

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

☐	Cylinder heads with ceramic balls blasting	50 € / pair
☐	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 boxers. They reduce oil consumption and extend the wear limit. (Material included)	40 € / pair
☐	Adjust combustion chamber for displacement increase 1000 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.	190 € / pair
☐	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.	190 € / pair
☐	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 both surfaces.	85 € / pair
☐	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 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.	85 € / pair
☐	Renew stud bolt threads: ☐ right ☐ left Note: 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)	29 € / Head

☐	Repair spark plug threads: ☐ right ☐ left (Material included)	79 € / Head
☐	Repairing exhaust threads: ☐ right ☐ left (Material included)	205 € / Head
☐	Conversion to 8 mm valve guides (R45/R65) (Material included)	120 € / pair
☐	Enlarge exhaust valve R80/R100 cylinder heads (40 mm) (Material included)	80 € / pair
☐	Enlarge intake valve R80/R100 cylinder heads (44 mm) (Material included)	110 € / pair
☐	Measuring and adjusting combustion chambers	185 € / pair
☐	Drill second spark plug hole for dual ignition & Cut thread	190 € / pair
☐	Replace tappet protection tubes (stainless steel) in cylinder head (Material included)	139 € / pair

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

 **SIGNATURE**

Place/Date: _____ **Customer signature:** _____

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