



SPORTSTER

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PERFORMANCE
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MACHINING SERVICES FOR EVO SPORTSTER & BUELL Engines

January 2024 / 2024-2025

PORTING

Dealer Price Retail Price

EVOLUTION Sportster 1200 ('88 to '03)

663	STAGE II	Upgraded intake and exhaust port design and CNC ported. Not included: valve guides, valve seals, High Performance BEEHIVE Spring kit, 1.770" intake valves and 1.485" exhaust valves.	Call us	701.89
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. Not included: valve guides, valve seals, High Performance BEEHIVE Spring kit, 1.900" intake valves and 1.575" exhaust valves.	Call us	1265.20

EVOLUTION Sportster 883 to 1200

665	STAGE II	Upgraded intake and exhaust port design and CNC ported. Not included: valve guides, valve seals, High Performance BEEHIVE Spring kit, 1.720" intake valves and 1.480" exhaust valves.	Call us	697.91
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. Not included: valve guides, valve seals, High Performance BEEHIVE Spring kit, 1.900" intake valves and 1.575" exhaust valves.	Call us	1306.73

EVOLUTION Sportster Buell XB-9 & XB-12

668	STAGE II	Upgraded intake and exhaust port design and CNC ported. Not included: valve guides, valve seals, High Performance BEEHIVE Spring kit, 1.720" intake valves and 1.480" exhaust valves.	Call us	701.89
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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. Not included: valve guides, valve seals, High Performance BEEHIVE Spring kit, 1.900" intake valves and 1.575" exhaust valves.	Call us	963.48
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HEAD WORK OPTIONS

Dealer Price Retail Price

650	Intake manifold porting (carburetor)	Call us	59.72
254-S	MACHINE 2 heads for compression release valves (machining only)	Call us	114.72
255-S	MACHINE 2 heads for compression release valves (includes 1 set of AV&V compression release valves)	Call us	194.85
607	PISTON valve pockets machined for valve clearance (2 pistons)	Call us	77.00
613	Check and adjust cc on Twin Cam / EVO / Sportster/ Milwaukee-Eight (decking not included)	Call us	73.85

CYLINDER HEADS

Dealer Price Retail Price

OVERALL REBUILD 2 HEADS

Includes

- Head gasket faces resurfaced
- Valves centerless grinded
- Set-up spring pressure & reassembly
- Soda blast combustion chambers & ports
- CNC seat job
- Ultrasonic washed
- Not included: 4 new AV&V valve guides and valve seals

200	Overall rebuild 2 heads	Call us	411.72
201	Overall rebuild 2 heads + High Flow seat job	Call us	520.00
202	Overall rebuild 2 heads without guides replacement	Call us	368.13



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CYLINDER HEADS (con't)

Dealer Price Retail Price

ESTHETIC

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	HIGHLIGHT 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

VALVE SEATS

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

VALVE GUIDES

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	191.72 & up
224	BORE CLEAN damaged valve guide receiver hole	Call us	103.72

VALVES

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

RESURFACING

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

SPARK PLUGS

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
250	DUAL PLUG modification (2 heads)	Call us	240.43

MISCELLANEOUS

260	REMOVE broken exhaust stud & install Helicoil	Call us	110.00
262	WELD & REPAIR damaged combustion chamber	Call us	45.00 & up



MACHINING SERVICES FOR EVO SPORTSTER & BUELL Engines

CYLINDERS

Dealer Price Retail Price

ESTHETIC

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	HIGHLIGHT cooling fins on 2 cylinders	Call us	78.57
126	SAND BLAST, PAINT & HIGHLIGHT 2 cylinders	Call us	255.00

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	103.72
312	BORE, HONE & fit 2 cylinders with stress plates	Call us	171.28
313	SAME for 3 5/8" bore	Call us	187.00
314	SAME for 3 13/16" bore & up	Call us	204.28
315	BORE & HONE 883 to 1200 conversion with stress plates (2 cylinders)	Call us	408.57

MISCELLANEOUS

318	REFACE 2 cylinders - lower decks	Call us	70.72
319	REFACE 2 cylinders - upper decks	Call us	86.43

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
417	Late Sportster w/ pressed-in crank pin. Crank rebuilt, balanced & welded (not included: S&S Extreme Duty Rods, S&S Bearing & cages, Heavy duty crankpin, Trust washer)	Call us	777.87
418	RECONDITION, glass bead & fit 2 connecting rods	Call us	158.72
419	Late Sportster w/ pressed-in crank pin. crank rebuilt, balanced & welded(not included: Jobber Rods, S&S Bearing & cages, Heavy duty crankpin, Trust washer)	Call us	777.87
420	REPLACE Rod races (labor only)	Call us	70.72
423	SLEEVE damaged pinion shaft end (bushing section)	Call us	212.15
425	CHANGE & precision grind new inner race sleeve on pinion shaft (EVO late model) Race not included	Call us	141.43
426	MACHINE 1 S&S flywheel for thrust washer	Call us	70.72

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
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
532	Replace TIMKEN cups + "C" clip	Call us	48.72



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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