring seat			2	5.45	10.90T
Freight & Insurance				153.97	153.97T
Shop Labor / Road			59.06	179.00	10,571.74T
Shop Labor			5.74	179.00	1,027.46T

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**Thank you for the opportunity to serve you.**

<b>Subtotal</b>	\$15,934.29
<b>Sales Tax (6.0%)</b>	\$956.06
<b>Payments/Credits</b>	\$0.00
<b>Balance Due</b>	\$16,890.35-

Invoice #	Date
82204	5/10/2022

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**153 Pennsylvania Avenue  
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Year	Make	Model	Vin #	Mileage	
1970 (series 2)	Jaguar	XKE	TR13486	76,029	
Description			Qty	Cost	Amount
<p>Remove PS engine tins for access. Remove brake vacuum reservoir for access. Remove PS interior carpet to access starter access cover. Remove starter access cover screws and cover. Remove starter cables, mounting clamp, bolts and removed factory starter. Installed spacer on new high torque starter. Installed high torque starter into chassis. Fabricated signal cable for starter using 1 female crimp connector and shrink tubing. Installed starter wiring and tested starter operation.</p> <p>Research tail lamp fitting to original tail lamp buckets. Found new tail lamps require bucket modification for use. Found aftermarket battery tray (wrong size) welded into engine compartment and rusted. Cut out battery tray. Noted patch panels restricting new battery tray fitment. Removed excess body filler and reformed fender liner to fit tray. Found frame rail rusted and detached from firewall. Rec repair or replace frame rail. Install new battery tray.</p> <p>Modify original coil bracket for MDS coil. Fabricated new positive and ground cables with new cables. Paint ignition coil bracket. Installed MSD coil into coil bracket and installed in vehicle. Installed coil wiring.</p> <p>Remove and replaced heater core inlet and outlet hoses. Installed (4) 12-20 clamps on heater hoses. Removed and replace intake manifold coolant hose and (2) 12-20 clamps. Removed and replaced firewall to intake manifold and (2) 12-20 clamps. Removed and replaced firewall to coolant rail hose and (2) 12-20 clamps. Removed and replaced coolant rail to intake manifold hose and (2) 20-32 clamps. Removed and replaced coolant rail to water pump hose and (2) 20-32 clamps. Removed and replaced water valve hose and (2) 12-20 clamps. Removed and replace water pump to intake manifold hose and (2) 20-32 clamps.</p> <p>Start fabrication of the mounting brackets for the new cooling fan. Continue cooling fan installation. Brackets are made and fitted. (still need to add holes for air flow). Installed water pump pulleys and water pump belt. Mod. for hole in RR tail lamp bucket and installed 1 insert</p>					

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Year	Make	Model	Vin #	Mileage	
1970 (series 2)	Jaguar	XKE	TR13486	76,029	
Description			Qty	Cost	Amount
<p>Mounted RR tail lamp bucket. Installed foam tape into RR tail lamp. Installed grommet in body for tail lamp harness. Rout wiring for RR tail lamp through body into trunk. Fabricated ground wire from lamp to trunk ground. Installed eyelet for ground and wrapped in raychem. Installed 10/32 screw, washer and nylon nut. Installed (3) 10/32 X 3/4" screws, (3) flat washers and (3) split washers in tail lamp. Installed (2) 10/32 x 1/2" screws, (2) flat washers, (2) split washers and (2) sheet metal screws in tail lamp bucket. Wired RR tail lamp to body harness. Found new alternator too large. Measured original belt and source from parts supply house.</p> <p>Modified LS tail lamp bucket for new tail lamp and paint as needed. Attach new brackets and fan to the radiator.</p> <p>Rewire LS tail lamp. Installed bucket, 10 new screws, 6 flat washers, 1 split washer, 1 nut, and 1 grommet. Installed new foam tape on tail lamp and installed LR tail lamp.</p> <p>Removed thermostat bolts. Found housing seized onto engine. Removed seized housing. Chased mounting studs. Cleaned old gasket material from engine. Glass bead thermostat housing, bolts and washers. Installed new thermostat and gasket. Installed radiator and fan assembly. Found threads stripped in radiator for mounting bracket. Installed heli coil in radiator housing. Glass bead mounting washers and nuts. Installed new upper radiator hose, by pass hose and 4 new clamps. Installed alternator bracket and adjusted belt tension. Installed fan relay and routed wiring. Covered harness and wiring in raychem.</p>					

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Year	Make	Model	Vin #	Mileage	
1970 (series 2)	Jaguar	XKE	TR13486	76,029	
Description			Qty	Cost	Amount
<p>Installed battery supply, ignition supply and coolant sensor switch to fan relay. Covered wiring in raychem. Rewire coolant switch harness. Connected wiring with 1 eyelet, 4 blue connectors. Installed lower hose pipe, 4 clamps and both lower hoses. Removed expansion tank to radiator hose. Installed new expansion tank to radiator hose and 2 clamps. Secured wiring and hose with 11 zip ties.</p> <p>Performed coolant system evacuation and filled with 4 gallons of antifreeze. Filled vehicle with 3 gallons of fuel. Started engine and brought up to temperature. Found engine dieseling (with cooling fan running). Noted tachometer not functioning correctly. Found tachometer reading incorrect. Verified engine speed with digital timing light/rpm gauge. Set ignition timing to 10 degrees BTDC. Performed troubleshooting engine dieseling. Discounted MSD box and ignition coil on shut down. Found dieseling still present. Inspected alternator for feedback during shut down. No feedback present. Noted excessive carbon most likely causing dieseling.</p> <p>Removed dashboard to access tachometer. Removed tachometer and prepared for calibration. Source wheel knock off key. Moved canister for access. Installed brake reservoir hose to booster hose and 1 clamp. Filled brake fluid and worked front calipers in and out. Removed front brake pads. Glass bead front brake pins, lubricated pads and installed pins into calipers. Found RF caliper sticking. Removed caliper and exercised piston. Installed RF caliper and bled front brakes using 2 bottles of brake fluid. Attempted to bleed rear brakes. Found fluid not reaching rear brake. Opened brake lines and found rear brake hose restricted. Found L.R caliper bleeder screw seized. Soaked bleed screw in penetrating oil. Noted bleeder screws rusted and broken. Prep to R&amp;R rear and send calipers out for rebuild.</p> <p>Plugged fuel line. Removed choke cables, linkage and removed carburetors. Disassembled carburetors and soaked in cleaner. Cleaned parts in ultrasonic clean and glass beaded rusted pieces. Assembled forward carburetor assembly.</p>					
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Description			Qty	Cost	Amount
Cleaned and glass bead rearward carburetor. Assembled carburetor. Soaked rear bleeder screw. Attempted to loosen bleeder. Found screw seized. Heated bleeder screw and attempted removal. Found bleeder screw broken upon removal. Removed old carburetor gaskets. Installed new carb gaskets. Installed both carburetors. Installed linkage and fuel line. Brought engine up to operating temperature. Adjusted airflow using STE flow meter. Found engine dieseling. Treated engine with 1 can of Scafoam top engine cleaner. Allowed engine to sit and restarted. Found fuel mixture out of adjustment.  Installed road wheels and prepared vehicle to move on to lift.  Work in progress... Drive belt V-belt Shrink wrap, crimp con. 4 1/4" bolts, 2 nuts, 4 lock washers and 6 flat washers, 2 new terminal ends, 2 cable clamps and heat shrink. (12) 12-20 clamps, (12) 20-32 clamps, 10/32 screw, washer and nylon nut. Installed (3) 10/32 X 1/4" screws, (3) flat washers and (3) split washers in tail lamp. Installed (2) 10/32 x 1/2" screws, (2) flat washers, (2) split washers and (2) sheet metal screws. 10 new screws, 6 flat washers, 1 split washer, 1 nut, and 1 grommet. 1 eyelet, 4 blue connectors, 20 Ziptic, 1 eyelet, 4 blue connectors Gasket Rear lamp Thermostat Gasket thermostat Carburetor kit Water pipe Antifreeze Battery					
			1	19.36	19.36T
			1	18.10	18.10T
			1	87.00	87.00T
			1	1.50	1.50T
			1	349.99	349.99T
			1	10.79	10.79T
			1	1.09	1.09T
			2	39.99	79.98T
			1	25.99	25.99T
			1	25.68	25.68T
			7	191.62	191.62T
<b>Subtotal</b>					
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Year	Make	Model	Vin #	Mileage	
1970 (series 2)	Jaguar	XKE	TR13486	76,029	
Description			Qty	Cost	Amount
Brake hose rear			1	13.99	13.99T
Brake hoses			2	12.99	25.98T
Ate Brake fluid - Liter			2	20.25	40.50T
Freight & Insurance				6.28	6.28T
Fuel			5.2	4.85	25.22
Radiator Recore...				1,185.00	1,185.00T
Pressurc wash and clean inside and out. Pressure test for leaks, seam leaks op top tank. Flow was poor. Heat and remove tanks and side straps from old core. Glass bead the tanks and side straps. Reassemble rad with new core. Install new petcock. Retest the rad system leaks. Convert electric tach for electric ignition			1	325.00	325.00T
Shop Labor / Road			70.7	159.00	11,241.30T
Fabrication Shop Labor			7.63	140.00	1,068.20T
CLOSED AND SENT ON 6/29/2022					

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<b>Subtotal</b>	\$14,742.57
<b>Sales Tax (6.0%)</b>	\$883.04
<b>Payments/Credits</b>	-\$0.26
<b>Balance Due</b>	\$15,625.35

Invoice #	Date
82179	2/17/2022

Bill to
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153 Pennsylvania Avenue  
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Year	Make	Model	Vin #	Mileage	
1970	Jaguar	XKE	TR13486	76,024	
Description			Qty	Cost	Amount
<p>Evaluate condition of engine, drive line, suspension and chassis after sitting for 15 years. report to owner. Owner noted older restoration 15+ years. However, did not see road use since restored.</p> <p>Customer request: Power steering, Alt. installed, setup for modern day specs. Perform overall check over car:</p> <p>Brake reservoirs need replacement, replace hoses, check carpet and access operation of systems (brakes and clutch). Radiator, noted leaks are present. Sent out for Recore with HP unit. Replace battery and cables. Ignition should be upgraded to a Pertronix / HEI unit. Fuel tank, lines, fuel pump, level sensor and fuel filter need replaced recommend updated fuel pump to solid state. Oil change and new filter. Tires / wheels need replacement. Clutch slave cylinder should be replaced unit noted very rusty. Trans noted leaking oil around rear seal. All belts / hoses need replacement. Engine looked over, oil in cylinders and turn over by hand, prime oil system and check carb operation and condition.</p> <p>Service: Removed fuel tank pick up. Blasted rust from pick up assembly. Installed new gasket, bolts, and copper washers. Install fuel pick up in new fuel tank. Installed new fuel tank sending unit, gasket, screws and copper washers. Removed compression fitting from fuel pick up assembly and installed new fuel filter screen on pick up. Found new fuel tank sump shorter than original by 1.5cm and binding on pick up screen. Modified sump pick-up tube to fit in shorter sump bowl. Painted pick-up tube and plate. Installed pick-up tube, plate and filter.</p>					
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Year	Make	Model	Vin #	Mileage	
1970	Jaguar	XKE	TR13486	76,024	
Description			Qty	Cost	Amount
<p>Installed sump and seal  Found fuel filler drain covered from prior bodywork. Found tube rusted in trunk.  Cut off rusted tube and drilled hole through DS lower quarter panel for drain. Installed new drain hose and clamp as needed for proper operation of system.  Fabricate and install decorative cover for same.</p> <p>Found trunk wiring harness has poor connections and bare wires. Rewired and repaired trunk harness. Fished wiring through rear body channel. Found wire disconnected from reverse lamps.  Install wiring, routed and secured connection behind rear bumper.  Rewired L&amp;R reverse lamps. Drilled out terminals on reverse lamps and installed new wire and terminals.  Fabricated new harnesses for reverse lamps and mounted with new grommets. Installed new ground to lamps in trunk.</p> <p>Primed engine cylinders with oil...soak for weeks.  Added 3 qts of oil to engine. Manually turned engine by hand. Installed battery and cranked engine over until oil pressure was achieved.</p> <p>Installed fuel tank. Installed 3 new fuel tank breather hoses. Installed fuel filler hose and clamps. Wrapped fuel pump with foam gasket and installed new fuel pump mounting brackets. Installed fuel pump and wiring. Found ground wire coated in paint. Cleaned paint off fuel pump ground. Installed 2 new fuel pump rubber mounting studs. Cleaned out fuel line from tank to fuel filter. Installed fuel tank to pump line, seating washers and new banjo bolts. Installed fuel pump output line, seating washers and new banjo bolts.  Install new fuel hose and 2 clamps from fuel filter housing to carb. Filled fuel tank with 2 gallons of fuel and added 1 bottle of seafoam to tank. Primed fuel system to inspect for leaks. Primed fuel system and verified holding pressure.</p> <p>Installed original spark plugs and wires. Drained engine oil. Filled engine with oil and 1 bottle of Lucas engine treatment. Attempted to start vehicle. Found no spark present. Cleaned distributor cap, rotor and points. Found</p>					

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Year	Make	Model	Vin #	Mileage	
1970	Jaguar	XKE	TR13486	76,024	
Description			Qty	Cost	Amount
<p>spark now present at points but not at coil By-passed coil resistor and jumped points Found coil spark now present. Topped off cooling system and attempted to start vehicle. Allowed engine to run for several minutes. Noted engine starving for fuel. Add heavy dose of Scafoam, let sit and soak to loosen varnish and gum prior to rebuilding carbs.</p> <p>Pivoted hood to forward most position to access radiator Drained cooling system Removed cooling fans and radiator assembly Sized radiator for updated cooling fan Scheduled pick-up for radiator testing noted needs new core Work in progress.</p>					
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Year	Make	Model	Vin #	Mileage	
1970	Jaguar	XKE	TR13486	76,024	
Description			Qty	Cost	Amount
<p>Installed trunk mounted fuel tank bracket and 4 new retaining nuts. Installed tank to mount bolt.            Removed and replaced 6 new spark plugs. Removed and replaced clutch and brake pedal rubber covers.            Tightened loose clutch pedal. Straightened LS tail lamp bucket and blasted off rust. Primed and painted LS tail lamp bucket. Removed RS tail lamp bucket. Blasted, primed and painted RS tail lamp bucket            Installed trunk latch and lubed. Verified trunk latch operation            Installed Pertronix distributor and retaining clamp            Fabricated wiring harness and wired MSD box, ignition coil and distributor            Wired MSD system to battery power.            Removed brake fluid reservoirs. Blasted reservoir mounting bracket. Installed new brake fluid reservoirs and installed 3 new clamps. Removed front wheels. Removed engine bracket and water pump.            Removed PS engine tins for access. Removed brake vacuum reservoir for access. Removed PS interior carpet to access starter access cover. Removed starter access cover screws and cover. Removed starter cables, mounting clamp, bolts and removed starter.            Installed spacer on new high torque starter. Installed high torque starter. Fabricated signal cable for starter using 1 female crimp connector and shrink tubing.            Installed starter wiring and tested starter operation. Researched tail lamp fitting to original tail lamp buckets. Found new tail lamps require bucket modification for use.            Discuss body detailing with T. Mc Nan. Waiting on est.            Work in progress.            Shop hardware:            Material: 6"x7" aluminum sheet, pop rivet x 4PCs.            Electrical connectors, cable ties, grommets, Elect. cable, heat shrink tube, clamps.            Brake res. caps            Fluid res/hose assy</p>			1	12.75	12.75
			2	6.31	12.62
			1	50.79	50.79

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1970	Jaguar	XKE	TR13486	76,024		
Description				Qty	Cost	Amount
Brake reservoir assy				2	68.11	136.22T
Bracket on pump				1	11.54	11.54T
Fuel pump bkl				1	25.65	25.65T
Union double ended Clips 5/16"				1	13.51	13.51T
Fuel pipe clips				5	1.56	7.80T
Fuel pipe fittings				7	3.81	7.62T
Fuel pipe kit				1	41.00	41.00T
Electronic fuel pump				1	107.67	107.67T
Fuel tank & fittings				1	238.23	238.23T
Fuel pump				1	809.00	809.00T
Fibre washers				1	76.03	76.03T
Banjo stems (singles)				4	0.17	0.68T
Fuel feed pipe				2	11.36	22.72T
Fibre washers				1	73.08	73.08T
Banjo bolt steel				8	0.88	7.04T
Fuel pipe kit				4	7.20	28.80T
Distributor elect				1	140.10	140.10T
Spark plugs				1	309.99	309.99T
High-torque starter				6	4.19	25.14T
Rear lamp RH				1	269.99	269.99T
Lamp pad RHR				1	329.99	329.99T
Lamp pad LHR				1	10.99	10.99T
Pad Backup lamp				1	10.99	10.99T
Oil filter				4	1.39	5.56T
Fuel filter				1	4.79	4.79T
Pedal pad				1	6.99	6.99T
Air filter				2	5.39	10.78T
				1	16.99	16.99T
<b>Subtotal</b>						
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