

Alfa 10/22/19

Larry Dickman / Alfa Parts Exchange
6071 11th Street
Tracy, CA 95304
925-200-1998 (Larry Jr)
209-365-1383 (Shop)

October 12, 2019

Invoice # 18264

Model: ~~1965 GT~~ 1957 Sprint Veloce

Description of Parts or Services:

Install second return spring in engine bay for carburetors.

Install catch can in right fender well for road draft tube to terminate into.

Install plastic liner/gasket to stop side mirror from loosening

Flip E-brake handle to correct orientation.

Reverse driveshaft rear section so slip yolk towards the front.

Adjust trunk lid latching and reattach top of Airplane on lid.

Fabricate door latch wedge plates to make doors latch better.

Reset Left side aluminum trim at leading edge of door to better align with rubber to door frame.

Dismantle sliding window frames and latches, manipulate channel felts for more track width, reverse glass left to right. Fabricate latch pins so windows lock in place.

Adjust existing brakes for better pedal height. Bleed brakes, checked master (seemed to have stopped leaking but that was not the case.)

Adjust clutch pedal resting height.

Switch seat tracks left to right to get correct travel and easier sliding, eliminate loose feel.

Spec new custom 100mm dia. rear springs to eliminate clunking, remove old springs and install new ones.

Fabricate Delrin bushings and machine alum. support blocks to try and eliminate accelerator pedal vibration.

Removed Generator to inspect and lube brush holders to stop random lack of charging.

Reset speedo, check wiring for electrical draw.

Space engine up slightly for better alignment and reduce vibration. (there seems to be some consensus that the new motor mount rubbers that we all buy are too stiff and cause a lot of vibration issues.)

Deliver car to Alamo

Fabricate new seat back rest stops as original and Black zinc plating.

New parts, fabrication, plating and misc. fluids, gas etc. \$ 527.00

Labor \$ 1840.00

Total: \$ 2,367.00

Epifani Restorations



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Invoice

1216 Fifth Street
Berkeley, CA 94710 USA

info@epifanirestorations.com

DATE	INVOICE #
12/30/2020	12726

BILL TO

PROJECT

ALFA GIULIETTA SPRINT #1493 03798

QTY	DESCRIPTION	RATE	AMOUNT
2	LABOR-(May 7) Test drive car, brakes dragging. Jack up rear of car, hand brake cable is hanging up. Adjust hand brake free play. Remove rear wheels and brake drums. Check shoe adjustment. Shoes are not square to drums. Adjust rear shoe angles. Lower shoe at RR is thin. Axle seal appears to be leaking at RR. Car left trail of oil in driveway. (Paolo)	115.00	230.00
3	LABOR-(May 13) Clean and blast RR brake drum. Reinstall rear drums and wheels, adjust rear brakes. Place rear on ground. Jack up front of car. Remove front wheels. Attempt to remove drums, will not budge. Remove front hubs (RF hub nut damaged). Press out hubs from drums. Drums and hubs painted with thick black paint at mating surface, causing drums to not detach from hubs. Remove paint from mating surfaces, reinstall hubs. Front shoes not square to drums, adjust shoe angle. Reinstall front drums and wheels. Adjust brakes. Go for test drive. Car does not stop straight. Recommend re-lining shoes. Master cylinder is leaking. (Paolo)	115.00	345.00
3.5	LABOR-(May 20) Lift vehicle to jack stands. Remove wheels. Right pitman arm fulcrum has excessive play. Remove brake drums. Remove front hubs to gain access to brake shoes and springs. Remove front and rear brake shoes and springs. Unbolt brake master cylinder from side of pedal cluster. Disconnect master cylinder clevis from brake pedal. Remove pedal cluster to gain access to master cylinder. Evacuate brake fluid reservoir. Disconnect hard lines and remove brake master cylinder. (Chris)	115.00	402.50
0.25	LABOR-(May 26) Package and ship brake shoes for re-lining. (Chris)	115.00	28.75
Total			

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QTY	DESCRIPTION	RATE	AMOUNT
1	LABOR-(May 29) Disassemble original master cylinder to confirm size. Swap fittings to new master cylinder. Replace crush washers install onto pedal cluster and adjust brake pedal. (Chris)	115.00	115.00
0.75	LABOR-(June 16) Remove axle to expose leaking axle seal. Disconnect parking brake cable and hydraulic brake line. Remove and wash backing plate. (Chris)	115.00	86.25
3.5	LABOR-(June 17) Install brake and clutch pedal cluster with new master cylinder. Connect hard lines to new master cylinder. Install front stainless braided brake lines. Rear brake line seized in T-fitting. Remove T-fitting to place in vice. Remove brake line and install new stainless braided rear brake line with new sealing washer. Remove parking brake cable and housing. (Chris)	115.00	402.50
1	LABOR-(June 17) Remove passenger door panel. Remove hardware holding in window frame. Remove latches from door glass. Lift up window frame, remove glass. Some hardware will need repair. Window channel is not in good shape. (Paolo)	115.00	115.00
5.25	LABOR-(June 18) Check rear axle oil level. Remove left axle seal. Pick up replacement axle seal from supplier. Install new axle seal. Reinstall LR axle and brake backing plate. Install passenger backrest adjusters. Inner driver's side threaded hole for adjuster has an undressed weld obstructing collar for adjuster. Remove driver's seat to dress weld. Measure seat mounting points and compare them to the holes in the seat frame. Seat frame is 1/2" wider than mounting points on slides. Inner slide is bent. Machine posts, straighten seat frame and inner track. (Chris)	115.00	603.75
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2.5	LABOR-(June 19) Dress weld on seat adjuster hole. Install seat adjusters. Clean seat upholstery. Reinstall driver's seat. (Chris)	115.00	287.50
1	LABOR-(June 19) Disassemble driver door, remove glass. Compare sizes of LH and RH door glass. (Paolo)	115.00	115.00
1	LABOR-(June 23) Write instructions, drop off door glass for duplication in plexiglass. (Paolo)	115.00	115.00
2	LABOR-(June 29) Install LF brake shoes. Chase threads on right side spindle. Install RF brake shoes. Retract shoe adjusters. Install rear brake shoes. (Chris)	115.00	230.00
3.25	LABOR-(July 6) Use shoe adjustment tool to adjust front and rear brake shoes. Mount brake drums. Pressure bleed brakes. (Chris)	115.00	373.75
4	LABOR-(July 7) Pick up plexiglass windows from manufacturer. Assess engine location. Headers are touching pedal box. Transmission is touching tunnel (brake reservoir feed line making hard contact with brake line). Loosen engine mounts. Remove incorrect rubber sandwiched between engine mounts and chassis. Relocate engine to improve header clearance. Machine spacers to install under transmission mount to address transmission clearance. Install spacers. Clearance issues much improved. Note: Crank pulley is larger than original and has very little clearance to front cross member. (Paolo)	115.00	460.00
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QTY	DESCRIPTION	RATE	AMOUNT
3.5	LABOR-(August 17) Work on window assemblies. "U" channel for sliding windows is damaged and too wide for window frame. Search for correct channel, call Italy to check availability. Check rear brake drums for wear limit. Ok. Set up brake doctor on rear brake shoes, adjust and machine shoes. Install rear brake drums, adjust brakes. (Paolo)	115.00	402.50
0.5	LABOR-(August 18) Measure front brake drums. Drums are machined beyond limit. Search for replacement drums. (Paolo)	115.00	57.50
0.5	LABOR-(August 24) Receive and degrease replacement front brake drums. Preliminary measure drums. (Paolo)	115.00	57.50
0.5	LABOR-(August 25) Bead blast replacement brake drums, measure drums. Ok. Debur drums. (Paolo)	115.00	57.50
1.5	LABOR-(August 26) Remove bearings from LF hub. Clean hub. Outer race has shims installed, not correct. Remove race and shims, reinstall race. Strip heavy paint from hub. Set up hub and new drum in brake lathe. Check for out of round. Ok. Machine drum. Clean and paint hub. (Paolo)	115.00	172.50
1.5	LABOR-(August 27) Repeat process for RF hub and brake drum. (Paolo)	115.00	172.50
1	LABOR-(August 27) Remove grease from LF bearings. Clean bearings in parts washer. Dry bearings and repack with grease. Install bearings into LF hub and install seal. Remove grease from RF wheel bearings. Clean bearings in parts washer. (Chris)	115.00	115.00
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QTY	DESCRIPTION	RATE	AMOUNT
7	LABOR-(September 25) Pack and install RF wheel bearings, install seal. Pick up correct outer wheel bearing washer from supplier. Set up brake doctor on front brake shoes. Adjust and machine front shoes. Install and cotter front hubs. Install front brake drums, adjust shoes. Lube, install and adjust hand brake cable. Fix trunk prop. Install wheels (rear drums may need turning). Clearance clutch rod to clear speedo cable. Front crossmember is bent. Straighten crossmember so it lays flat on chassis and to increase clearance to oil pan. Preferable to replace with an undamaged unit. Install crossmember with new hardware. Brake line going to rear brakes is copper, recommend replacing. (Paolo)	115.00	805.00
2.5	LABOR-(September 26) Torque wheels, set tire pressure. Put car on ground. Go to gas station, fill tank. Test drive car. Throttle is hanging up. Clutch needs adjusting. Place car on jack stands, remove drums, inspect shoes. Rear drums have excessive run out, poor contact to shoes. (Paolo)	115.00	287.50
3	LABOR-(September 28) Remove air filter assembly. Troubleshoot sticking throttle issue. Throttle assembly mounts on body have been modified to accept bushings, leaving no room for side play. Search through stock for original mounts. Tidy up and install new mounts (required straightening firewall). Reinstall air filter assembly. One hose clamp is broken. Bead blast and turn rear drums. Install drums. (Paolo)	115.00	345.00
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QTY	DESCRIPTION	RATE	AMOUNT
2	LABOR-(October 28) Install/torque rear wheels. Adjust rear brakes. Test drive car. Much improved. Brakes require more bedding in. Registration tags expired. (Paolo)	115.00	230.00
0.5	LABOR-(November 30) Call Italy, order window channel. Arrange payment. (Paolo)	115.00	57.50
5.5	LABOR-(December 23) Drain brake fluid. Open line hold downs and separate rear brake line from bundle. Disconnect brake line fitting from brake line junction. Disconnect brake line fitting from rear flex hose. Remove rear brake hard line. Flaring on hard line is incorrect at brake line junction. Flaring is male and receiving junction is also male. Line from master cylinder also copper. Remove hard line from master cylinder to junction. BMC hard line also flared incorrectly at brake junction. Remove brake junction to check for damage and to double check flaring on other hard lines. Brake lamp switch negative terminal loose. Bolt holding junction held in by two threads. With brake junction removed, rusty broken bolt visible in brake junction mounting hole. Brake switch sealed with teflon tape. Junction seats damaged by improper flaring and requires replacement. Shape new line to roughly follow profile of cooper line. Remove from vehicle flared "junction" end. Original fitting cracked. (Chris)	115.00	632.50
	SUBLET-Reline brake shoes.	417.20	417.20
	SUBLET-Make 4 duplicate windows	185.28	185.28
	PARTS-L & R front brake drums	420.00	420.00T
2	PARTS-Wheel seals front	12.60	25.20T
1	PARTS-Axle seal rear	13.09	13.09T
Total			

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QTY	DESCRIPTION	RATE	AMOUNT
2	PARTS-Throttle assembly mounts	35.00	70.00T
	PARTS-Misc sundries & hardware	12.56	12.56T
	PARTS-Flocked slide window channel	159.60	159.60T
	GAS, OIL & GREASE-Chevron gas	42.81	42.81
	FREIGHT-UPS charges to Porterfield.	20.41	20.41
	FREIGHT-Shipping charges for reline brake shoes.	25.65	25.65
		114.01	114.01
	Sales Tax	9.50%	66.54
		Total	\$8,874.85

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QTY	DESCRIPTION	RATE	AMOUNT
3	LABOR-(December 28) Disconnect master cylinder from reservoir. Disconnect clutch linkage from pedal cluster. Pull back carpet and insulation. Remove pedal cluster for access to broken bolt. Drill out broken bolt that retains brake junction to chassis. Brake junction is damaged, find suitable replacement. Clean replacement brake junction and install brake lamp switch. (Chris)	115.00	345.00
5	LABOR-(December 29) Install brake junction with new bolt. Examine all fittings of lines removed. Many are worn or mushroomed from overtightening. Make new line for master to junction with new fittings. Remove line from junction to LF. Fitting mushroomed and end at brake hose is single flared. Make new line with new fitting and double flare both ends. Shape and install new LF hard line. Install RF line. Transfer fittings from original rear brake line to new line, install line. Secure rear brake line and fuel line to chassis. Disconnect power lead from cut off switch to tuck hard lines. Pole on cut off switch loose. Tighten pole and reconnect power lead. Remove brake reservoir and reservoir hard line. (Chris)	115.00	575.00
5	LABOR-(December 30) Make new brake reservoir hard line, transfer original fittings and double flared both ends. Reinstall pedal cluster. Install line from BMC to junction. Shape and install new reservoir hard line. Reinstall brake fluid reservoir. Remove LF & RF slave cylinder hard lines. Lines are double flared at slave and should be bubble flared. Several fittings are over-tightened and damaged. Remove RR and LR slave cylinder hard lines. Rear lines are single flared and should be double flared. Find suitable replacement fittings online. (Chris)	115.00	575.00
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QTY	DESCRIPTION	RATE	AMOUNT
5	LABOR-(January 5) Make and mount new RR brake hard line. LR was routed incorrectly. Make and install new LR line. LF hard line from brake hose to first wheel cylinder has worn flare nut and incorrect flaring. Make new line with new flare nut and re-route to original configuration. Make new LF cylinder to cylinder line with new fittings and correct bubble flaring. Check fit both LF lines. Make new RF hard line from brake hose to wheel cylinder with new flare nut and correct bubble flare at wheel cylinder. Make new hard line for RF cylinder to cylinder with new flare nuts and correct bubble flaring. Check fit both RF lines. (Chris)	115.00	575.00
2.5	LABOR-(January 13) Remove drums, remove and inspect slave cylinders. Fronts are questionable, rears are corroded. Pick up new slave cylinders from supplier. (Paolo)	115.00	287.50
2.5	LABOR-(January 14) Install new front slave cylinders and brake lines. New rear slave cylinders are sub-standard, do not hold shoes in proper location. Pack and ship original wheel cylinders for re-sleeving. (Paolo)	115.00	287.50
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QTY	DESCRIPTION	RATE	AMOUNT
4	LABOR-(January 26) Work on driver window assembly. Remove old glue, etc from window channels. Cut to size and trail fit new "u" channel to alloy frame. Test fit glass windows. Some trimming and shimming required on "u" channels. Test fit glass again, windows work well. Glue "u" channel to upper window frame. Test fit latches. Locking mechanisms are missing, latch interferes with glass (evident by scratches at latch button). Machine latch button, make thinner gasket. Fit much improved but button still rubs. Latches probably not original to car. Making new thinner button will probably help situation. Make sample locking mechanism, test fit on latch. (Paolo)	115.00	460.00
6	LABOR-(January 27) Make second locking mechanism for driver window latch. Misc adjustments to improve function. Repeat u-channel and latch repair process for passenger door. Reassemble passenger door. Latch buttons as they are will scratch new plexiglass windows. (Paolo)	115.00	690.00
0.5	LABOR-(February 1) Machine passenger latch button to increase clearance to glass. Make thinner gasket, install button. Button still touches window. Recommend making thinner buttons. Need customer input as to how to proceed before finishing windows. (Paolo)	115.00	57.50
0.5	LABOR-(March 25) Receive and inspect sleeved wheel cylinders. No good, bore is not round. Pack and return to sleeving shop. (Paolo) No charge	0.00	0.00
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QTY	DESCRIPTION	RATE	AMOUNT
1	LABOR-(April 14) Install new shorter clevis pin in clutch linkage clevis at pedal. Pin was too long and stacked with washers. Install throttle stop with nut on either side of firewall so that it's actually adjustable. Stop was originally installed just through bolted with flat nut. No lock washer. (Chris)	115.00	115.00
4	LABOR-(April 14) Receive/inspect repaired rear wheel cylinders. Ok. Assemble and install rear cylinders and brake lines. Square all brake shoes, install drums. Bleed brakes, adjust brake shoes. Install wheels, place car on ground. (Paolo)	115.00	460.00
2	LABOR-(April 15) Test drive car. Check over after drive. Brakes will require bedding in. Bleed brakes. (Paolo)	115.00	230.00
0.5	LABOR-(April 15) Assist bleed brakes. (Chris)	115.00	57.50
2.5	LABOR-(April 21) Take car for long test drive. Adjust brakes after drive. Final bleed brakes. (Paolo)	115.00	287.50
0.25	LABOR-(April 21) Assist in brake bleed. (Chris)	115.00	28.75
	SUBLET-Wheel cylinder resleeved.	168.00	168.00
	PARTS-Brake fittings	36.96	36.96T
2	PARTS-Wheel cylinder front left	112.00	224.00T
2	PARTS-Wheel cylinder front right	112.00	224.00T
	PARTS-Wheel cylinder mounting kits	52.50	52.50T
	PARTS-Weatherstrip adhesive	21.55	21.55T
1	PARTS-Rear wheel cylinder kit	49.00	49.00T
	PARTS-Used Alfa brake junction and misc brake fittings	35.00	35.00T
	PARTS-Misc sundries & hardware.	26.87	26.87T
14	PARTS-Ft. 3/16" brake tubing	3.14	43.96T
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1	PARTS-Qt. brake fluid	13.40	13.40T
	MISCELLANEOUS-Brake fluid disposal fee	3.00	3.00
	FREIGHT-Shipping charges for brake fittings.	6.00	6.00
	FREIGHT-UPS charges for window channel shipment from Italy.	123.82	123.82
	FREIGHT-UPS charges to wheel cyinder repair.	14.04	14.04
	FREIGHT-Shipping charges from wheel cylinder repair.	15.00	15.00
	Sales Tax	9.50%	69.09
Total			\$6,157.44

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QTY	DESCRIPTION	RATE	AMOUNT
2	LABOR-(May 10) Remove passenger rear door glass retaining button and machine until correct clearance is achieved between two glass pieces. Hole for retaining screw is now exposed on button. Test fit button on driver side, ok. Drop off button at machine shop to have new pieces made with correct dimensions. (Paolo)	115.00	230.00
1.5	LABOR-(May 18) Pick up new window latch buttons from machine shop. Shorten rear door latch screws, fit new buttons to windows. Polish buttons, install on windows. (Paolo)	115.00	172.50
1.5	LABOR-(May 21) Final glue lower door window channels to window frames. Silver solder cracked air cleaner hose clamps, install on car. Vacuum interior, quick detail car. (Paolo)	115.00	172.50
	SUBLET-Machine shop product: 2 Aluminum spacer threaded M6x1.0	126.00	126.00
	Sales Tax	10.25%	0.00
Total			\$701.00