



EVOLUTION

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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. \_\_\_\_\_

### HEAD MODEL

M Twin Cam M EVO Sportster 883 to 1200 conversion M Milwaukee-Eight  
M EVO Big Twin M EVO Sportster 1200 M Other (specify) \_\_\_\_\_

### ENGINE SIZE

Engine size \_\_\_\_\_ Bore \_\_\_\_\_ Stroke \_\_\_\_\_

### DESIRED

M Stage II M Stage IIB M Stages IIB M Stages IVB Stages IV+ M Stages V  
M Other (specify): \_\_\_\_\_

**NOTE** For all Stage IIB, IIB and IVB, you must send us the two intake manifold flange to engrave them with a new "F" and "R".  
Because you need to interchange the flanges to match the raised ports.  
Not required for 2007 and up manifold with identical flanges.

### PISTON MODEL

With crankworks, we need the Piston weight in grams (inc. pin, clips and rings)

M Flat top M Domed M Reverse Dome Specify \_\_\_\_\_

### DESIRED COMPRESSION

Ex.: 9.8 to 1 \_\_\_\_\_ cc's Specify \_\_\_\_\_

### CAMSHAFT USED

Model \_\_\_\_\_ Lift \_\_\_\_\_ TDC lift \_\_\_\_\_

### OUTSIDE ESTHETIC

M The heads will be shipped back as received M Other (specify) \_\_\_\_\_

### HEAD WORK OPTIONS

- J Precision Titanium logo installed on Stage IIB and UP (no extra charge)..... M Yes M No
  - Compression release valves installation: Machine heads for manual model & supply Machine..... M Yes M No  
heads for electric 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
- Extra(s) to repair (Ex.: Fix damage threads, weld crack, etc)*

1 \_\_\_\_\_  
2 \_\_\_\_\_  
3 \_\_\_\_\_



## MACHINING SERVICES FOR EVOLUTION BIG TWIN Engines (1984-1999)

January 2024– 2024/2025

### HEAD: PORTING

			Dealer Price	Retail Price
		Piston to valve clearance must be checked with all performance head work. Cast piston usually require more clearance. Don't forget to send them to us with the heads		
659	STAGE II	(From 80" to 96"): Upgraded intake and exhaust port design and CNC ported. Not included: valve guides, valve seals, High Performance BEEHIVE Spring kit, 1.900" intake valves and 1.585" exhaust valves.	Call us	623.35
660	STAGE IIB	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. Not included: valve guides, valve seals, High Performance BEEHIVE Spring kit, 1.900" intake valves and 1.585" exhaust valves.	Call us	903.06
661	STAGE IIIB	Same as stage IIB plus we install 1.940" intake valves & oversize seats and increase the intake port area, resulting in peak horsepower increase. Not included: valve guides, valve seals, High Performance BEEHIVE Spring kit, 1.940" intake valves and 1.585" exhaust valves, intake valve	Call us	1009.17
662	STAGE IVB	Ultimate modification for 3 3/4" & up bore engines. We install 1.990" intake & 1.585" exhaust valves and enlarge the ports accordingly. Not included: valve guides, valve seals, High Performance BEEHIVE Spring kit, 1.990" intake valves and 1.585" exhaust valves, intake valve seats.	Call us	1062.56

### HEAD: WORK OPTIONS

			Dealer Price	Retail Price
650	Intake manifold porting (Carburator)		Call us	59.72
254	MACHINE (2) head for compression release valves (machining only)		Call us	104.00
255	MACHINE (2) heads for compression release valves (includes 1 set of AV&V compression release valves) JCR10A-2		Call us	182.28
607	PISTON valve pockets machined for valve clearance (2 pistons)		Call us	77.00
613	Check and adjust cc on Twin Cam / EVO / Sportster		Call us	73.85



## MACHINING SERVICES FOR EVOLUTION BIG TWIN Engines (1984-1999)

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### CYLINDER HEADS

Dealer Price      Retail Price

#### OVERALL REBUILD 2 HEADS

<b>Includes</b>	<ul style="list-style-type: none"> <li>-Head gasket faces resurfaced</li> <li>-Valves centerless grinded</li> <li>-Set-up spring pressure &amp; reassembly</li> <li>-Soda blast combustion chambers &amp; ports</li> <li>-CNC seat job</li> <li>-Ultrasonic washed</li> </ul>	<b>Not included</b>	<ul style="list-style-type: none"> <li>-4 new AV&amp;V valve guides and valve seals</li> </ul>
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200	Overall rebuild (2) heads	Call us	411.72
201	Overall rebuild (2) heads + High Flow seat job Overall	Call us	520.0
202	rebuild (2) heads without guides replacement	Call us	368.13

### HEAD: ESTHETIC

Dealer Price      Retail Price

103	DISASSEMBLE & degrease (2) heads	Call us	48.72
105	SODA BLAST carbon out of (2) heads	Call us	48.72
107	GLASS BEAD (2) previously painted heads	Call us	151.14
108	GLASS BEAD (2) unpainted heads	Call us	110.00
109	SAND BLAST, (2) painted head (ready to paint)	Call us	70.72
110	SAND BLAST & paint (2) heads	Call us	176.00
111	SAND BLAST, paint & highlight (2) heads	Call us	213.72
114	HILITE fins (2 heads)	Call us	72.28
115	WELD & rebuild cooling fins	Call us	45.00 & UP
116	ULTRASONIC cleaning of (2) heads (ready for assembly)	Call us	56.57

### HEAD: VALVE SEATS

Dealer Price      Retail Price

204	CNC 3 ANGLE seat job (2 heads)	Call us	121.00
205	CNC HP seat job (2 heads)	Call us	143.50
210	MACHINE & install (1) valve seat (valve seat not included)	Call us	108.43
211	MACHINE & install (4) valve seats (valve seats not included)	Call us	271.85
213	WELD & repair valve seat receiver hole (valve seat not included)	Call us	115.00&UP

### HEAD: VALVE GUIDES

Dealer Price      Retail Price

218	REMOVE, install & fit (1) valve guide (labor only)	Call us	36.15
219	REMOVE, install & fit (4) valve guides (labor only)	Call us	72.28
223	WELD & REPAIR valve guide receiver hole to std (includes 1 new valve guide & valve seat)	Call us	190.00&UP
224	BORE CLEAN damaged valve guide receiver hole	Call us	103.72

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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		12.57	
228	RECONDITION (1) valve	Call us		12.57	
229	RECONDITION (4) valves	Call us		38.00	
227	CLEAN & RECONDITION (4) valves	Call us		75.50	

		<b>HEAD: RESURFACING</b>		<b>Dealer Price</b>	<b>Retail Price</b>
234	RESURFACE (2) heads .005" or less	Call us		84.85	
235	RESURFACE (2) heads .006" & up	Call us		99.00	
242	ANGLE MACHINE (2) combustion chambers & resurface gasket faces	Call us		180.72	

		<b>HEAD: SPARK PLUGS</b>		<b>Dealer Price</b>	<b>Retail Price</b>
245	INSTALL 1 spark plug helicoil	Call us		48.72	
247	WELD & repair cracked spark plug hole (helicoil included) (2 heads)	Call us		216.85	
251	MACHINE (2) heads dual plug modification	Call us		215.28	
260	Remove broken exhaust bolt + install Helicoil	Call us		110.00	

		<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		103.72	
312	BORE, HONE & fit (2) cylinders with stress plates	Call us		171.28	
313	BORE, HONE & fit (2) cylinders with stress plates for 3 5/8" bore	Call us		187.00	
314	BORE, HONE & fit (2) cylinders with stress plates for 3 13/16" bore & up	Call us		204.28	

		<b>CYLINDERS: ESTHETIC</b>		<b>Dealer Price</b>	<b>Retail Price</b>
120	GLASS BEAD (2) cylinders	Call us		110.00	
121	GLASS BEAD (2) previously painted cylinders	Call us		144.57	
122	SAND BLAST (2) cylinders (ready to paint)	Call us		70.72	
123	SAND BLAST & PAINT (2) cylinders black (paint included)	Call us		176.00	
125	HILITE cooling fins on (2) cylinders	Call us		78.57	
126	SAND BLAST, PAINT & HIGHLIGHT (2) cylinders	Call us		255.00	
127	HILITE cooling fins & Paint on (2) cylinders	Call us		168.00	

		<b>CYLINDERS: MISCELLANEOUS</b>		<b>Dealer Price</b>	<b>Retail Price</b>
318	REFACE (2) cylinders - lower decks	Call us		70.72	
319	REFACE (2) cylinders - upper decks	Call us		86.43	
320	REFACE (2) S&S cylinders - upper decks w/2 steps	Call us		111.57	



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### CRANKS

		Dealer Price	Retail Price
415	RECONDITION, assemble & true (1) crank & connecting rods (complete job, labor only) Rod races replacement	Call us	580.00
	add 31.00		
416	SAME as previous + Dynamic balancing	Call us	777.87
418	RECONDITION, glass bead & fit (2) connecting rods	Call us	158.72
423	SLEEVE damaged pinion shaft end (bushing section)	Call us	212.15
426	MACHINE (1) S&S flywheel for thrust washer	Call us	70.72
425	CHANGE & precision grind new inner race sleeve on pinion shaft (EVO late model) Race not included	Call us	141.43
420	REPLACE rod races (labor only)	Call us	70.72
421	STRAIGHTEN pinion shaft	Call us	47.15

### 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	253.00
512	RESURFACE engine case deck (cylinder studs must be removed)	Call us	136.72
513	WELD & repair left case primary O ring lip (studs must be removed)	Call us	212.15
515	HELICOIL timing plug hole	Call us	58.15
518	OVERSIZE bore, breather gear hole .030"	Call us	92.72
519	SLEEVE breather gear hole (welding extra if required)	Call us	297.00
521	REMOVE & reinstall new case pinion bearing race + HONE & FIT (race not included)	Call us	168.15
523	HONE & FIT pinion bearing race	Call us	91.15
524	SLEEVE cam bearing hole	Call us	251.43
526	MACHINE left case for oversize bearing race insert	Call us	737.00
527	MACHINE engine case supports	Call us	135.15
528	CONVERT EVO case to Shovel style (includes 8 long helicoils)	Call us	465.15
530	Replace & Fit Cam bushing (labor only)	Call us	64.43
531	Replace & Fit pinion bushing (labor only)	Call us	48.72
532	Replace TIMKEN cups + "C" clip	Call us	48.72

### ENGINE CASE : ESTHETIC

		Dealer Price	Retail Price
130	GLASS BEAD unpainted engine case (oil galleries masked)	Call us	103.72
131	GLASS BEAD painted engine case (oil galleries masked)	Call us	141.43
133	SAND BLAST engine case (oil galleries masked) ready to paint	Call us	77.00
135	OIL GALLERY spot weld removal & installation of 1/8 NPT plug (allows better oil gallery clean up)	Call us	66.00
134	MASK & PAINT engine case	Call us	141.43
136	ULTRASONIC cleaning engine cases	Call us	73.85

### ENGINE CASE : MISCELLANEOUS

		Dealer Price	Retail Price
606	REFACE & polish (4) rocker arms	Call us	100.90
609	REBUSH & align hone 4 rocker arms (labor only)	Call us	108.43
610	HONE & fit (4) oversize tappets	Call us	103.72

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