



SPORTSTER

**Unmatched
PERFORMANCE
& DURABILITY**



Serving Harley-Davidson dealers and motorcycle shops since 1983

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MACHINING SERVICES FOR EVO SPORTSTER & BUELL Engines

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	799.00
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	1275.00

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	799.00
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	1275.00

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	799.00
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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	1150.00
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HEAD WORK OPTIONS

Dealer Price Retail Price

650	Intake manifold porting (carburetor)	Call us	45.94
254-S	MACHINE 2 heads for compression release valves (machining only)	Call us	90.00
255-S	MACHINE 2 heads for compression release valves (includes 1 set of AV&V compression release valves)	Call us	143.75
607	PISTON valve pockets machined for valve clearance (2 pistons)	Call us	59.06
652	Spring kit upgrades for EVO SPORTSTER. Maximum recommended lift .675", Titanium Retainers VSK675T	Call us	137.50

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	373.75
201	Overall rebuild 2 heads + High Flow seat job	Call us	398.75
202	Overall rebuild 2 heads without guides replacement	Call us	323.75



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CYLINDER HEADS (con't)

Dealer Price Retail Price

ESTHETIC

103	DISASSEMBLE & degrease 2 heads	Call us	37.50
105	SODA BLAST carbon out of 2 heads	Call us	36.88
107	GLASS BEAD 2 previously painted heads	Call us	112.50
108	GLASS BEAD 2 unpainted heads	Call us	85.94
109	SAND BLAST, 2 painted head (ready to paint)	Call us	50.00
110	SAND BLAST & paint 2 heads	Call us	137.50
111	SAND BLAST, paint & highlight 2 heads	Call us	166.25
114	HIGHLIGHT fins (2 heads)	Call us	50.00
115	WELD & rebuild cooling fins	Call us	31.25 & up
116	ULTRASONIC cleaning of 2 heads (ready for assembly)	Call us	43.75

VALVE SEATS

204	CNC 3 ANGLE seat job (2 heads)	Call us	65.63
205	CNC HP seat job (2 heads)	Call us	91.88
210	MACHINE & install 1 valve seat (valve seat included)	Call us	87.50
211	MACHINE & install 4 valve seats (valve seats included)	Call us	196.88
213	WELD & repair valve seat receiver hole (valve seat included)	Call us	87.50 & up

VALVE GUIDES

218	REMOVE, install & fit 1 valve guide (labor only)	Call us	25.00
219	REMOVE, install & fit 4 valve guides (labor only)	Call us	52.50
223	WELD & REPAIR valve guide receiver hole to std (includes 1 new valve guide & valve seat)	Call us	150.00 & up
224	BORE CLEAN damaged valve guide receiver hole	Call us	78.75

VALVES

231	CLEAN carbon out of 1 valve	Call us	5.00
228	RECONDITION 1 valve	Call us	8.75
229	RECONDITION 4 valves	Call us	26.25
227	CLEAN & RECONDITION 4 valves	Call us	39.38

RESURFACING

234	RESURFACE 2 heads .005" or less	Call us	55.13
235	RESURFACE 2 heads .006" & up	Call us	65.63
242	ANGLE MACHINE 2 combustion chambers & resurface gasket faces	Call us	131.25

SPARK PLUGS

245	INSTALL 1 spark plug helicoil	Call us	36.25
247	WELD & repair cracked spark plug hole (helicoil included) (2 heads)	Call us	160.00
251	DUAL PLUG modification (2 heads)	Call us	160.00

MISCELLANEOUS

260	REMOVE broken exhaust stud & install Helicoil	Call us	68.75
262	WELD & REPAIR damaged combustion chamber	Call us	31.25 & up



MACHINING SERVICES FOR EVO SPORTSTER & BUELL Engines

CYLINDERS

Dealer Price Retail Price

ESTHETIC

120	GLASS BEAD 2 cylinders	Call us	63.00
121	GLASS BEAD 2 previously painted cylinders	Call us	98.44
122	SAND BLAST 2 cylinders (ready to paint)	Call us	49.88
123	SAND BLAST & PAINT 2 cylinders black (paint included)	Call us	111.56
125	HIGHLIGHT cooling fins on 2 cylinders	Call us	60.00
126	SAND BLAST, PAINT & HIGHLIGHT 2 cylinders	Call us	156.25

BORING & HONING

Note: For EVO cylinders that are sent with base gaskets still adhered (late H-D gaskets are very difficult to remove), we will remove the gaskets by machining the lower deck. This operation also trues the cylinder lower deck.

307	HONE & FIT only, 2 cylinders with stress plates	Call us	76.13
312	BORE, HONE & fit 2 cylinders with stress plates	Call us	118.13
313	SAME for 3 5/8" bore	Call us	131.25
314	SAME for 3 13/16" bore & up	Call us	144.38
315	BORE & HONE 883 to 1200 conversion with stress plates (2 cylinders)	Call us	318.75

MISCELLANEOUS

318	REFACE 2 cylinders - lower decks	Call us	49.88
319	REFACE 2 cylinders - upper decks	Call us	63.00

CRANKS

Dealer Price Retail Price

415	RECONDITION, assemble & true 1 crank & connecting rods (complete job, labor only) Rod races replacement	Call us	281.25 add 28.00
416	SAME as previous + Dynamic balancing	Call us	418.75
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	1087.50
418	RECONDITION, glass bead & fit 2 connecting rods	Call us	123,75
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	843,75
420	REPLACE Rod races (labor only)	Call us	43.75
423	SLEEVE damaged pinion shaft end (bushing section)	Call us	162.50
425	CHANGE & precision grind new inner race sleeve on pinion shaft (EVO late model) Race not included	Call us	106.25
426	MACHINE 1 S&S flywheel for thrust washer	Call us	52.50

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	196.88
521	REMOVE & reinstall new case pinion bearing race + HONE & FIT (race not included)	Call us	131.25
523	HONE & FIT pinion bearing race	Call us	70.81
532	Replace TIMKEN cups + "C" clip	Call us	36.75



MACHINING SERVICES FOR EVO SPORTSTER & BUELL Engines

MISCELLANEOUS

Dealer Price Retail Price

606	REFACE & polish 4 rocker arms	Call us	63.00
609	REBUSH, align & hone 4 rocker arms (labor only)	Call us	76.13
610	HONE & fit 4 oversize tappets	Call us	81.25