



Hammer Performance

355 McGhee Road
Sandpoint, ID. 83864

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

Estimate

Date	Estimate #
4/1/2021	10633

Name / Address

Project

Item	Description	Qty	Rate	Total
	2004-2006 XL883 80+hp 1275 Conversion, sans air cleaner and exhaust			
XL/Buell 1275 Ki...				
3.596 Silver 04 ...	Silver 3.596 Cylinder, 04 Later	2	181.475	362.95T
HP 3600 30DD6...	HP 3600 30DD61FS 3.600 30 Degree 10.5-1 Piston With Reverse Dome, 61 CC Chamber, Full Skirt, Thermal Barrier Coating	2	179.975	359.95T
Cylinder Honing C10095-3625	Hone cylinder and fit piston (each) Cometic 04-06 Top End Gasket Kit .030 3.625 Head Gasket	2	45.00	90.00T
	XL/Buell 1275 kit, Silver, 04- Later XL/ Buell The above engine kit has silver big fin cylinders included (correct fin style for 2004-up bikes). The cylinders are also available in straight black or black with highlighted fins, same price. 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 \$875	1	102.10	102.10T
Ring Gap and Pi...	Gap Rings and Assemble Pistons and Rings into Cylinders (pair)	1	50.00	50.00
				915.00

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	Sales Tax (0.0%)
	Total



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	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.			
Competition Val...	Competition Valve Job (per head, does not include guides or seals)	2	175.00	350.00
VG6601	7 MM +.001 Intake Valve Guide	2	13.00	26.00T
VG6701	7 MM +.001 Exhaust Valve Guide	2	13.00	26.00T
V7MMOE-100	7 MM Valve Guide Seal, Viton, pack of 100	0.04	250.00	10.00T
	As part of the Competition Valve Job, we set up the valves to work properly with the IMPACT 560 cams, and we also size your chambers to work with the pistons in the above 1275 kit.			
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 1275 kit. We throw this in for free when you buy an engine kit and head work together.	2	0.00	0.00T
898560-00	XL 560 lift Impact Hammer Performance Cam Set, 00-Later This advanced cam set has a special lobe design to minimize valvetrain noise while still producing impressive power gains.	1	350.00	350.00T

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HP45PG	Bronze Oil Pump Gear, Sportster/Buell	1	98.00	98.00T
Grindlock-2000	Pinion Gear Locking Tool, 2000- Later 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's, 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	1	5.50	5.50T
	This high quality gasket is rubber-coated steel construction			
HPFLXL 10.676...	04/Buell XB Intake Pushrod 10.676x.065x3/8 (-.050)	2	14.875	29.75T
HPFLXL 10.730...	04/Buell XB Exhaust Pushrod 10.730x.065x3/8 (-.050)	2	14.875	29.75T
	Corrections to the valvetrain geometry that we'll make as a part of setting up your heads for the IMPACT 560 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.			

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BTX-11	Energy One Extra Plate Clutch Kit, 1991 - Later Sportster, with 15% Stronger Diaphragm Spring Clutch Compression Tool, Motion Pro, 90-97 Big Twin and 91+ XL This is the complete clutch upgrade package, which not only upgrades the 883's weak clutch spring to handle the conversion, but also replaces the entire clutch pack and eliminates the embedded compensator plate that's so prone to failure.	1	164.95	164.95T
DS197026		1	70.00	70.00T
CY34955-04FM	Cyco 2004-up sportster primary gasket This is a high quality rubber-coated steel primary gasket	1	12.00	12.00T
1009	Twin Tec TC88A Adjustable Ignition Module, 04-06 Sportster/Twin cam single 12 pin Because the the 1275 brings more compression and a more efficient chamber, the burn speeds considerably, necessitating less timing advance than stock. However, the timing is not adjustable on an 04-06 model. The solution is an aftermarket ignition module. The above is the best one we've come across. Set it on initial 2, slope 0, and your motor will be happy.	1	358.00	358.00T
DS289326	185 CV Main Jet, 5 pack	0.2	22.50	4.50T
DS289318	45 Pilot CV/ Keihin Carb, 5 pack	0.2	29.75	5.95T

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	In addition to addressing ignition timing with the module, you also need to increase fuel delivery when doing a conversion. The above jets should make a good starting point. In addition to changing these jets, we recommend you access the idle mixture screw, on the underside of the carb near the outlet, and set it at 3 turns out from lightly seated.			
27794-08	10R12X Spark Plug	2	5.95	11.90T
80312	Red Line Assembly Lube, 4 OZ	1	9.95	9.95T
Shipping and Ha...	Shiping and Handling TBD		0.00	0.00T

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	Sales Tax (0.0%)	\$0.00
	Total	\$2,577.25