

## ORDER FORM – CYLINDER HEAD OVERHAUL

Please complete, sign and enclose with the cylinder head

### Customer Details

Name: \_\_\_\_\_

E-Mail: \_\_\_\_\_

Phone number : \_\_\_\_\_

### VEHICLE DATA

Model: \_\_\_\_\_ Year of Manufacture: \_\_\_\_\_

Can old parts be disposed of?  Yes  No

Has the cylinder head already been overhauled?  Yes  No  unknown

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

- Lead-free conversion  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 services for cylinder head overhaul (included in the base price)

- Cleaning in the parts cleaning system
- Disassembly of heads & inspection
- Removal of 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 the base holes for the 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 & springs
- Perform vacuum test to check valve tightness
- Assemble all components
- Includes parts package

◆ **Optional additional work**

**Please check the desired options**

**Important note: The prices apply to a pair of cylinder heads, except for repairs to spark plug threads, valve cover studs, and exhaust threads**

<input type="checkbox"/>	Cylinder heads with ceramic balls blasting	50 € / pair
<input type="checkbox"/>	<p><b>Highly recommended: Valve guides with shaft seals</b></p> <p><b>Note:</b> 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 boxers. They reduce oil consumption and extend the wear limit. (Material included)</p>	40 € / pair
<input type="checkbox"/>	<p>Adjust combustion chamber for displacement increase 1000 cc</p> <p><b>Note:</b> 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.</p>	190 € / pair
<input type="checkbox"/>	<p>Adjust combustion chamber for displacement increase to 1070 cc</p> <p><b>Note:</b> 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.</p>	190 € / pair
<input type="checkbox"/>	<p>Face milling on the cylinder side</p> <p><b>Note:</b> 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 both surfaces.</p>	85 € / pair
<input type="checkbox"/>	<p>Face milling on the valve cover side</p> <p><b>Note:</b>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, it is always best to plane both surfaces.</p>	85 € / pair
<input type="checkbox"/>	<p>Renew stud bolt threads: <input type="checkbox"/> right <input type="checkbox"/> left</p> <p><b>Note:</b> The cylinder head is clamped onto the milling bench for this so that the stud bolt is correctly at right angles to the flat surface  (Material included)</p>	29 € / Head

<input type="checkbox"/>	Repair spark plug threads: <input type="checkbox"/> right <input type="checkbox"/> left (Material included)	79 € / Head
<input type="checkbox"/>	Repairing exhaust threads: <input type="checkbox"/> right <input type="checkbox"/> left (Material included)	205 € / Head
<input type="checkbox"/>	Conversion to 8 mm valve guides (R45/R65) (Material included)	120 € / pair
<input type="checkbox"/>	Enlarge exhaust valve R80/R100 cylinder heads (40 mm) (Material included)	80 € / pair
<input type="checkbox"/>	Enlarge intake valve R80/R100 cylinder heads (44 mm) (Material included)	110 € / pair
<input type="checkbox"/>	Measuring and adjusting combustion chambers	185 € / pair
<input type="checkbox"/>	Drill second spark plug hole for dual ignition & Cut thread	190 € / pair

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

 **SIGNATURE**

Place/Date: \_\_\_\_\_ Customer signature: \_\_\_\_\_

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 **Please enclose this completed form with the cylinder head.**