



**UNITED RACING SERIES:  
Engine program details:**

1. All UNITED RACING SERIES engine seals must be obtained from Competition Director – Darryl Timmermans - dtimmermans38@hotmail.com
2. GM 604/602 RED SEAL ENGINE can only be purchased from **Humberview GM-Parts**
3. ALL CRATE ENGINES MUST RETAIN FACTORY SPECIFICATIONS.
4. UNITED RACING SERIES engine repair facilities must verify that engine is within ALL factory specifications & install UNITED RACING SERIES engine seals.
5. All crate engine repairs must be approved by Competition Director – Darryl Timmermans.
6. All engines sealed with UNITED RACING SERIES engine seals will have 5 seals installed at following locations: Drill (1/8 hole) two adjacent bolt head at each location & install seal & cut off excess cable)
  - (1) Intake Manifold
  - (1) Oil Pan
  - (1) Timing Chain Cover
  - (1) Left Cylinder Head
  - (1) Right Cylinder Head

**UNITED RACING SERIES APPROVED ENGINE REPAIR FACILITIES:**

<b>John Saunders Racing Enterprise</b> 621 Simcoe St, Watford, Ontario PH: 519 876 3821	<b>Nova Motorsports</b> 20529 Milburn St Livonia, Michigan 48152 PH: 248-767-9560	<b>McGunegill Engine Performance</b> 320 West Ontario Drive Muncie, IN PH: 765 282 1913
<b>Leitch Performance Engines</b> 4080 North Service Road, Unit 21 Windsor, Ontario PH: 519 988 0037	<b>Stefko Racing Engines</b> 11940 Highway 48 Stouffville, Ontario PH: 905 642 6289	<b>Klotz Engines</b> 330 Dundas Street South Cambridge, Ontario 519.620.4664
<b>AP Racing Engines</b> 3096 Devon Dr. Windsor, ON N8X 4L2 Ph: 519 946 0718	<b>Beauchamp Performance Engines</b> Unit 1_2160 Solar Crescent Oldcastle On N0R 1LO 519 977 3359	<b>OSCAAR Series – ONLY</b> OSCAAR series cars may also use - Engines by Hal, Billy Howard Engines

**UNITED RACING SERIES APPROVED GM/FORD ENGINE SUPPLIERS:**

<b>Humberview GM Truck – (“RED SEAL” - GM 604)</b> <b>Scott Janes –</b> <a href="mailto:sjanes@humberviewparts.ca">sjanes@humberviewparts.ca</a> 416-231-4462	<b>APC AUTO PARTS CENTRE STORES (FORD CRATE ENGINE ONLY)</b> <a href="http://www.autopartscentres.com/apc-locations/">http://www.autopartscentres.com/apc-locations/</a>
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## Engine Tech Inspection: POST-RACE

1. Engines maybe removed after racing event for further inspection at an approved engine repair facility.
2. Engines removed for further tech inspection will not be taken to engine repair facility that originally "sealed" the engine.
3. Any engine that passes post-race inspection will be "re-sealed" with UNITED RACING SERIES seals at no cost to car driver/owner.
4. If engine fails post-race inspection: Car driver/owner is responsible for ALL outstanding invoices prior to engine being returned.

Within the guidelines of utilizing the 'Crate' engine options, all competitors are subject to a zero-tolerance policy of inspection and conformability to all guidelines as specified by the manufacturer.

If in the event any team is considered in question as to the productivity of performance from a 'crate' powered engine, that engine will be susceptible to the following inspection process without protest. Failure to adhere to any action taken by UNITED RACING Series officials will result in immediate disqualification & one race suspension.

At the conclusion of any race event UNITED RACING Series reserves the right to require any team to remove engine in complete form and turn over possession to appropriate officials for inspection purposes to be determined by officials.

Engine will be susceptible to dyno testing and/or engine tear down for complete inspection to determine total legality to factory produced complete form.

In the event of engine rebuild the only modifications are listed below. Crate engine rebuild maximum parameters.

- Maximum overbore of .008". Maximum Deck surfacing of block: .005"
- Maximum deck surfacing of cylinder head: .010 straight only. NO angle milling permitted.
- Minimum rod and main bearing size: .010" under
- Compression Ratio: GM 604 10.0:1 Max, Ford 347Sr/Sr7 10.0:1 Max

All other necessary parts required for rebuild are to be direct factory replacement purchased through GM/FORD and are exact OEM specified part numbered to '604', '602' OR 'D347SR/7' specification sheet and installed to factory specs. **APPROVED AFTERMARKET REPLACEMENT ENGINE PARTS LIST BELOW. APPROVED Stock Crate Engine replacement parts:**

<b>GM 604 Replacement Piston:</b>  <b>Mahle Engine Parts - Part # 930127805</b>	<b>GM 604 Replacement Oil Pan:</b>  <b>Champ Oil Pan - Part # CP100LTRB Champ Oil Pick-up Tube - Part # 046- 1012SB</b>	<b>GM 604 Replacement Timing Cover</b> <b>ALLSTAR Part # 90008 or "602" stock timing cover</b>	<b>GM 602 Replacement Oil Pan:</b>  <b>Champ Oil Pan – Part # CP55LTRB Champ Oil Pick-up Tube – Part 1010SB</b>
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**ANY CRATE ENGINE THAT FAILS TECHNICAL INSPECTIONS WILL RESULT ONE YEAR SUSPENSION FOR CAR OWNER/DRIVER/CREW CHIEF!!**

### ENGINE CLAIM RULE:

**Any CRATE engine maybe claimed after any event for the cost of a new replacement stock Crate Engine. (Crate engine cost + Tax + \$750.00 sealing/admin fee. CASH ONLY). Must finish in the top 10 in order to claim an engine. (See General rule book for details)**

UNITED RACING SERIES

COMPETITION DIRECTOR

DARRYL TIMMERMANS

[DTIMMERMANS38@HOTMAIL.COM](mailto:DTIMMERMANS38@HOTMAIL.COM)