

”z ORDER FORM – CYLINDER HEAD OVERHAUL

Please complete, sign and enclose with the cylinder head

) CUSTOMER DETAILS

Name

Email _____

Telephone _____ number:

;~2” – VEHICLE DATA

Model: _____ Year of manufacture: _____

☐ Not known

Has the cylinder head been overhauled? ☐ Yes ☐ No

If yes, please tick which work has been carried out:

☐ Lead removal ☐ Valve guides replaced

☐ Valve seats replaced: ☐ Intake ☐ Exhaust

☐ Cylinder head surface-milled: ☐ Cylinder side ☐ Valve cover side

☐ I can't say, or I'm not sure

◆ Scope of cylinder head overhaul (included in the base price)

- Cleaning in the parts cleaning system
- Disassemble heads C inspection
- Removing the valve guides
- Precision honing of base bores for guides
- Shrink-fit guides and hone to final dimensions
- Removing outlet seat rings (on ML/TS models)
- Milling basic bores for valve seat ring (for ML/TS models)
- Shrink fit new valve seat ring (for ML/TS models)
- Milling all valve seat contours (SERDI 100)
- Install new valves C springs
- Perform vacuum test to check valve tightness
- Assemble all components
- Includes parts package

◆ Optional additional work

Please tick the desired options

Important note: Prices are for a pair of cylinder heads, except for repairs to spark plug threads, valve cover studs and exhaust threads.

<input type="checkbox"/>	Blasting cylinder heads with ceramic balls (price per pair)	50 €
<input type="checkbox"/>	Highly recommended: valve guides with shaft seals Note: BMW 2-valve cylinder heads were built without valve stem seals. A certain amount of oil consumption was normal, and overhaul intervals of 25,000 km were common. We have developed valve guides with stem seals for BMW 2V boxer engines. They reduce oil consumption and extend the wear limit. (including materials)	40 €
<input type="checkbox"/>	Adjusting the combustion chamber for a displacement increase to 1000 cc Note: We recommend planning both sealing surfaces before adjusting the combustion chamber. If one surface is warped, the faulty contour will otherwise be transferred to the combustion chamber.	145 €
<input type="checkbox"/>	Adjust combustion chamber for displacement increase to 1070 cc Note: We recommend planning both sealing surfaces before adjusting the combustion chamber. If one surface is warped, the incorrect contour will otherwise be transferred to the combustion chamber.	145 €
<input type="checkbox"/>	Face milling on the cylinder side Note: The valve cover side of the cylinder head is often warped. Since the head rests on this surface when the cylinder side is planed, the deformation is transferred. Therefore, the surface for the valve cover should be planed first, followed by the surface for the cylinder. For best results, always face-mill both surfaces.	85 €
<input type="checkbox"/>	Face milling on the valve cover side Note: The valve cover side of the cylinder head is often warped. Since the head rests on this surface when the cylinder side is being planed, the deformation is transferred. Therefore, the surface facing the valve cover should be planed first, followed by the surface facing the cylinder. For best results, always face both surfaces.	85 €
<input type="checkbox"/>	Replace threaded studs: <input type="checkbox"/> on the right <input type="checkbox"/> on the left Note: The cylinder head is clamped onto the milling machine so that the stud bolt is positioned at a right angle to the flat surface. (including materials)	29€ / head
<input type="checkbox"/>	Repair spark plug threads: <input type="checkbox"/> right <input type="checkbox"/> left (including materials)	79€ / head

<input type="checkbox"/>	Repair exhaust thread: <input type="checkbox"/> right <input type="checkbox"/> left	205€ / head
<input type="checkbox"/>	Conversion to 8 mm valve guides (R45/R65) (including materials)	120 €
<input type="checkbox"/>	Enlarge exhaust valve R80/R100 cylinder heads (40 mm) (including materials)	80 €
<input type="checkbox"/>	Enlarge intake valve R80/R100 cylinder heads (44 mm) (including materials)	110 €
<input type="checkbox"/>	Cylinder chamber capacity measurement and adjustment	185 €
<input type="checkbox"/>	Drill second spark plug hole for dual ignition C Cut thread	190 €
<input type="checkbox"/>	Replace tappet protection tubes (stainless steel) in cylinder head (including materials)	139 €

Overtime: We will automatically carry out additional work up to 10% of the order value without prior consultation.

Q.5/ SIGNATURE

Place/date: _____ **Customer signature:** _____

• Please enclose this completed form with the cylinder head.