



# Hammer Performance

355 McGhee Road  
Sandpoint, ID. 83864

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

# Estimate

Date	Estimate #
4/1/2021	10645

Name / Address

				Project
Item	Description	Qty	Rate	Total
	1998-1999 XL883 120+hp 1275 Conversion, sans air cleaner and exhaust			
XL/Buell 1275 Ki...				
3.596 Silver 86-...	Silver 3.596 Cylinder, 86-03	2	131.475	262.95T
HP 3600 XL30D...	HP 3600 XL30D5FS 3.600 30 Degree .500 Dome Piston, Full Skirt, Thermal Barrier Coating	2	179.975	359.95T
C10096-3625	Cometic 91-03 Top End Gasket Kit .030 3.625 Head Gasket	1	102.10	102.10T
Cylinder Honing	Hone cylinder and fit piston (each) XL/Buell 1275 kit, Silver, 86-03 The above engine kit has silver small fin cylinders included (correct fin style for 86-03-up bikes). The cylinders are also available in 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 \$775	2	45.00	90.00T 815.00
Ring Gap and Pi...	Gap Rings and Assemble Pistons and Rings into Cylinders (pair) 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.	1	50.00	50.00
This estimate represents a proposal by HAMMER PERFORMANCE. Please verify all items are correct before proceeding with your order.			<b>Subtotal</b>	
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BFH Head Servi...				
F0078	2.020 intake 7MM 4.400 SG	2	50.00	100.00T
F0077	1.630 Exhaust 7MM 4.440 SG	2	50.00	100.00T
VG6625	7 MM +.025 Intake Valve Guide	2	13.00	26.00T
VG6725	7 MM +.025 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	756.00	756.00T
Alter Valve Angles	Alter valve angles on XL heads	1	180.00	180.00T
Welding Intake ...	Weld Intake Port Floors (pair)	1	75.00	75.00T
Hand Form Floors	Hand Form Intake Port Floors (pair)	1	125.00	125.00T
	BFH Head Porting Service 7mm			1,398.00
	As part of the BFH porting service, we set up the valves to work properly with the cams below, and we also size your chambers to work with the pistons in the above 1275 kit.			
7MM Spring Kit ...				
7256-16	Conical Valve Springs, 1.060x.660 top, 1.390x.990 bottom, 184lbs@1.850, 1.160 coil bind, set of 16	0.25	336.00	84.00T
E12028	7MM Titanium Retainer, 600 Lift	4	20.00	80.00T
K10090	7MM Locks Single Groove (2 each)	4	4.25	17.00T
LSC6000-4	AV&V Seat Locator, 600 Lift Beehive Spring - pack of 4	1	17.00	17.00T
	Striker Performance 7MM Valve Spring Kit 600 Lift Single Groove Locks			198.00
	This conical spring pack represents the latest in high performance spring development. The valvetrain is stable to at least 8000rpm.			

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898562	XL 600 Lift Crush Hammer Performance Cam Set, 91-99 This advanced cam set has a special lobe design to minimize valvetrain noise while still producing impressive power gains.	1	350.00	350.00T
HP45PG	Bronze Oil Pump Gear, Sportster/Buell	1	98.00	98.00T
Grindlock-9199	Pinion Gear Locking Tool, 1991-1999 XL, With Mounting Bolts 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.	1	50.00	50.00T
CY25263-90DFM	Cyco sportster cam cover gasket This high quality gasket is rubber-coated steel construction	1	5.50	5.50T
HPFLXL 10.696...	91-03 XL Intake Pushrod 10.696x.065x3/8 (-.050)	2	14.875	29.75T
HPFLXL 10.750...	91-03 XL Exhaust Pushrod 10.750x.065x3/8 (-.050)	2	14.875	29.75T

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	Corrections to the valvetrain geometry that we'll make as a part of setting up your heads for the cams above, 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.			
0927-0028	S&S 1.725 ratio Roller Rocker Arms, set of 4	1	628.95	628.95T
90-4036	S& S Rocker Shaft Set Roller rockers are normally used at this valve lift to reduce side loading on the valve. We also use high ratio rockers to get more lift without creating additional cam box clearance issues. Rocker shafts are recommended because they are a high wear item.	1	38.95	38.95T
BTX-11	Energy One Extra Plate Clutch Kit, 1991 - Later Sportster, with 15% Stronger Diaphragm Spring	1	164.95	164.95T
DS197026	Clutch Compression Tool, Motion Pro, 90-97 Big Twin and 91+ XL	1	70.00	70.00T
CY34955-89FM	Cyco 91-03 sportster primary gasket This is a high quality rubber-coated steel primary gasket	1	12.00	12.00T
48-2X	Mikuni 48mm Carburetor, Standard Finish	1	459.95	459.95T
34-0834	Mikuni to CV carb air box adapter	1	21.95	21.95T
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HPXL4803C ASWXL 4803C	Billet Intake Manifold, HSR48, 88-06 XL, for Carb type heads	1	165.28	165.28T
48 Billet Manifold...	48 Billet manifold Finishing	1	37.72	37.72
29539-99Y	48 MM Manifold Seal Ring	1	17.00	17.00T
	Billet Intake Manifold, HSR48, 88-06 XL, for Carb type heads			220.00
2101-0027	Dyna 2000I PC Programmable Ignition Module	1	273.99	273.99T
2102-0226	Single Fire Coil, Drag Specialties, 2.4 ohm	1	85.95	85.95T
2401-0869	12 MM Spark Plug Index Washers	1	22.19	22.19T
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...	Shipping and Handling TBD		0.00	0.00T

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	<b>Sales Tax (0.0%)</b>	\$0.00
	<b>Total</b>	\$5,044.73