

Hammer Performance

355 McGhee Road
Sandpoint, ID. 83864

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

Estimate

Date	Estimate #
7/20/2025	14091

Name / Address

				Project
Item	Description	Qty	Rate	Total
	1991-1993 XL883 80+hp 1275 Conversion, sans air cleaner and exhaust			
XL/Buell 1275 Ki...				
3.596 Silver 86-...	Silver 3.596 Cylinder, 86-03	2	157.525	315.05T
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	207.50	415.00T
C10096-3625	Cometic 91-03 Top End Gasket Kit .030 3.625 Head Gasket	1	124.95	124.95T
Cylinder Honing	Hone cylinder (each)	2	45.00	90.00
	XL/Buell 1275 kit, Silver, 86-03			945.00
	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
			Subtotal	
			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
VG5601	5/16 +.001 Intake Valve Guide	2	13.00	26.00T
VG5701	5/16 +.001 Exhaust Valve Guide	2	13.00	26.00T
V312531-100	5/16 Valve Guide Seal, Viton, pack of 100	0.04	200.00	8.00T
	The Competition Valve Job is essentially half a porting job when done on 883 heads, and it goes right to the heart of the big big problem with 883 heads which is how the big bowls neck down to small valves sitting on poorly blended seats. So the heads REALLY respond well to this service. As part of the service, we'll size your chambers for 10.5:1 compression with the pistons in the 1275 kit.			
Angled Squish B...	Cut Angled Squish Band (each)	2	0.00	0.00
	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.			
DS199196	Andrews N4 Cam Set, 91-99 XL, 94-99 Buell	1	504.95	504.95T
			Subtotal	
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	This is the best bolt-in cam set for this generation of bikes.			
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	10.50	10.50T
	This high quality gasket is rubber-coated steel construction			
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
2101-0043	Dyna 2000 Digital Ignition Module, Single or Dual Fire, W/ 7 Pin, 91-93 XL	1	269.72	269.72T
DS289318	45 Pilot CV/ Keihin Carb, 5 pack	0.2	29.75	5.95T
DS289326	185 CV Main Jet, 5 pack	0.2	29.75	5.95T
			Subtotal	
			Sales Tax (0.0%)	
			Total	

