

# Hammer Performance

355 McGhee Road  
Sandpoint, ID. 83864

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

# Estimate

Date	Estimate #
2/26/2017	5702

Name / Address

			Project
Description	Qty	Rate	Total
2004-2006 XL883 80+hp 1275 Conversion, sans air cleaner and exhaust			
Silver 3.596 Cylinder, 04 Later	2	143.95	287.90T
HP 3600 30DD61 3.600 30 Degree 10.5-1 Piston With Reverse Dome, 61 CC Chamber	2	154.975	309.95T
Hone cylinder and fit piston (each)	2	45.00	90.00T
Cometic 04-06 Top End Gasket Kit .030 3.625 Head Gasket XL/Buell 1275 kit, Silver, 04- Later XL/ Buell	1	102.10	102.10T
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 \$749.95			789.95
Gap Rings and Assemble into Pistons 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	40.00	40.00T
Competition Valve Job (per head, does not include guides or seals)	2	100.00	200.00T
7 MM +.001 Exhaust Valve Guide	2	13.00	26.00T
		<b>Subtotal</b>	
		<b>Sales Tax (0.0%)</b>	
		<b>Total</b>	

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7 MM +.001 Exhaust Valve Guide	2	13.00	26.00T
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.			
Cut Angled Squish Band (each)	2	0.00	0.00T
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.			
XL 560 lift Impact Hammer Performance Cam Set, 00-Later	1	325.00	325.00T
This advanced cam set has a special lobe design to minimize valvetrain noise while still producing impressive power gains.			
Bronze Oil Pump Gear/Buell, Sportster	1	98.00	98.00T
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, 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.			
Cyco sportster cam cover gasket	1	5.50	5.50T
This high quality gasket is rubber-coated steel construction			
		<b>Subtotal</b>	
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04/Buell XB Intake Pushrod 10.676x.065x3/8 (-.050)	2	14.875	29.75T
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.			
Energy One Extra Plate Clutch Kit, 1991 - Later Sportster, with 15% Stronger Diaphragm Spring	1	145.95	145.95T
Clutch Compression Tool, Motion Pro, 90-97 Big Twin and 91+ XL		70.00	70.00T
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.			
Cyco 2004-up sportster primary gasket	1	12.00	12.00T
This is a high quality rubber-coated steel primary gasket			
Twin Tec Adjustable Ignition Module, 04-06 Sportster/Twin cam single 12 pin	1	331.00	331.00T
		<b>Subtotal</b>	
		<b>Sales Tax (0.0%)</b>	
		<b>Total</b>	

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<p>Because the the 1250 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.</p> <p>185 CV Main Jet 45 Pilot CV/ Keihin Carb.</p> <p>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.</p> <p>Box 1, engine kit and parts, Shipping and Handling with insurance Box 2, heads, Shipping and Handling with insurance We'll add the actual ship charges above based on your location</p>	1	3.95 3.95	3.95T 3.95T
		0.00	0.00T
		0.00	0.00T
		<b>Subtotal</b>	\$2,196.80
		<b>Sales Tax (0.0%)</b>	\$0.00
		<b>Total</b>	\$2,196.80