



TWIN CAM

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PERFORMANCE
& DURABILITY



Serving Harley-Davidson dealers and motorcycle shops since 1983

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MACHINING SERVICES FOR TWIN CAM Engines (1999-up)

January 2026– 2026/2027

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. Not Included: valve guides, valve seals, High Performance BEEHIVE Spring kit, 1.900" intake valves and 1.585" exhaust valves	call us Add parts call us	642.50 470.00
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. Not included: valve guides, valve seals, High Performance BEEHIVE Spring kit, 1.900" intake valves and 1.585" exhaust valves	call us Add parts call us	930.50 502.00
674	STAGE IIB	(For S/E 110) redesigned and raised by welding to increase velocity, allowing for a crisper throttle response. Not included: valve guides, valve seals, High Performance DOUBLE Springs kit, 2.100" intake valves and 1.650" exhaust valves	call us Add parts call us	820.50 650.00
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. Not included: valve guides, valve seals, High Performance DOUBLE Springs kit, 2.100" intake valves and 1.650" exhaust valves	call us Add parts call us	985.50 650.00
657	STAGE IIIB	(For stock castings) Same as Stage IIB, Not included High Performance BEEHIVE Spring kit, 1.940" intake valves and 1.585" exhaust valves, intake valve seats.	call us Add parts call us	1039.50 600.00
658	STAGE IVB	(For stock castings) Ultimate modification for your factory casting. 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 Add parts call us	1094.50 568.00
658+	STAGE IV+	(For stock castings 117") Ultimate modification for your factory casting. Not Included: valve guides, valve seals, High Performance BEEHIVE Spring kit, 2.020" intake valves and 1.585" exhaust valves, intake valve seats.	call us Add parts call us	1202.00 584.00
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. Labor only	call us Add parts call us	1343.00 650.00
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. Labor only	call us Add parts call us	1432.00 650.00

HEAD: WORK OPTIONS

Dealer
Price

Retail
Price

650	Intake manifold porting (Carburator)	call us	62.00
651	Screaming Eagle 50mm injection manifold porting (must be disassembled) except for the throttle plate	call us	89.50
649	Intake manifold porting (Hurricane)	call us	123.50
254	MACHINE 2 head for compression release valves (machining only)	call us Add parts call us	107.50 90.50
257	MACHINE 2 heads for electric compression release valves (machining only)	call us	178.50
607	PISTON valve pockets machined for valve clearance (2 pistons)	call us	79.50
613	Check and adjust cc on Twin Cam / EVO / Sportster	call us	76.50



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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

Add parts call us 90.50

200	Overall rebuild 2 heads	call us	424.50
201	Overall rebuild 2 heads + High Flow seat job	call us	536.00
202	Overall rebuild 2 heads without guides replacement	call us	379.50

HEAD: ESTHETIC

Dealer Price Retail Price

103	DISASSEMBLE & degrease 2 heads	call us	50.50
105	SODA BLAST carbon out of 2 heads	call us	50.50
114	HILITE fins (2 heads)	call us	74.50
115	WELD & rebuild cooling fins	call us	47 & UP
116	ULTRASONIC cleaning of 2 heads (ready for assembly)	call us	58.50

HEAD: VALVE SEATS

Dealer Price Retail Price

204	CNC 3 ANGLE seat job (2 heads)	call us	125.00
205	CNC HP seat job (2 heads)	call us	148.00
210	MACHINE & install 1 valve seat (valve seat not included)	call us	112.00
211	MACHINE & install 4 valve seats (valve seats not included)	call us	280.50
213	WELD & repair valve seat receiver hole (valve seat not included)	call us	115 & UP

Add parts: each valve seat call us 14.90

HEAD: VALVE GUIDES

Dealer Price Retail Price

218	REMOVE, install & fit 1 valve guide (labor only)	call us	37.50
219	REMOVE, install & fit 4 valve guides (labor only)	call us	74.50
223	WELD & REPAIR valve guide receiver hole to std (includes 1 new valve guide & valve seat)	call us	198 & UP
224	BORE CLEAN damaged valve guide receiver hole	call us	107.00

Add parts: each valve guide call us 20.12

HEAD: VALVES

Dealer Price Retail Price

231	CLEAN carbon out of 1 valve	call us	13.00
228	RECONDITION 1 valve	call us	13.00
229	RECONDITION 4 valves	call us	39.50
227	CLEAN & RECONDITION 4 valves	call us	78.00

Prices may change without notice • Phone: 450-647-6650
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HEAD: RESURFACING

		Dealer Price	Retail Price
234	RESURFACE 2 heads .005" or less	call us	87.50
235	RESURFACE 2 heads .006" & up	call us	102.00
242	ANGLE MACHINE 2 combustion chambers & resurface gasket faces	call us	186.50

HEAD: SPARK PLUGS

		Dealer Price	Retail Price
245	INSTALL 1 spark plug helicoil (helicoil included)	call us	50.50
247	WELD & repair cracked spark plug hole (helicoil included) (2 heads)	call us	223.50
250	MACHINE 2 heads dual plug	call us	248.00
260	Remove broken exhaust bolt + install Helicoil	call us	113.50

CYLINDERS: BORING & HONING

		Dealer Price	Retail Price
303	BORE, HONE & fit 2 cylinders with stress plates	call us	176.50
304	SAME AS ABOVE but for 4" to 4 1/8" bore	call us	204.00
305	SAME AS ABOVE but for 4 1/8" bore & up	call us	230.00
307	HONE & FIT only, 2 cylinders with stress plates	call us	107.00
308	BORE, HONE & fit 2 cylinders from 3.875" to 3.927" with stress plates	call us	230.00
309	BORE, HONE & fit 2 cylinders from 1450cc. to 1550cc. with stress plates	call us	298.00
310	BORE, HONE & fit 2 cylinders from 1450cc to 107" with stress plates	call us	345.00

CYLINDERS: ESTHETIC

		Dealer Price	Retail Price
125	HILITE cooling fins on 2 cylinders	call us	81.00
127	HILITE cooling fins & Paint on 2 cylinders	call us	173.50

CYLINDERS: MISCELLANEOUS

		Dealer Price	Retail Price
318	REFACE 2 cylinders - lower decks	call us	73.00
319	REFACE 2 cylinders - upper decks	call us	89.50
320	REFACE 2 S&S cylinders - upper decks w/2 steps	call us	115.00



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CRANK

		Dealer Price	Retail Price
404	CHECK alignment only & tig weld crank pin	call us	129.50
405	DISASSEMBLE, inspect, reassemble & align crank & tig weld crank pin (for misaligned crank)	call us	309.50
406	DISASSEMBLE, inspect, reassemble & align crank & tig weld crank pin (for misaligned crank) + Hone & Fit for new Rod Bearings (Sold separately)	call us	445.50
407	SAME AS PREVIOUS + Dynamic balancing	call us	664.00
408	SLEEVE damaged pinion shaft end (bushing section) (on already disassembled flywheels)	call us	209.00
409	COMPLETE CRANK REBUILD (not included: new H-Beam rods, crank pin & bearing)	call us	801.50
410	"B" to "A" PINION SHAFT CONVERSION (on already disassembled flywheels)	call us	223.50
411	STRAIGHTEN TC 96" sprocket shaft	call us	52.00
412	Rebuild S/E ROD	call us	163.50
413	Small end conn. rod	call us	172.00
414	Replace and ream 2 W Pin Bush	call us	74.50
422	Grind solder of the crankpin	call us	42.50
401	Remove, prepare and loctite pinion race	call us	60.00
428	Weight compensation drilling for aluminum plugs	call us	49.00
429	Relocate Twin Cam balance gear	call us	131.50
400	Remove Steel Plug During Disassembly	call us	41.50

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	358.50
506	TIMKEN RACE CONVERSION (Timken bearing not included)	call us	201.00
508	SLEEVE one damaged cam bearing receiver hole	call us	246.50
509	Crank case machining for cam clearance	call us	96.00
532	Install Timken cups	call us	50.50
520	Flexhone and fit (4) lifter bores	call us	159.00
522	Sleeve (1) TC lifter bore	call us	486.00
522-4	Sleeve (4) TC lifter bores	call us	1619.00
536	Replace (2) cam bearing	call us	57.00

MISCELLANEOUS

		Dealer Price	Retail Price
606	REFACE & polish 4 rocker arms	call us	104.00
608	TC CAM Support plate bushing replacement (labor only)	call us	62.00