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

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. 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. Includes: valve guides, valve seals, High Performance BEEHIVE Spring kit, 1.900" intake valves and 1.585" exhaust valves.	Call us	921.43
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. Includes: valve guides, valve seals, High Performance BEEHIVE Spring kit, 1.900" intake valves and 1.585" exhaust valves.	Call us	1175.71
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. Includes: valve guides, valve seals, High Performance BEEHIVE Spring kit, 1.940" intake valves and 1.585" exhaust valves, intake valve seats.	Call us	1292.86
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. 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

HEAD: WORK OPTIONS

			Dealer Price	Retail Price
650	Intake manifold porting (Carburator)		Call us	54.29
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) JCR10A-2		Call us	165.71
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
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 & 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	101.25
205	CNC HP seat job (2 heads)	Call us	111.38
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

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

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		HEAD: VALVES		Dealer Price	Retail Price
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	

		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	Call us		44.29	
247	WELD & repair cracked spark plug hole (helicoil included) (2 heads)	Call us		197.14	
251	MACHINE (2) heads dual plug modification	Call us		195.71	
260	Remove broken exhaust bolt + install Helicoil	Call us		100.00	

		CYLINDERS: BORING & HONING		Dealer Price	Retail Price
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	

		CYLINDERS: ESTHETIC		Dealer Price	Retail Price
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	HILITE cooling fins on (2) cylinders	Call us		71.43	
126	SAND BLAST, PAINT & HIGHLIGHT (2) cylinders	Call us		194.29	
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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CRANKS

		Dealer Price	Retail Price
415	RECONDITION, assemble & true (1) crank & connecting rods (complete job, labor only) Rod races replacement	Call us	350.00
	add 28.00		
416	SAME as previous + Dynamic balancing	Call us	492.86
418	RECONDITION, glass bead & fit (2) connecting rods	Call us	144.29
423	SLEEVE damaged pinion shaft end (bushing section)	Call us	192.86
426	MACHINE (1) S&S flywheel for thrust washer	Call us	64.29
425	CHANGE & precision grind new inner race sleeve on pinion shaft (EVO late model) Race not included	Call us	128.57
420	REPLACE rod races (labor only)	Call us	64.29
421	STRAIGHTEN pinion shaft	Call us	42.86

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
512	RESURFACE engine case deck (cylinder studs must be removed)	Call us	124.29
513	WELD & repair left case primary O ring lip (studs must be removed)	Call us	192.86
515	HELICOIL timing plug hole	Call us	52.86
518	OVERSIZE bore, breather gear hole .030"	Call us	84.29
519	SLEEVE breather gear hole (welding extra if required)	Call us	270.00
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
524	SLEEVE cam bearing hole	Call us	228.57
526	MACHINE left case for oversize bearing race insert	Call us	670.00
527	MACHINE engine case supports	Call us	122.86
528	CONVERT EVO case to Shovel style (includes 8 long helicoils)	Call us	422.86
530	Replace & Fit Cam bushing (labor only)	Call us	58.57
531	Replace & Fit pinion bushing (labor only)	Call us	44.29
532	Replace TIMKEN cups + "C" clip	Call us	44.29

ENGINE CASE : ESTHETIC

		Dealer Price	Retail Price
130	GLASS BEAD unpainted engine case (oil galleries masked)	Call us	94.29
131	GLASS BEAD painted engine case (oil galleries masked)	Call us	128.57
133	SAND BLAST engine case (oil galleries masked) ready to paint	Call us	70.00
135	OIL GALLERY spot weld removal & installation of 1/8 NPT plug (allows better oil gallery clean up)	Call us	60.00
134	MASK & PAINT engine case	Call us	128.57
136	ULTRASONIC cleaning engine cases	Call us	67.14

ENGINE CASE : 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

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