

# Hammer Performance

355 McGhee Road  
Sandpoint, ID. 83864

Phone # (208)696-1250 <http://www.hammerperf.com>

# Estimate

Date	Estimate #
5/3/2024	13027

Name / Address

Project

Item	Description	Qty	Rate	Total
	1994-1997 XL883 110+hp 1275 Conversion, sans air cleaner and exhaust			
XL/Buell 1275 Ki...				
3.596 Silver 86-...	Silver 3.596 Cylinder, 86-03	2	153.155	306.31T
HP 3600 XL30D...	HP 3600 XL30D5FS 3.600 30 Degree .500 Dome Piston, Full Skirt, Thermal Barrier Coating	2	199.975	399.95T
C10096-3625	Cometic 91-03 Top End Gasket Kit .030 3.625 Head Gasket	1	113.74	113.74T
Cylinder Honing	Hone cylinder (each)	2	45.00	90.00
	XL/Buell 1275 kit, Silver, 86-03			910.00
	The above engine kit has silver small fin cylinders included (correct fin style for 86-03 bikes). The cylinders are also available in straight black (same price) or black with highlighted fins (\$50 additional). The above also includes the optional upgrade to a Cometic EST full top end gasket set, which is recommended. Without this upgrade, the kit comes with head and base gaskets only and sells for \$850			
Ring Gap and Pi...	Gap Rings and Assemble Pistons and Rings into Cylinders (pair)	1	50.00	50.00
	This is our optional preassembly service. We precision gap your rings using our high-end gapping machine which does a perfect job every time, and then we assemble the pistons and rings into the cylinders and ship them in sealed plastic bags, ready for installation. This service greatly simplifies installation and eliminates the need for any special tools on your end.			

<b>Subtotal</b>		
<b>Sales Tax (0.0%)</b>		
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Sledge Head Se...		1		
AV1980-7TGB	1.980 Intake 7MM 4.455 TG	2	30.00	60.00T
AV1610-7TGB	1.610 Exhaust 7MM 4.555 TG	2	26.00	52.00T
VG6601	7 MM +.001 Intake Valve Guide	2	13.00	26.00T
VG6701	7 MM +.001 Exhaust Valve Guide	2	13.00	26.00T
V7MM-100	7MM Valve Guide Seal, for larger springs and lower collar, pack of 100	0.04	250.00	10.00T
Sledge Head Po...	7MM Sledge Head Porting	1	887.55	887.55T
	Sledge Head Porting Service 7mm			1,061.55
	As part of the SLEDGE porting service, we set up the valves to work properly with the cams below, and we also size your chambers to work with the 30 degree pistons in the above 1275 kit.			
VSK6500S-7SG	Beehive Valve Spring Kit, 7MM Valves, 650 Lift, With Locks, Lower Collars, and Retainers This is the premium spring pack which is standard with the SLEDGE head service and can handle up to .650 lift and is safe to 8000+rpm.	1	138.45	138.45T
Angled Squish B...	Cut Angled Squish Band (each) This is the machining operation that makes the chambers match the trick 30 degree reverse dome pistons in the above engine kit. We throw this in for free when someone buys both an engine kit and head work.	2	0.00	0.00T
898562	XL 600 Lift Crush Hammer Performance Cam Set, 91-99	1	495.00	495.00T

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HP45PG	Bronze Oil Pump Gear, Sportster/Buell	1	128.99	128.99T
Grindlock-9199	Pinion Gear Locking Tool, 1991-1999 XL, With Mounting Bolts	1	50.00	50.00T
	XL's use a steel oil pump drive gear that becomes failure prone at higher power levels, and when it fails, it's really ugly. This was an especially bad problem with Buells due to their higher power levels, and HD finally came out with this bronze drive gear in 2006 to solve the problem, but they never put it in XL's. It's a nice upgrade when hopping up an XL, especially if you're in the cam box for a cam swap anyway, and it's cheap insurance against a catastrophic failure. The locking tool listed is necessary for proper installation.			
CY25263-90DFM	Cyco sportster cam cover gasket, 91-present	1	7.50	7.50T
HPFLXL 10.696...	91-03 XL Intake 10.696x.065x3/8 (-.050) Pushrod	2	14.875	29.75T
HPFLXL 10.750...	91-03 XL Exhaust 10.750x.065x3/8 (-.050) Pushrod	2	14.875	29.75T
	Corrections to the valvetrain geometry that we'll make as a part of setting up your heads for the cams, in combination with the thinner gaskets used to create a tighter squish clearance, create the need for somewhat shorter pushrods. These are high quality .065" wall heat treated chrome moly pushrods with Mae West ends. You cannot buy a finer pushrod.			
0927-0015	S&S Roller Rocker Arms, 1986-up XL, set of four	1	652.95	652.95T
90-4036	S& S Rocker Shaft Set	1	50.95	50.95T

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	Roller rockers are normally used at this valve lift to reduce side loading on the valve. You can use your stock rockers however you'll get somewhat shorter valve guide life. Rocker shafts are recommended because they are a high wear item.			
BTX-11	Energy One Extra Plate Clutch Kit, 1991 - Later Sportster, with 15% Stronger Diaphragm Spring	1	209.95	209.95T
DS197026	Clutch Compression Tool, Motion Pro, 90-97 Big Twin and 91+ XL	1	71.99	71.99T
CY34955-89FM	Cyco 91-03 sportster primary gasket This is a high quality rubber-coated steel primary gasket	1	18.00	18.00T
2101-0045	Dyna 2000 Digital Ignition Module, Single or Dual Fire, W/ 8 Pin, 94-97 XL	1	264.43	264.43T
2102-0226	Single Fire Coil, Drag Specialties, 2.4 ohm	1	61.95	61.95T
TM45-2	Mikuni HSR 45 mm Carburetor	1	438.95	438.95T
34-0834	Mikuni to CV carb air box adapter	1	33.71	33.71T
HPXL4503C NMXL 4503C	Billet Intake Manifold, HSR45/CV44, 88-06 XL, for Carb type heads	1	187.38	187.38T
42/45 Billet Mani...	42/45 Billet Manifold Finishing	1	22.22	22.22
DS173538	45MM/44MM Manifold Seal Ring	1	10.40	10.40T
	Billet Intake Manifold, HSR45/CV44, 88-06 XL, for Carb type heads			220.00

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2401-0869	12 MM Spark Plug Index Washers	1	24.95	24.95T
27794-08	10R12X Spark Plug	2	6.95	13.90T
80312	Red Line Assembly Lube, 4 OZ	1	13.95	13.95T
Shipping and Ha...	Shipping and Handling TBD		0.00	0.00T

This estimate represents a proposal by HAMMER PERFORMANCE. Please verify all items are correct before proceeding with your order.	<b>Subtotal</b>	\$4,976.67
	<b>Sales Tax (0.0%)</b>	\$0.00
	<b>Total</b>	\$4,976.67