



TWIN CAM

Unmatched
PERFORMANCE
& DURABILITY



Serving Harley-Davidson dealers and motorcycle shops since 1983

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MACHINING SERVICES FOR TWIN CAM Engines (1999-up)

December 2020 – 2020/2021

HEAD: PORTING Dealer Price Retail Price

Piston to valve clearance must be checked with all performance head work.
Cast piston usually require more clearance. Do not forget to send them to us with the heads

655	STAGE II	(For stock casting from 88" to 107") Upgraded intake and exhaust port design and CNC ported. Includes: valve guides, valve seals, High Performance BEEHIVE Spring kit, 1.900" intake valves and 1.585" exhaust valves	Call us	921.43
656	STAGE IIB	(For stock & aftermarket castings) Same as Stage II, except for the intake port which is redesigned and raised 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 1.585" exhaust valves	Call us	1175.71
674	STAGE IIB	(For S/E 110) redesigned and raised by welding to increase velocity, allowing for a crisper throttle response. Includes: valve guides, valve seals, High Performance DOUBLE Springs kit, 2.100" intake valves and 1.650" exhaust valves	Call us	1175.71
675	STAGE IIB	(For S/E 117 WET) Same as Stage II, except for the intake port which is redesigned and raised by welding to increase velocity; allowing for a crisper throttle response. Includes: valve guides, valve seals, High Performance DOUBLE Springs kit, 2.100" intake valves and 1.650" exhaust valves	Call us	1321.43
657	STAGE IIIB	High Performance BEEHIVE Spring kit, 1.940" intake valves and 1.585" exhaust valves, intake valve seats.	Call us	1292.86
658	STAGE IVB	(For stock castings) Ultimate modification for your factory casting. Includes: valve guides, valve seals, High Performance BEEHIVE Spring kit, 1.990" intake valves and 1.585" exhaust valves, intake valve seats.	Call us	1341.43
658+	STAGE IV+	(For stock castings 117") Ultimate modification for your factory casting. Includes: valve guides, valve seals, High Performance BEEHIVE Spring kit, 2.020" intake valves and 1.585" exhaust valves, intake valve seats.	Call us	1450.00
654	STAGE V	(For stock castings) We install 2.150" intake, 1.650" exhaust valves and modify the ports accordingly. Intake valve angle is modified, and rocker arm geometry is corrected.	Call us	1827.14
653	STAGE V	(For 120R, JIMS 131...) We install 2.150" intake, 1.650" exhaust valves and modify the ports accordingly. Intake valve angle is modified, and rocker arm geometry is corrected.	Call us	1905.71

HEAD: WORK OPTIONS Dealer Price Retail Price

650	Intake manifold porting (Carburator)	Call us	54.29
651	Screaming Eagle 50mm injection manifold porting (must be disassembled) except for the throttle plate	Call us	78.57
649	Intake manifold porting (Hurricane)	Call us	108.57
254	MACHINE 2 head for compression release valves (machining only)	Call us	94.29
255	MACHINE 2 heads for compression release valves (includes 1 set of AV&V compression release valves) JCR10B-2	Call us	165.71
257	MACHINE 2 heads for electric compression release valves (machining only)	Call us	157.14
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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CYLINDER HEADS

Dealer Price	Retail Price
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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
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103	DISASSEMBLE & degrease 2 heads	Call us	44.29
105	SODA BLAST carbon out of 2 heads	Call us	44.29
114	HILITE fins (2 heads)	Call us	65.71
115	WELD & rebuild cooling fins	Call us	37.14 & UP
116	ULTRASONIC cleaning of 2 heads (ready for assembly)	Call us	51.43

HEAD: VALVE SEATS

Dealer Price	Retail Price
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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 not included)	Call us	98.57
211	MACHINE & install 4 valve seats (valve seats not included)	Call us	247.14
213	WELD & repair valve seat receiver hole (valve seat not included)	Call us	101.43&UP

HEAD: VALVE GUIDES

Dealer Price	Retail Price
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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&UP
224	BORE CLEAN damaged valve guide receiver hole	Call us	94.29

HEAD: VALVES

Dealer Price	Retail Price
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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

Prices may change without notice • Phone: 450-647-6650 • Fax: 450-647-1650

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HEAD: RESURFACING

		Dealer Price	Retail Price
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

HEAD: SPARK PLUGS

		Dealer Price	Retail Price
245	INSTALL 1 spark plug helicoil (helicoil included)	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

CYLINDERS: BORING & HONING

		Dealer Price	Retail Price
303	BORE, HONE & fit 2 cylinders with stress plates	Call us	155.71
304	SAME AS ABOVE but for 4" to 4 1/8" bore	Call us	180.00
305	SAME AS ABOVE but for 4 1/8" bore & up	Call us	202.86
307	HONE & FIT only, 2 cylinders with stress plates	Call us	90.00
308	BORE, HONE & fit 2 cylinders from 3.875" to 3.927" with stress plates	Call us	202.86
309	BORE, HONE & fit 2 cylinders from 1450cc. to 1550cc. with stress plates	Call us	262.86
310	BORE, HONE & fit 2 cylinders from 1450cc to 107" with stress plates	Call us	304.29

CYLINDERS: ESTHETIC

		Dealer Price	Retail Price
125	HILITE cooling fins on 2 cylinders	Call us	71.43
127	HILITE cooling fins & Paint on 2 cylinders	Call us	142.86

CYLINDERS: MISCELLANEOUS

		Dealer Price	Retail Price
318	REFACE 2 cylinders - lower decks	Call us	60.00
319	REFACE 2 cylinders - upper decks	Call us	74.29
320	REFACE 2 S&S cylinders - upper decks w/2 steps	Call us	101.43



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CRANK

		Dealer Price	Retail Price
404	CHECK alignment only & tig weld crank pin	Call us	114.29
405	DISASSEMBLE, inspect, reassemble & align crank & tig weld crank pin (for misaligned crank)	Call us	272.86
406	DISASSEMBLE, inspect, reassemble & align crank & tig weld crank pin (for misaligned crank) + Hone & Fit for new Rod Bearings (Sold separately)	Call us	392.86
407	SAME AS PREVIOUS + Dynamic balancing	Call us	577.14
408	SLEEVE damaged pinion shaft end (bushing section) (on already disassembled flywheels)	Call us	184.29
409	COMPLETE CRANK REBUILD wih new H-Beam rods, crank pin & bearing (Sold separately)	Call us	642.86
410	"B" to "A" PINION SHAFT CONVERSION (on already disassembled flywheels)	Call us	197.14
411	STRAIGHTEN TC 96" sprocket shaft	Call us	45.71
412	Rebuild S/E ROD	Call us	144.29
413	Small end conn. rod	Call us	151.43
414	Replace and ream 2 W Pin Bush	Call us	65.71
422	Grind solder of the crankpin	Call us	37.14

ENGINE CASES

		Dealer Price	Retail Price
505	BORE CASE for big bore cylinders (case must be assembled & torqued, unnecessary to remove cylinder studs)	Call us	234.29
506	TIMKEN RACE CONVERSION (Timken bearing not included)	Call us	177.14
508	SLEEVE one damaged cam bearing receiver hole	Call us	217.14
509	Crank case machining for cam clearance	Call us	84.29
532	Install Timken cups	Call us	44.29
517	Bore, Hone & fit 4 lifter holes	Call us	117.14
517-1	Bore, Hone & fit 1 lifter hole	Call us	74.29

MISCELLANEOUS

		Dealer Price	Retail Price
606	REFACE & polish 4 rocker arms	Call us	91.43
608	TC CAM Support plate bushing replacement (labor only)	Call us	54.29

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