



**SPORTSTER**

**Unmatched  
PERFORMANCE  
& DURABILITY**



Serving Harley-Davidson dealers and motorcycle shops since 1983

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# WORK SHEET

Shipping Address 2191, De la Province,  
Longueuil, Qc, Canada, J4G 1R2  
Phone: 450-647-6650  
Fax: 450-647-1650

|   |  |      |
|---|--|------|
| Dealer/Shop name _____  | Date _____                             |      |
| Person to contact _____   | Tel. _____                             |      |
| <b>HEAD MODEL</b>   |  |      |
| M Twin Cam  | M EVO Sportster 883 to 1200 conversion |      |
| M EVO Big Twin  | M Milwaukee-Eight                      |      |
| M EVO Sportster 1200  | M Other (specify) _____                |      |
| <b>ENGINE SIZE</b>  |  |      |
| Engine size _____   | Bore _____ Stroke _____                |      |
| <b>DESIRED</b>  |  |      |
| M Stage II  | M Stage IIB                            |      |
| M Stages IIIB   | M Stages IVB                           |      |
| Stages IV+  | M Stages V                             |      |
| M Other (specify): _____  |  |      |
| <b>NOTE</b> For all Stage IIB, IIIB and IVB, you must send us the two intake manifold flange to engrave them with a new "F" and "R".<br>Because you need to interchange the flanges to match the raised ports.<br>Not required for 2007 and up manifold with identical flanges. |  |      |
| <b>PISTON MODEL</b> <small>With crankworks, we need the Piston weight in grams (inc. pin, clips and rings)</small>  |  |      |
| M Flat top  | M Domed                                |      |
| M Reverse Dome  | Specify _____                          |      |
| <b>DESIRED COMPRESSION</b>  |  |      |
| Ex.: 9.8 to 1 _____ cc's      Specify _____   |  |      |
| <b>CAMSHAFT USED</b>  |  |      |
| Model _____   | Lift _____ TDC lift _____              |      |
| <b>OUTSIDE ESTHETIC</b>   |  |      |
| M The heads will be shipped back as received  |  |      |
| M Other (specify) _____   |  |      |
| <b>HEAD WORK OPTIONS</b>  |  |      |
| - J Precision Titanium logo installed on Stage IIB and UP (no extra charge).....  | M Yes                                  | M No |
| - Compression release valves installation:  |  |      |
| Machine heads for <b>manual</b> model & supply Machine.....   | M Yes                                  | M No |
| heads for <b>electric</b> model (machining only).....   | M Yes                                  | M No |
| - Intake manifold supplied to be ported.....  | M Yes                                  | M No |
| - Pistons supplied to be machined for valve clearance.....  | M Yes                                  | M No |
| <i>Extra(s) to repair (Ex.: Fix damage threads, weld crack, etc)</i>  |  |      |
| 1 _____   |  |      |
| 2 _____   |  |      |
| 3 _____   |  |      |



## MACHINING SERVICES FOR EVO SPORTSTER & BUELL Engines (1999-up)

December 2020 – 2020/2021

### HEAD: PORTING

Dealer  
Price      Retail  
Price

#### EVOLUTION Sportster 1200 ('88 to '03)

|     |           |  |         |         |
|-----|-----------|--|---------|---------|
| 663 | STAGE II  | Upgraded intake and exhaust port design and CNC ported. Includes: valve guides, valve seals, High Performance BEEHIVE Spring kit, 1.770" intake valves and 1.485" exhaust valves.  | Call us | 972.86  |
| 664 | STAGE IVB | The Ultimate heads for Sportster & Buell engines. We redesign and raise the intake port by welding to increase velocity, allowing for a crisper throttle response. Includes: valve guides, valve seals, High Performance BEEHIVE Spring kit, 1.900" intake valves and 1.575" exhaust valves. | Call us | 1450.00 |

#### EVOLUTION Sportster 883 to 1200

|     |           |  |         |         |
|-----|-----------|--|---------|---------|
| 665 | STAGE II  | Upgraded intake and exhaust port design and CNC ported. Includes: valve guides, valve seals, High Performance BEEHIVE Spring kit, 1.720" intake valves and 1.480" exhaust valves.  | Call us | 934.29  |
| 666 | STAGE IVB | The Ultimate heads for Sportster & Buell engines. We redesign and raise the intake port by welding to increase velocity, allowing for a crisper throttle response. Includes: valve guides, valve seals, High Performance BEEHIVE Spring kit, 1.900" intake valves and 1.575" exhaust valves. | Call us | 1522.71 |

#### EVOLUTION Sportster Buell XB-9 & XB-12

|     |          |   |         |        |
|-----|----------|---|---------|--------|
| 668 | STAGE II | Upgraded intake and exhaust port design and CNC ported. Includes: valve guides, valve seals, High Performance BEEHIVE Spring kit, 1.720" intake valves and 1.480" exhaust valves. | Call us | 972.86 |
|-----|----------|---|---------|--------|

#### EVOLUTION Sportster 1200 (2004 & up)

|     |           |  |         |         |
|-----|-----------|--|---------|---------|
| 670 | STAGE IIB | We redesign and raise the intake port by welding to increase velocity, allowing for a crisper throttle response. Includes: valve guides, valve seals, High Performance BEEHIVE Spring kit, 1.900" intake valves and 1.575" exhaust valves. | Call us | 1175.71 |
|-----|-----------|--|---------|---------|

### HEAD: WORK OPTIONS

Dealer  
Price      Retail  
Price

|       |  |  |         |        |
|-------|--|--|---------|--------|
| 650   | Intake manifold porting (Carburator)   |  | Call us | 54.29  |
| 254-S | MACHINE (2) head for compression release valves (machining only)                                       |  | Call us | 104.29 |
| 255-S | MACHINE (2) heads for compression release valves (includes (1) set of AV&V compression release valves) |  | Call us | 177.14 |
| 607   | PISTON valve pockets machined for valve clearance (2 pistons)  |  | Call us | 70.00  |
| 613   | Check and adjust cc on Twin Cam / EVO / Sportster  |  | Call us | 67.14  |

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## MACHINING SERVICES FOR EVO SPORTSTER & BUELL Engines (1999-up)

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### CYLINDER HEADS

| Dealer Price | Retail Price |
|--------------|--------------|
|--------------|--------------|

#### OVERALL REBUILD 2 HEADS

- Includes**
- (4) new AV&V valve guides and valve seals
  - Head gasket faces resurfaced
  - Valves centerless grinded
  - Set-up spring pressure & reassembly
  - Soda blast combustion chambers & ports
  - CNC seat job
  - Ultrasonic washed

|     |  |         |        |
|-----|--|---------|--------|
| 200 | Overall rebuild (2) heads                            | Call us | 441.43 |
| 201 | Overall rebuild (2) heads + High Flow seat job       | Call us | 471.43 |
| 202 | Overall rebuild (2) heads without guides replacement | Call us | 384.29 |

### HEAD: ESTHETIC

| Dealer Price | Retail Price |
|--------------|--------------|
|--------------|--------------|

|     |   |         |           |
|-----|---|---------|-----------|
| 103 | DISASSEMBLE & degrease (2) heads                      | Call us | 44.29     |
| 105 | SODA BLAST carbon out of (2) heads                    | Call us | 44.29     |
| 107 | GLASS BEAD (2) previously painted heads               | Call us | 131.43    |
| 108 | GLASS BEAD (2) unpainted heads                        | Call us | 100.00    |
| 109 | SAND BLAST, (2) painted head (ready to paint)         | Call us | 64.29     |
| 110 | SAND BLAST & paint (2) heads                          | Call us | 160.00    |
| 111 | SAND BLAST, paint & highlight (2) heads               | Call us | 194.29    |
| 114 | HILITE fins (2 heads)                                 | Call us | 65.71     |
| 115 | WELD & rebuild cooling fins                           | Call us | 37.14 & + |
| 116 | ULTRASONIC cleaning of (2) heads (ready for assembly) | Call us | 51.43     |

### HEAD: VALVE SEATS

| Dealer Price | Retail Price |
|--------------|--------------|
|--------------|--------------|

|     |  |         |            |
|-----|--|---------|------------|
| 204 | CNC 3 ANGLE seat job (2 heads)                               | Call us | 110.00     |
| 205 | CNC HP seat job (2 heads)                                    | Call us | 120.00     |
| 210 | MACHINE & install (1) valve seat (valve seat included)       | Call us | 98.57      |
| 211 | MACHINE & install (4) valve seats (valve seats included)     | Call us | 247.14     |
| 213 | WELD & repair valve seat receiver hole (valve seat included) | Call us | 101.43 & + |

### HEAD: VALVE GUIDES

| Dealer Price | Retail Price |
|--------------|--------------|
|--------------|--------------|

|     |  |         |            |
|-----|--|---------|------------|
| 218 | REMOVE, install & fit (1) valve guide (labor only)                                       | Call us | 32.86      |
| 219 | REMOVE, install & fit (4) valve guides (labor only)                                      | Call us | 65.71      |
| 223 | WELD & REPAIR valve guide receiver hole to std (includes 1 new valve guide & valve seat) | Call us | 174.29 & + |
| 224 | BORE CLEAN damaged valve guide receiver hole   | Call us | 94.29      |

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|     |                                | <b>HEAD: VALVES</b> | <b>Dealer Price</b> | <b>Retail Price</b> |
|-----|--------------------------------|---------------------|---------------------|---------------------|
| 231 | CLEAN carbon out of (1) valve  |                     | Call us             | 11.43               |
| 228 | RECONDITION (1) valve          |                     | Call us             | 11.43               |
| 229 | RECONDITION (4) valves         |                     | Call us             | 32.86               |
| 227 | CLEAN & RECONDITION (4) valves |                     | Call us             | 47.14               |

|     |  | <b>HEAD: RESURFACING</b> | <b>Dealer Price</b> | <b>Retail Price</b> |
|-----|--|--------------------------|---------------------|---------------------|
| 234 | RESURFACE (2) heads .005" or less                              |                          | Call us             | 65.71               |
| 235 | RESURFACE (2) heads .006" & up                                 |                          | Call us             | 78.57               |
| 242 | ANGLE MACHINE (2) combustion chambers & resurface gasket faces |                          | Call us             | 164.29              |

|     |   | <b>HEAD: SPARK PLUGS</b> | <b>Dealer Price</b> | <b>Retail Price</b> |
|-----|---|--------------------------|---------------------|---------------------|
| 245 | INSTALL (1) spark plug helicoil                                     |                          | Call us             | 44.29               |
| 247 | WELD & repair cracked spark plug hole (helicoil included) (2 heads) |                          | Call us             | 197.14              |
| 250 | MACHINE (2) heads dual plug   |                          | Call us             | 218.57              |
| 260 | Remove broken exhaust bolt + install Helicoil                       |                          | Call us             | 100.00              |
| 262 | WELD & REPAIR damaged combustion chamber                            |                          | Call us             | 37.14 & +           |

|     |  | <b>CYLINDERS: BORING &amp; HONING</b> | <b>Dealer Price</b> | <b>Retail Price</b> |
|-----|--|---------------------------------------|---------------------|---------------------|
| 307 | HONE & FIT only, (2) cylinders with stress plates                        |                                       | Call us             | 90.00               |
| 312 | BORE, HONE & fit (2) cylinders with stress plates                        |                                       | Call us             | 155.71              |
| 313 | BORE, HONE & fit (2) cylinders with stress plates for 3 5/8" bore        |                                       | Call us             | 170.00              |
| 314 | BORE, HONE & fit (2) cylinders with stress plates for 3 13/16" bore & up |                                       | Call us             | 185.71              |
| 315 | BORE & HONE 883 to 1200 conversion with stress plates (2 cylinders)      |                                       | Call us             | 371.43              |

|     |   | <b>CYLINDERS: ESTHETIC</b> | <b>Dealer Price</b> | <b>Retail Price</b> |
|-----|---|----------------------------|---------------------|---------------------|
| 120 | GLASS BEAD (2) cylinders                                |                            | Call us             | 100.00              |
| 121 | GLASS BEAD (2) previously painted cylinders             |                            | Call us             | 131.43              |
| 122 | SAND BLAST (2) cylinders (ready to paint)               |                            | Call us             | 58.57               |
| 123 | SAND BLAST & PAINT (2) cylinders black (paint included) |                            | Call us             | 160.00              |
| 125 | HIGHLIGHT cooling fins on (2) cylinders                 |                            | Call us             | 71.43               |
| 126 | SAND BLAST, PAINT & HIGHLIGHT (2) cylinders             |                            | Call us             | 194.29              |

|     |                                    | <b>CYLINDERS: MISCELLANEOUS</b> | <b>Dealer Price</b> | <b>Retail Price</b> |
|-----|------------------------------------|---------------------------------|---------------------|---------------------|
| 318 | REFACE (2) cylinders - lower decks |                                 | Call us             | 60.00               |
| 319 | REFACE (2) cylinders - upper decks |                                 | Call us             | 74.29               |

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### CRANKS

|     |  | Dealer Price | Retail Price |
|-----|--|--------------|--------------|
| 415 | RECONDITION, assemble & true 1 crank & connecting rods (complete job, labor only)<br>Rod races replacement   | Call us      | 350.00       |
|     |  | add 28.00    |              |
| 416 | SAME as previous + Dynamic balancing   | Call us      | 492.86       |
| 417 | Late Sportster w/ pressed-in crank pin. (includes: S&S Extreme Duty Rods, S&S Bearing & cages, Heavy duty crankpin, Trust washer +crank rebuilt, balanced & welded | Call us      | 1267.14      |
| 418 | RECONDITION, glass bead & fit (2) connecting rods  | Call us      | 144.29       |
| 419 | Late Sportster w/ pressed-in crank pin. (includes: Jobber Rods, S&S Bearing & cages, Heavy duty crankpin, Trust washer +crank rebuilt, balanced & welded           | Call us      | 984.29       |
| 420 | REPLACE Rod races (labor only)   | Call us      | 64.29        |
| 423 | SLEEVE damaged pinion shaft end (bushing section)  | Call us      | 192.86       |
| 425 | CHANGE & precision grind new inner race sleeve on pinion shaft (EVO late model) Race not included  | Call us      | 128.57       |
| 426 | MACHINE 1 S&S flywheel for thrust washer   | Call us      | 64.29        |

### ENGINE CASES

|     |   | Dealer Price | Retail Price |
|-----|---|--------------|--------------|
| 510 | BORE case for big bore cylinders (case must be assembled & torqued, unnecessary to remove cylinder studs) | Call us      | 230.00       |
| 521 | REMOVE & reinstall new case pinion bearing race + HONE & FIT (race not included)                          | Call us      | 152.86       |
| 523 | HONE & FIT pinion bearing race  | Call us      | 82.86        |
| 532 | Replace TIMKEN cups + "C" clip  | Call us      | 44.29        |

### MISCELLANEOUS

|     |   | Dealer Price | Retail Price |
|-----|---|--------------|--------------|
| 606 | REFACE & polish (4) rocker arms                   | Call us      | 91.43        |
| 609 | REBUSH, align & hone (4) rocker arms (labor only) | Call us      | 98.57        |
| 610 | HONE & fit (4) oversize tappets                   | Call us      | 94.29        |