



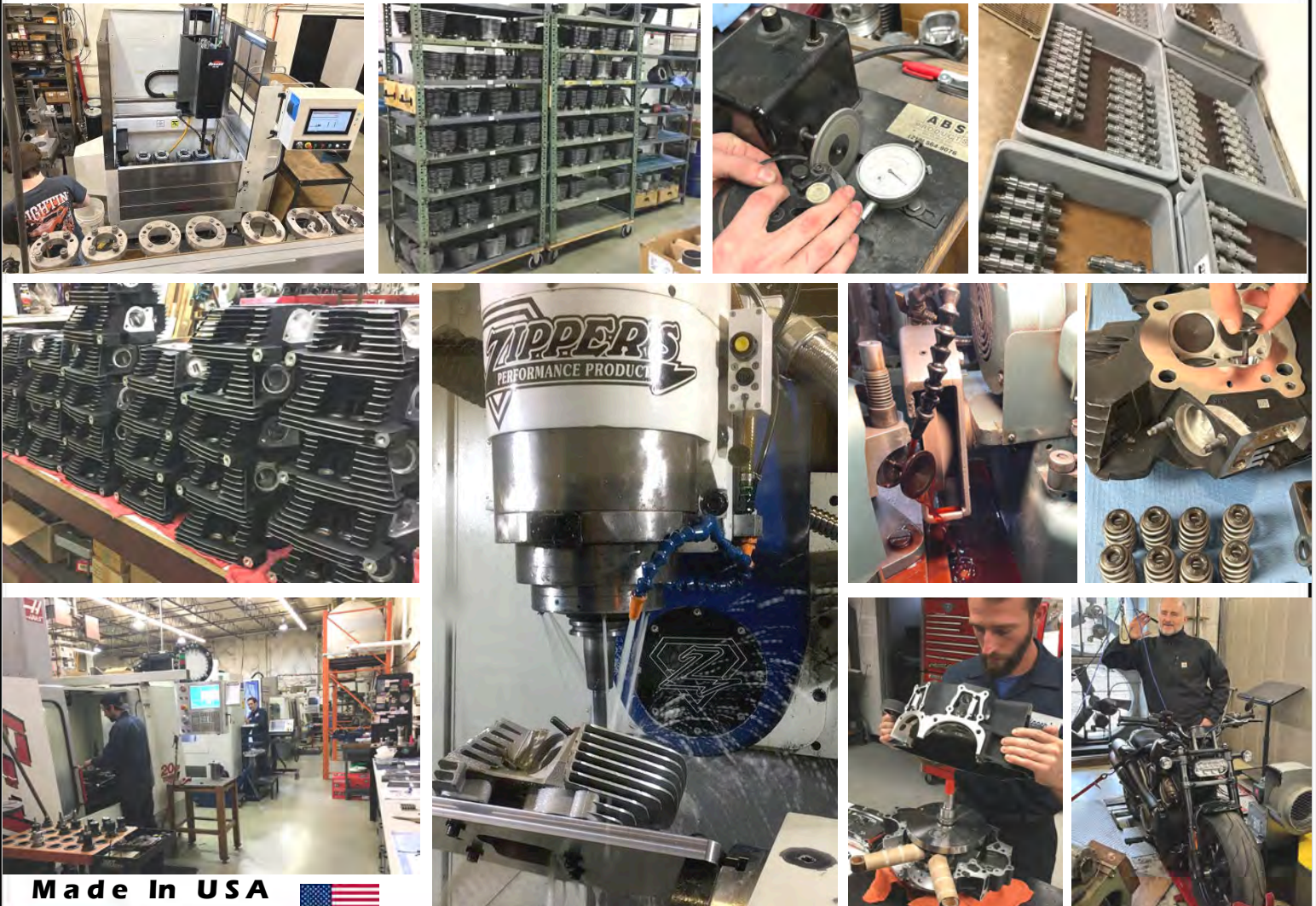
**NEW!**  
2<sup>ND</sup> Generation  
M8 Kits!

Updated  
For  
**2025!**

# ENGINE KITS

**From humble beginnings in a converted backyard shed,** Zipper's was officially incorporated in 1981 and used results from the race track to build our reputation for fast, reliable engines. In the 43+ years since then, Zipper's mission has been to provide the highest level of performance through the use of quality equipment and the best available components, and most importantly, staffing Zipper's with the best in the business to execute this plan. Zipper's has, and continues to, invest in the highest quality CNC automation and manufacturing techniques to accurately reproduce the components and results we develop through thorough extensive research & development testing.

**Buy with confidence from a small company that has always produced big results!**



**Made In USA**



**Zipper's Performance Products**  
Elkridge, MD, 21075 - USA  
Phone: (410) 579-2828

[www.ZippersPerformance.com](http://www.ZippersPerformance.com)  
[Zippers@ZippersPerformance.com](mailto:Zippers@ZippersPerformance.com)

Products on this page are not  
for sale or use on pollution  
controlled vehicles.



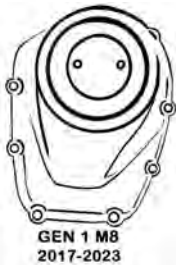


# RED SHIFT

# M8-G1 CAM ZIP KITS

**On an M8, our Step 1 modification for the biggest bang for your buck is a cam change!** Both the TC and M8 engines respond very favorably to a cam change, so we've put some kits together that include our most popular Zipper's-engineered Red Shift Cams® and the components you'll need for a successful cam change with upgrades. Dyno charts reflect the most popular applications shown here; you can view more on our web site with a scan of the QR codes with your phone.

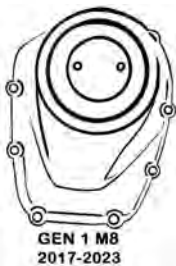
**Red Shift Cams® Zip Kits for G1 Milwaukee Eight® Engines**  
**All 1<sup>st</sup> generation (G1) 2017-2023 M8 kits** include Red Shift Cams®, cam bearing, Delphi® USA lifters, quikee pushrods and chrome or black EZ-adjust covers and gaskets needed for assembly.



## Red Shift G1 M8 468 Cam Zip Kit

The wildly popular Red Shift Cams® 468 bolt-in grind was developed to produce the best power for 107, 114 and 117" 1<sup>st</sup> Generation M8 engines. The RS468 delivers significant improvements in power and throttle response right where you ride. The Red Shift 468 is designed to complement the M8's high intake flow while its unique design overcomes the restrictive exhaust port for big gains in both torque and horsepower. The RS468 provides instant acceleration below 2,000 RPM while pulling strong to 6,000 – this cam really shines in the primary 2,000-4,000 RPM cruising range!

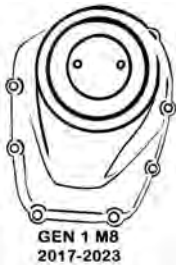
Part# 517-318 w/chrome covers      Part# 517-318B w/black covers



## Red Shift G1 M8 472 Cam Zip Kit

The Red Shift Cams® 472 was designed to shift power a little to the right of the RS468 in the same applications. It works great with either the factory valve train components or modified / ported heads with upgraded spring and valve combinations. Proprietary Red Shift Cams® ramp design delivers quiet operation and long valve train life. The RS472 cam is also widely used to improve SE engine upgrade kits, and many aftermarket big bore kits including 124 & 128's. If you are looking for a significant torque boost in the 2000-4500 RPM range, an excellent choice is the RS472 cam!

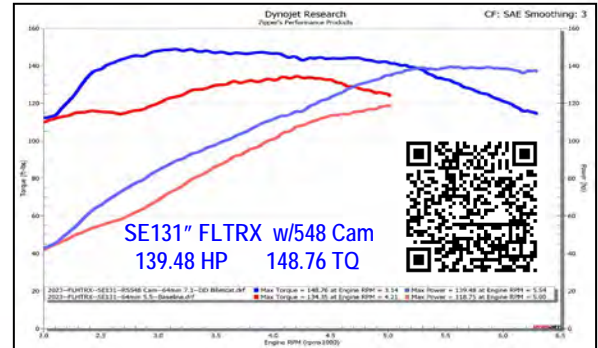
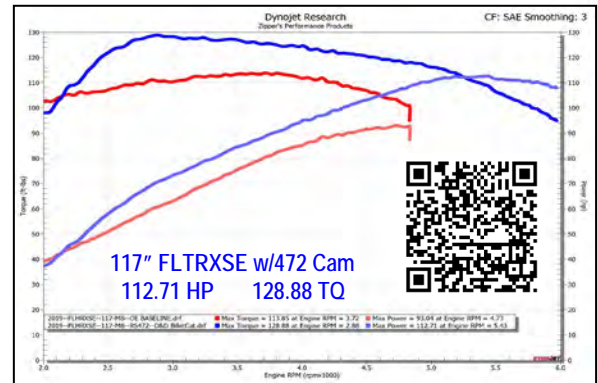
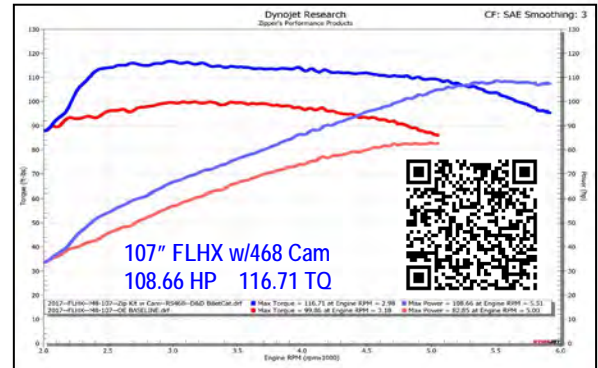
Part# 517-319 w/chrome covers      Part# 517-319B w/black covers



## Red Shift G1 M8 548 Cam Zip Kit

Popular bolt-in upgrade to SE131/135 engines and others. The Red Shift 548 produces huge low-mid torque, while still producing big power over the entire RPM range in modified engines. The RS548 is the early-torque favored companion to the extremely successful RS 552 cam for 124 & larger engines. Check the RS Cam Matrix on our web site for additional data on cam selection for popular applications. *The 548 Cam Zip Kit includes tappet cuffs due to .550" lift.*

Part# 517-331 w/chrome covers      Part# 517-331B w/black covers



**Zipper's Performance Products**  
 Elkridge, MD, 21075 - USA  
 Phone: (410) 579-2828

www.ZippersPerformance.com  
 Zippers@ZippersPerformance.com

Products on this page are not for sale or use on pollution controlled vehicles.



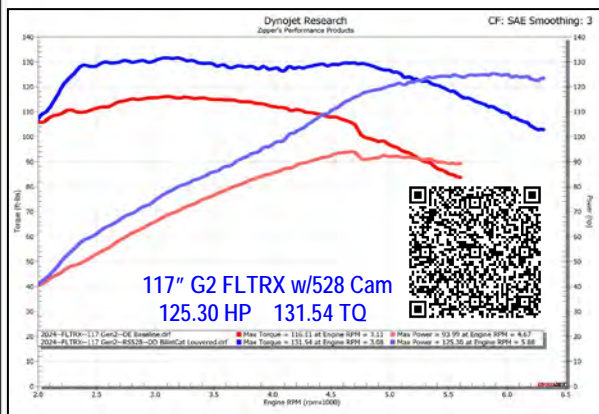


# RED SHIFT

# M8-G2 CAM ZIP KITS

Red Shift Cams® Zip Kits for G2 Milwaukee Eight® Engines

All 1<sup>st</sup> generation (G2) 2024-up (Helix engine) M8 kits for 117" and larger engines include Red Shift Cams®, Delphi® USA lifters, tappet cuffs, quikee pushrods and chrome or black EZ-adjust covers and gaskets needed for assembly. All are "bolt-in" chain-drive cams with profiles designed for quiet operation with factory valve springs in the engines listed.

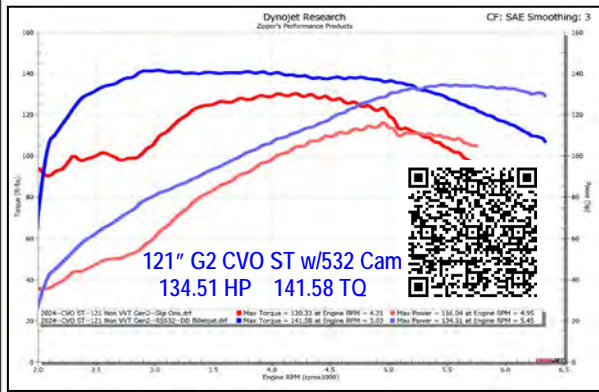


## Red Shift G2 M8 528 Zip Kit

The RS528 grind for 2<sup>nd</sup> generation Helix Model 117" M8's has been carefully designed and tested by Zipper's engineering to yield the best possible riding experience while producing the most Torque and Horsepower for a bolt-in camshaft. It works exceptionally well with the new ride modes available in the 2024-up Touring models. The RS528 cam provides the performance advantage in power and throttle response right where you ride, with a "drag bike" lobe at idle and impressive exhaust note under load. **This is THE Bolt-In Big Torque Cam for the new Generation II 117" Milwaukee-Eight® Engine!**



Part# 517-328 w/chrome covers      Part# 517-328B w/black covers



## Red Shift G2 M8 532 Cam Zip Kit

The RS532 grind for 2<sup>nd</sup> generation M8's is designed specifically for the higher compression, 121" High Output ST (non-VVT) engine with the G2 oval-port cylinder head and induction system. It provides instant acceleration from 2,000 RPM while pulling strong to 6,000. In the spirit of Red Shift early torque designs, this is the best bolt-in cam for the non-VVT 121" engines, providing the strongest overall balance of Huge Torque and Horsepower. Our proprietary Red Shift Cams® ramp design delivers quiet operation and long valve train life.



Part# 517-329 w/chrome covers      Part# 517-329B w/black covers

## Highly Recommended Option: Red Shift Dual Piston Tensioner & Drive System

The patented Red Shift dual piston, dual feed tensioners system and sprockets will help maintain the proper tension on the cam chain for more accurate valve timing. This system comes with stronger steel, tighter fitting drive gears designed to keep the chain centered up accurately on the tensioner. This revolutionary design using multiple hydraulic bodies is simple and effective, improving cam chain tension stability, hydraulic performance, and valve train control for a quieter, better running engine. This drive system works on all M8 engines except VVT models. Add this part number to your Zip Kit order! **Part # 413-801**



Zipper's Performance Products  
Elkridge, MD, 21075 - USA  
Phone: (410) 579-2828

www.ZippersPerformance.com  
Zippers@ZippersPerformance.com

Products on this page are not for sale or use on pollution controlled vehicles.





Zipper'sPerformance.com



# M8

# CYLINDER KITS



### Zipper's M8 Big Bore Kits are a Cut Above the Rest!

Some outfits sell M8 big bore kits where they source a finished-sized cylinder from one vendor and a piston from another. This will never happen at Zipper's. Our big bore cylinders are manufactured to our specs, with oversize cast iron liners and undersized bores. Our experience in sizing cylinders for a straight and true bore dictates that they are:

1. Torqued in a specific sequence for rough boring
2. Plated and roughed to undersize on a stout, rigid lathe
3. Torqued again in a specific sequence for final sizing
4. Each piston is measured with a micrometer
5. Each cylinder is honed to match the measured piston on our Sunnen SV-30 state of the art cylinder hone
6. Each cylinder is plateau-honed for superior ring seal
7. Rings are precision-fit to the piston manufacturer's spec
8. Shipped with instructions to duplicate the torque process

All of the above steps are performed at Zipper's - this way, you are assured of as straight and true bore as you can get.

**No 'Wham, Bam, Thank You Ma'am' here!**

Our experience building long-life road machines and championship racing engines is applied to every component we process. **You Can Count on it!**

### Zipper's Drop-On 4.250" Big Bore Cylinder Kits

include our proprietary cylinders, fitted forged piston kits complete with sized rings, pins & clips, head and base gaskets and new OE-style head bolts. Part numbers shown are for standard black finish; add 'G' to the P/N for CVO Granite finish. *Optional piston thermal coating is available.*

**PART NO. FOR 2024-UP 2<sup>nd</sup> GENERATION 117" M8 (4.5" stroke)**

# 517-871 128" w/-6.12cc dished pistons (11.15:1 w/stock G2 heads)

# 517-870 128" w/-2.8cc dished pistons (11.5:1 w/stock G2 heads)

# 517-872\* 128" w/+1.9cc domed pistons (use w/modified G2 heads)

*Compression estimates shown above assume .040" squish*

**PART NO. FOR 2017-2023 1st GENERATION 114 / 117" M8 (4.5")**

# 517-867 128" w/-6.12cc dished pistons (11.05:1w/stock G1 heads)

# 517-865 128" w/-2.8cc dished pistons (11.4:1 w/stock G1 heads)

# 517-863\* 128" w/+1.9cc domed pistons (use w/modified G1 heads)

*Compression estimates shown above assume .040" squish*

**PART NO. FOR 2017-2025 1st GENERATION 107" M8 (4.375" stroke)**

# 517-827 124" w/-5.5cc dished pistons (10.85:1 w/stock G1 heads)

# 517-825 124" w/+0cc flat top pistons (11.4:1 w/stock G1 heads)

# 517-826\* 124" w/+5.3cc domed pistons (use w/ modified G1 heads)

*Compression estimates shown above assume .040" squish*

*\*These part numbers include thermal coatings*



Zipper's Performance Products  
Elkridge, MD, 21075 - USA  
Phone: (410) 579-2828

www.Zipper'sPerformance.com  
Zipper's@Zipper'sPerformance.com

Products on this page are not for sale or use on pollution controlled vehicles.





Zipper'sPerformance.com

# ZIPPER'S

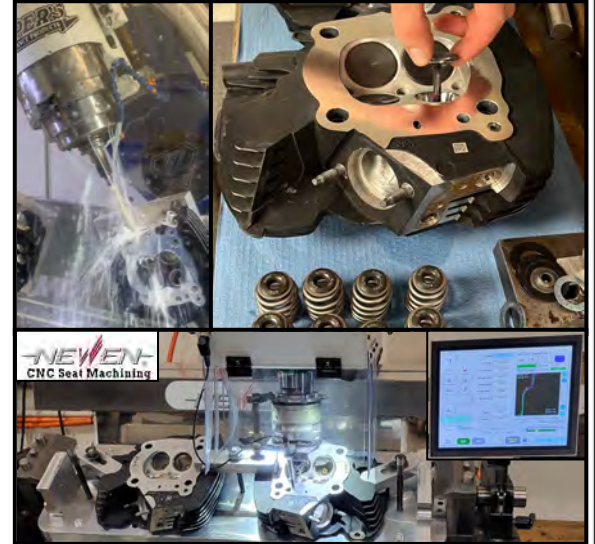
## PERFORMANCE PRODUCTS

THE POWER OF EXPERIENCE



# M8

# CNC HEADWORK



**While 4-valve M8 heads flow a lot of air in stock form, Big Gains are had with our Stages of modification!**

Heads are an important part of the performance equation, along with displacement, compression, cam timing, intake and exhaust flow, and more. We've spent a lot of time studying and developing our headwork stages and feel we can accommodate most applications and confidently meet your performance goals. All work is performed in-house at Zipper's, using state of the art equipment and a top-notch staff to execute it.

All M8 stages of headwork includes disassembly and soda blasting of ports and chambers, guide removal, then off to 5-axis CNC porting. Once the ports are reshaped for velocity and flow, new manganese bronze guides are installed and sized to new, high flow stainless valve stems. Seats are CNC machined to our proprietary shapes for big gains and blended to the ports. Valve heights are set to even heights for precise rocker arm contact, then the heads are decked for the calculated application compression ratio. Final assembly includes valve spring shimming to ensure proper pressures and travel for the application. Available for Gen 1 (2017-2023) & Gen 2 (2024-up) M8.

**GENERATION 2 (OVAL PORT) STAGE II HEADWORK** is available with 40mm intake / 32mm exhaust valves and factory valve springs that accommodate valve lifts up to .530", or include springs to accommodate .550" lift. These heads have delivered over 150 rear wheel HP & TQ in our G2 128" Sport/Tour kit with the stock throttle body/manifold!

**Part # 517-801** G2 Stage II Headwork f/.530" lift

**Part # 517-802** G2 Stage II Headwork f/.550" lift

**GENERATION 2 (OVAL PORT) STAGE III HEADWORK** is available with 41mm intake / 33mm exhaust valves with valve springs that accommodate valve lifts up to .610", with optional steel or titanium spring collars. These heads are used in our G2 Muscle kits.

**Part # 517-803S** G2 Stage III Headwork w/steel spring collars

**Part # 517-803T** G2 Stage III w/titanium spring collars

**GENERATION 1 (ROUND PORT) STAGE II HEADWORK** is available with 40mm intake / 32mm exhaust, factory valve springs up to .470". Great for big bore kits, used in our G1 128" Sport/Tour kit with upgraded valve springs.

**Part # 517-852** G1 Stage II Headwork f/.470" lift

Add **Part # 526-805** for use up to f/.580" lift cam

**GENERATION 1 (ROUND PORT) STAGE III HEADWORK** is available with 41mm intake / 33mm exhaust valves with valve springs that accommodate valve lifts up to .580", with optional steel or titanium spring collars. These heads are used in our G1 Muscle kits.

**Part # 517-853S** G2 Stage III Headwork w/steel spring collars

**Part # 517-853T** G2 Stage III w/titanium spring collars

**GENERATION 1 (ROUND PORT) STAGE IV HEADWORK** is available with 42mm intake / 34mm exhaust valves with valve springs that accommodate valve lifts up to .610", with optional steel or titanium spring collars. Used in our G1 Stage 4 Muscle kits.

**Part # 517-854S** G2 Stage III Headwork w/steel spring collars

**Part # 517-854T** G2 Stage III w/titanium spring collars



**Zipper's Performance Products**  
Elkridge, MD, 21075 - USA  
Phone: (410) 579-2828

www.Zipper'sPerformance.com  
Zipper's@Zipper'sPerformance.com

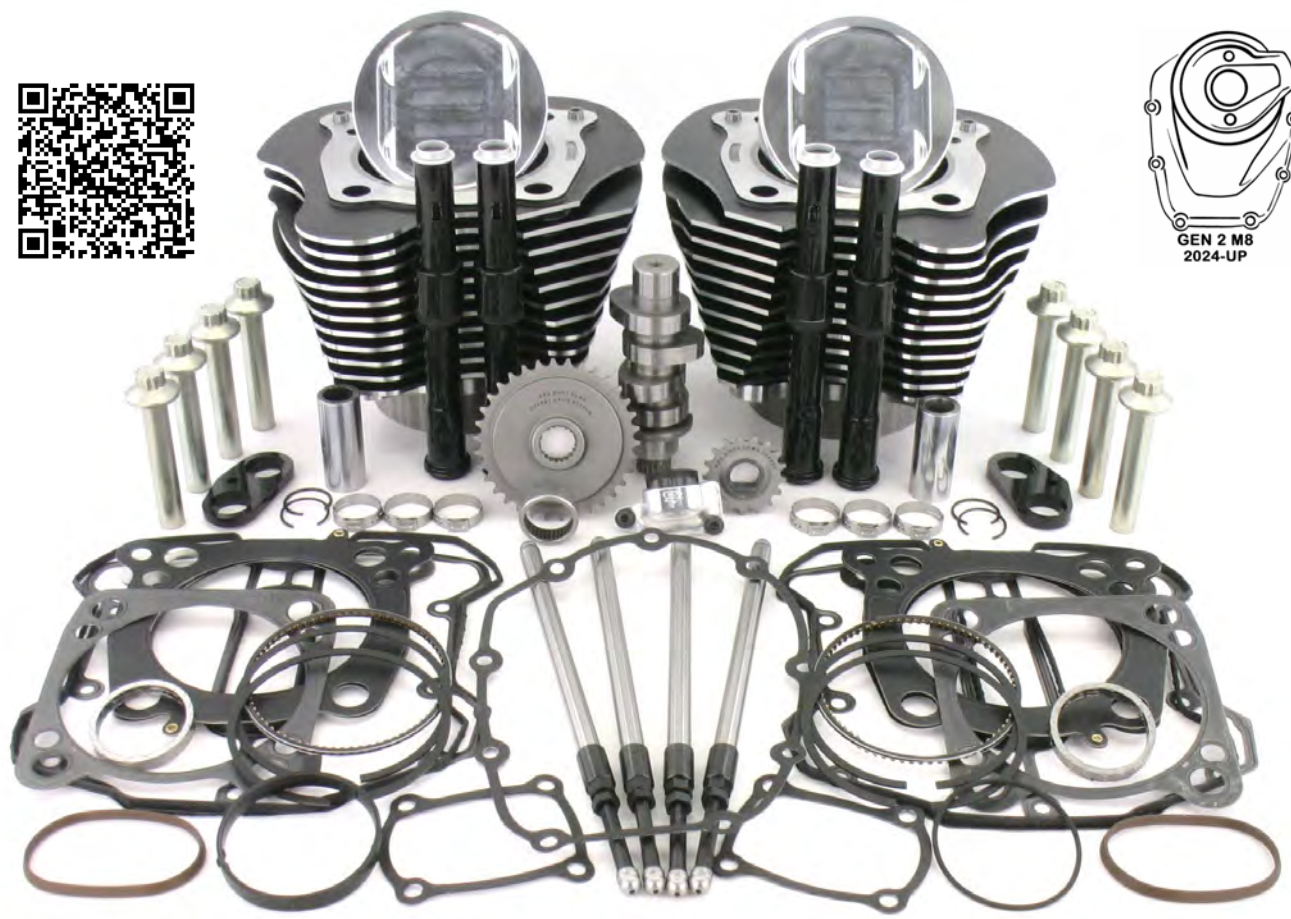
Products on this page are not for sale or use on pollution controlled vehicles.





# M8

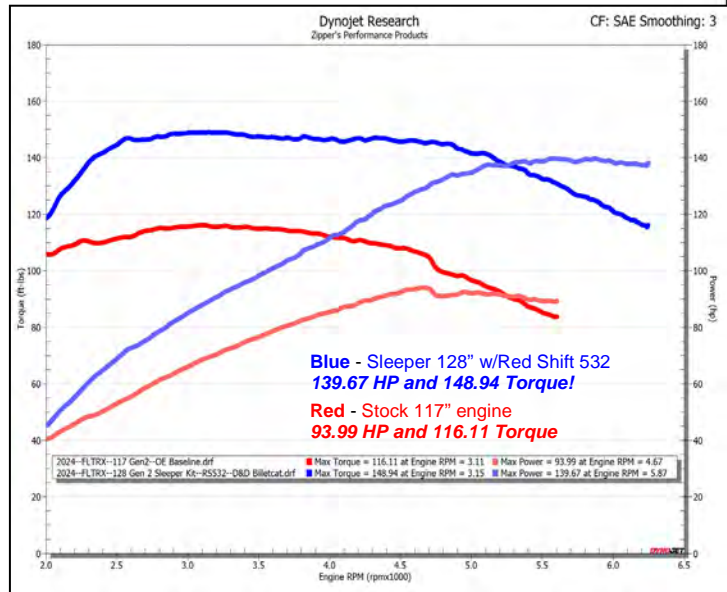
# GEN 2 ENGINE KITS



## 128 G2 SLEEPER KIT

**No replacement for displacement, right?** Our Sleeper kit easily turns your 2024 & later 117" G2 M8 into a 128 inch powerhouse! Kit includes new 4.25" bore cylinders fitted with Zipper's-designed forged pistons, Red Shift 532 cam, Red Shift dual piston tensioner with offset drive gears, quikee pushrods and chrome or black covers, cam bearing and gaskets. This entry-level big bore kit delivers powerful results with minimal parts changed. To keep costs lower, the Sleeper 128 kit uses your factory un-modified heads, along with the OEM throttle body and manifold. No cores needed to ship, just buy the kit in advance and install it once the motorcycle arrives on the lift. **Experience immediate throttle response at any RPM with this package!**

#517-420 Sleeper 128" kit for 2024-up Gen 2 117" engines



**Zipper's Performance Products**  
Elkridge, MD, 21075 - USA  
Phone: (410) 579-2828

www.ZippersPerformance.com  
Zippers@ZippersPerformance.com

Products on this page are not for sale or use on pollution controlled vehicles.

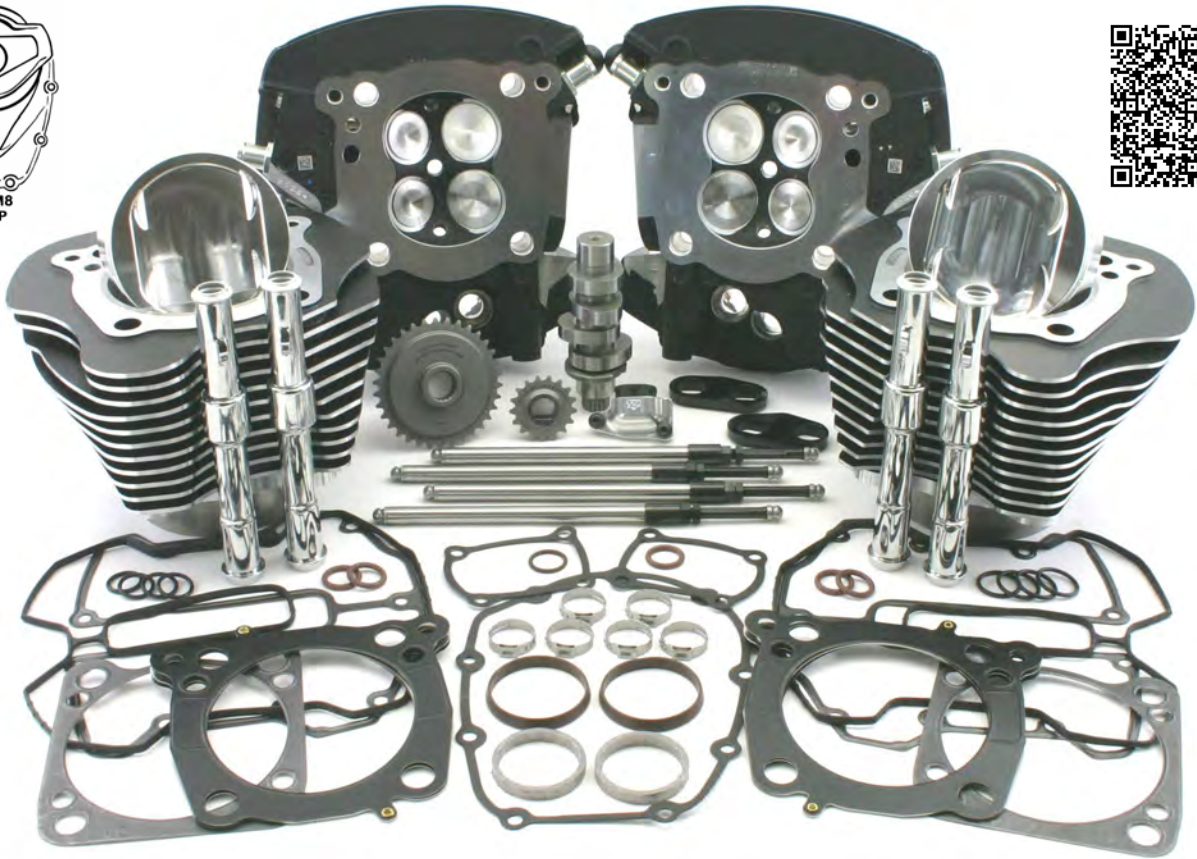




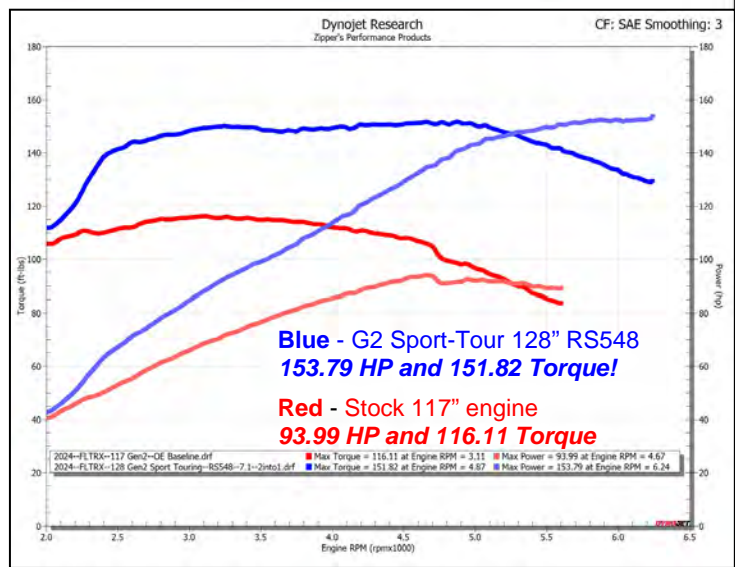
# M8

# G2 128

# SPORT-TOUR KIT



**The 128 Sport-Touring Kit is one of our most popular kits for M8 engines. This G2 version delivers over 150 rear wheel horsepower and torque through the stock manifold and throttle body!** Developed for the experienced rider that wants touring reliability and the widest power curve in its class. The Sport-Touring kit matches our Stage II M8 headwork blueprinting with our Red Shift 548 camshaft and 4.25" cylinder kit that results in big power across the entire RPM range. Twist the throttle at nearly any RPM and you're rewarded with immediate, seemingly effortless forward motion! The key to this great power is the carefully engineered combination of airflow, camshaft timing, compression, displacement and Zipper's legendary commitment to testing and machining detail. **All of these components are produced in-house at Zipper's so you can be assured of the highest quality and reliable results!**



# 517-422 Sport-Tour 128 Kit for G2 117" M8 engines  
**No Cost Options – Chrome or Black pushrod covers**

*This kit uses your factory head cores sent in for modification. An exchange may be possible once your cores are cleaned, inspected and qualified for exchange.*



**Zipper's Performance Products**  
Elkridge, MD, 21075 - USA  
Phone: (410) 579-2828

www.ZippersPerformance.com  
Zippers@ZippersPerformance.com

Products on this page are not for sale or use on pollution controlled vehicles.





# M8

# GEN 1 ENGINE KITS

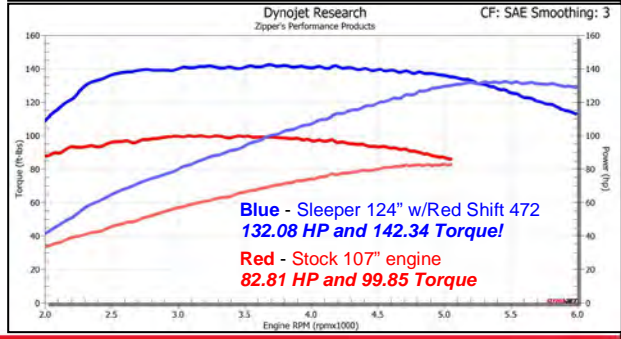
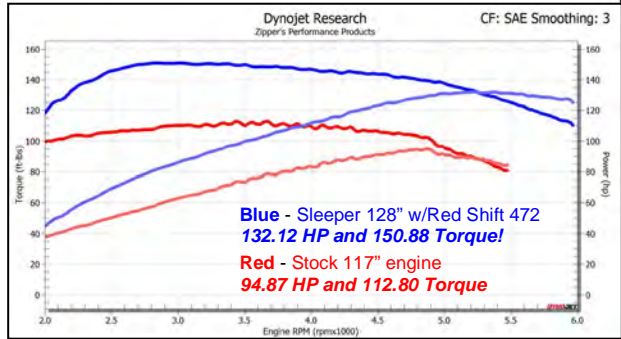


## 124 & 128 SLEEPER KITS

**No replacement for displacement, right?** Our Sleeper kits easily turn your First Generation (G1) 107 M8 into a 124, or your G1 114/117 M8 into a 128 inch powerhouse! Kit includes new drop-on 4.25" bore cylinders fitted by Zipper's with Zipper's-designed forged pistons, your choice of Red Shift 468 or 472 cam, Red Shift dual piston tensioner with offset drive gears, quikee pushrods and chrome or black covers, new cam bearing and gaskets. No cores required as this kit works great with stock heads. **Incredible power gains with stock heads, even more if you add our Stage II headwork!**

- # 517-980 Sleeper 124 kit for 2017-2025 107" engines
- # 517-984 Sleeper 128 kit for 2017-2023 114/117 engines

*No cores are required for this kit*



**Zipper's Performance Products**  
Elkridge, MD, 21075 - USA  
Phone: (410) 579-2828

www.ZippersPerformance.com  
Zippers@ZippersPerformance.com

Products on this page are not for sale or use on pollution controlled vehicles.





# M8 124/128 SPORT-TOUR KIT



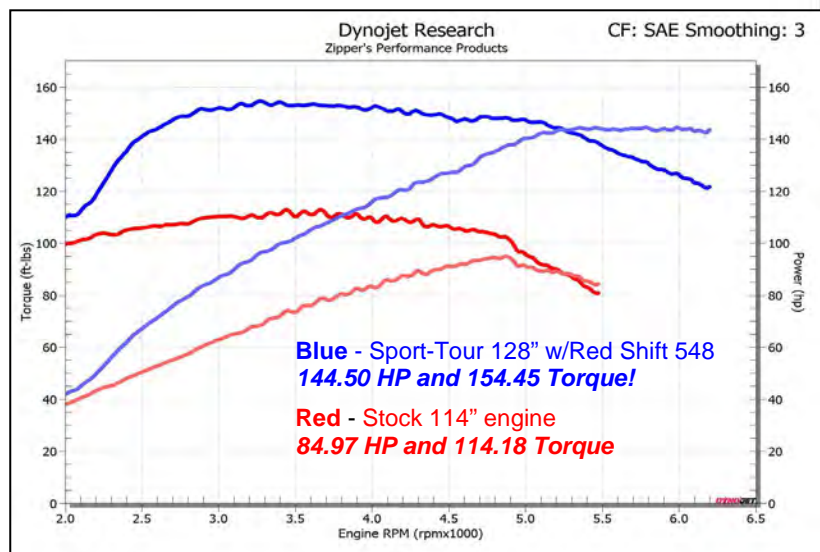
**The Sport-Touring Kit is a great choice between our popular Sleeper and Muscle kits!**

**Developed for the experienced rider that wants touring reliability and the widest power curve in its class!** The Sport-Touring kit matches our Stage II CNC M8 headwork with our Red Shift 548 camshaft and 4.25" cylinder kit that results in big power across the entire RPM range. Twist the throttle at nearly any RPM and you're rewarded with immediate, seemingly effortless forward motion! The key to this great power is the carefully engineered combination of airflow, camshaft timing, compression, displacement and Zipper's legendary commitment to testing and machining detail. **All of these components are produced in-house at Zipper's so you can be assured of the highest quality and reliable results!**

**#517-982 Sport-Touring 124 Kit for 107" M8 engines**

**#517-986 Sport-Tour 128 Kit for 114-117" M8 engines**

**No Cost Options – Chrome or Black pushrod covers**



*This kit uses your factory head cores sent in for modification. An exchange may be possible once your cores are cleaned, inspected and qualified for exchange.*



**Zipper's Performance Products**  
Elkridge, MD, 21075 - USA  
Phone: (410) 579-2828

www.ZippersPerformance.com  
Zippers@ZippersPerformance.com

Products on this page are not for sale or use on pollution controlled vehicles.





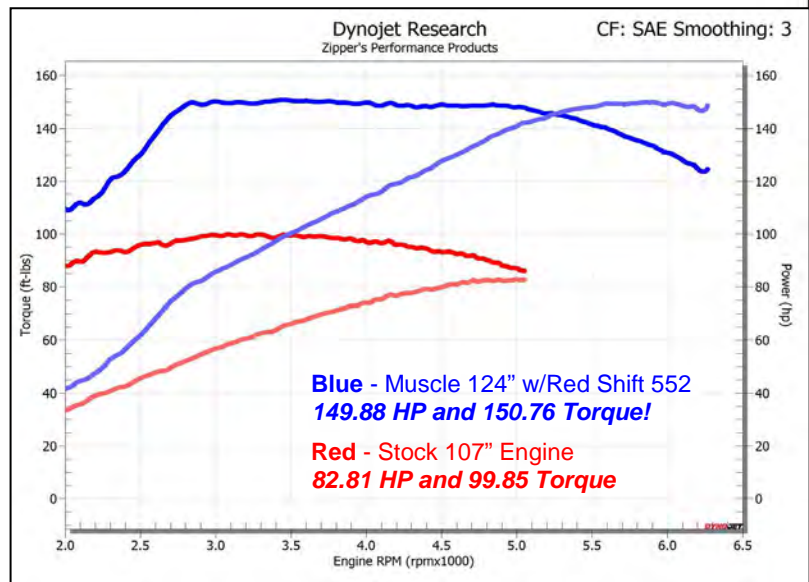
# M8 124/128 MUSCLE KIT



## Zipper's Muscle 124 & 128" Kits for the M8 produce great power across a wide RPM range!

Our 4.250" bore drop-on cylinders are fitted with Zipper's-designed forged pistons and topped off with Zipper's Stage III CNC-ported headwork featuring +1mm stainless valves and hi-lift springs. Our Red Shift 552 cam delivers HUGE torque as soon as you open the throttle, and carries it across the RPM range to provide instant acceleration from any RPM. Compression is set to a relatively modest 11:1. It has an amazing sound at idle and under load, with torque and horsepower at the 150's level. Peak torque starts at 2,800 rpm – 50 pounds more than stock, staying at nearly 150 ft/lbs for over 2,000 RPM, right where you ride! This performance is achieved with a 62mm throttle body, 7.1 injectors and performance exhaust. **Tire life not guaranteed!**

- # 517-990 Muscle 124 kit for 107 M8 engines
- # 517-992 Muscle 128 kit for 114/117 M8 engines
- No Cost Options - Chrome or Black Pushrod Covers**



This kit uses your factory head cores sent in for modification. An exchange may be possible once your cores are cleaned, inspected and qualified for exchange.



**Zipper's Performance Products**  
Elkridge, MD, 21075 - USA  
Phone: (410) 579-2828

www.ZippersPerformance.com  
Zippers@ZippersPerformance.com

Products on this page are not for sale or use on pollution controlled vehicles.





# M8

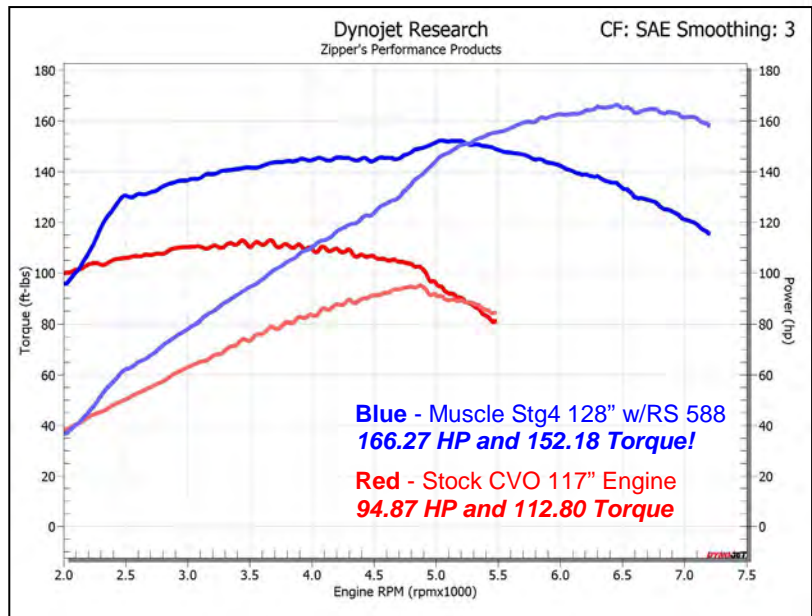
# 124/128" STAGE 4 MUSCLE KIT



**This is it, horsepower junkies - The Big Gun!** Our engineering team developed Zipper's Muscle 124 and 128 Stage 4 kits for riders who want to win, every time. Careful testing of the latest technologies and components yields incredible power from the M8 platform on pump gas. Cylinder heads are CNC-machined for maximum flow using +2mm oversize stainless valves, and Zipper's 4.250" bore cylinders are fitted with 12:1 thermal and friction coated pistons. Our Red Shift 588 cam optimizes the output of these powerful components, and careful selection of intake, exhaust and tuning delivers impressive results to 6500 RPM. This is not a bolt-on kit. It requires strengthening of the engine base and drive line upgrades - not unexpected when you are almost doubling the factory output - and should be executed by an experienced professional. **"Walk softly, but carry a Big Gun!"**

- # 517-993 Muscle 124 Stg 4 kit for 107" M8 engines
- # 517-994 Muscle 128 Stg 4 kit for 114/117" M8 engines

**No Cost Options - Chrome or Black Pushrod Covers**



*This kit uses your factory head cores sent in for modification. An exchange may be possible once your cores are cleaned, inspected and qualified for exchange.*



**Zipper's Performance Products**  
Elkridge, MD, 21075 - USA  
Phone: (410) 579-2828

www.ZippersPerformance.com  
Zippers@ZippersPerformance.com

Products on this page are not for sale or use on pollution controlled vehicles.





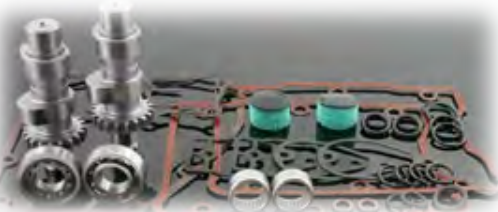
Zipper'sPerformance.com

# RED SHIFT CAM ZIP KITS

# 2-CAM



**On a Twin Cam<sup>®</sup>, our Step 1 modification for the biggest bang for your buck is a cam change!** Both the TC and M8 engines respond very favorably to a cam change, so we've put some kits together that include our most popular Zipper's-engineered Red Shift Cams<sup>®</sup> and the components you'll need for a successful cam change with upgrades. Dyno charts reflect the most popular applications shown here; you can view more on our web site with a scan of the QR codes with your phone.



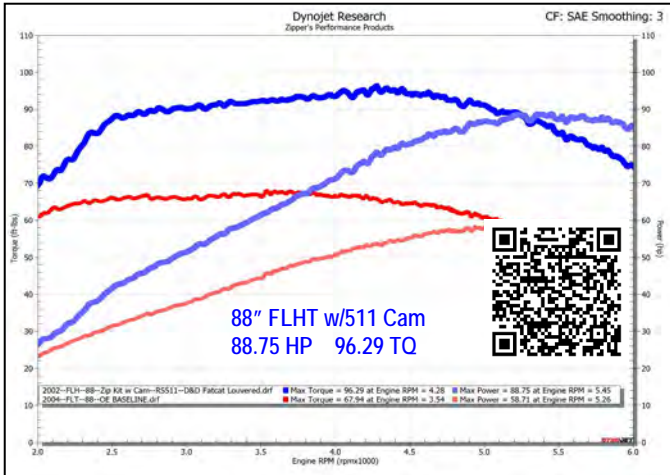
## Red Shift Cams<sup>®</sup> Zip Kits for Twin Cam<sup>®</sup> Engines

All Twin Cam<sup>®</sup> kits include Red Shift Cams<sup>®</sup>, cam bearings and gaskets needed for assembly. All are "bolt-in" chain-drive cams with profiles designed for quiet operation with factory valve springs in the year groups listed. All can use factory pushrods.

### Red Shift '99-'06 Twin Cam<sup>®</sup> 511 Cam Zip Kit

The Red Shift 511 cams are our best-selling cams for early TC engines. Very powerful bolt-in grind for stock 1999-2006 Twin Cam<sup>®</sup> 88 or 95" engines, specifically designed for stock heads. Unique profile makes exceptional power and torque while maintaining excellent valve train dynamics for quiet operation. Huge upgrade to the early Twin Cam<sup>®</sup>, and our hydraulic cam chest upgrade will give you peace of mind and miles of smiles!

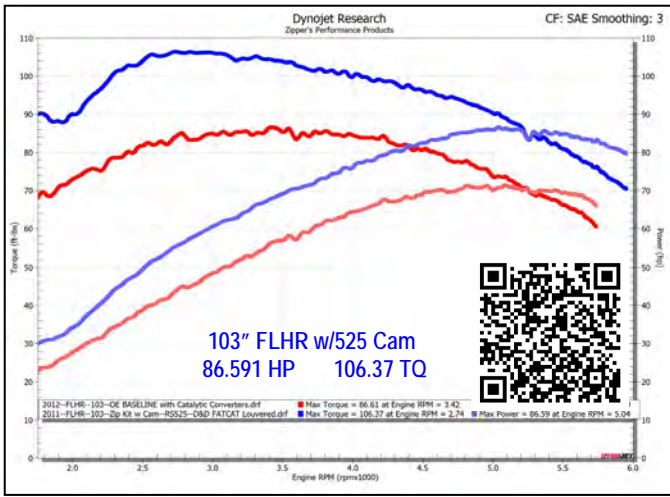
- Part # 517-301 '99-'06 Twin Cam<sup>®</sup> Red Shift 511 Cams Zip Kit
- Part # 417-494 '99-'06 TC Cam Chest Upgrade for Zip Kit



### Red Shift '07-'17 Twin Cam<sup>®</sup> 525 Cam Zip Kit

The Red Shift 525 cams are extremely popular with heavily loaded bikes and riders who like to short-shift and stay in the lower RPM ranges. The 525's are early-torque cams for 96" and 103" Twin Cam<sup>®</sup> engines with stock, unmodified heads. These cams were developed to deliver immediate passing power in 6th gear at any typical cruising speed. Power starts just above 1600 RPM with peak torque at approximately 3500 RPM and peak horsepower right at 5000 - perfect for heavy motorcycles, trikes and 2-up riding with heavy loads.

- Part # 517-305 '07-'17 Twin Cam<sup>®</sup> Red Shift 525 Cams Zip Kit
- Part # 417-492 '07-'17 TC Cam Chest Upgrade for Zip Kit



Zipper's Performance Products  
Elkridge, MD, 21075 - USA  
Phone: (410) 579-2828

www.Zipper'sPerformance.com  
Zipper's@Zipper'sPerformance.com

Products on this page are not for sale or use on pollution controlled vehicles.

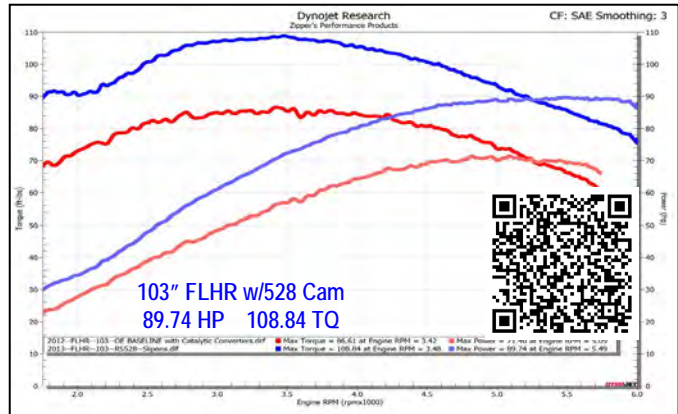
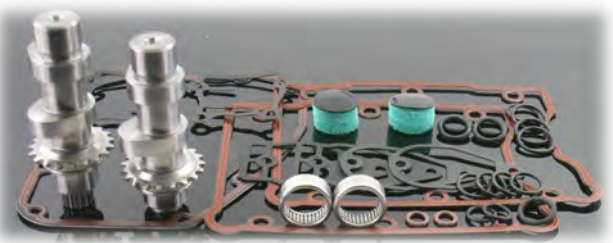




# RED SHIFT CAM ZIP KITS

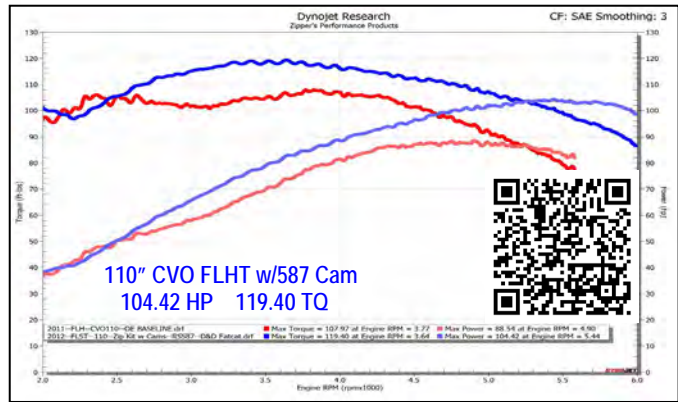
## 2-CAM

**Red Shift Cams® Zip Kits for Twin Cam® Engines**  
 All Twin Cam® kits include Red Shift Cams®, cam bearings and gaskets needed for assembly. All are "bolt-in" chain-drive cams with profiles designed for quiet operation with factory valve springs in the year groups listed. All can use factory pushrods.



**Red Shift '07-'17 Twin Cam® 528 Cam Zip Kit**  
 The Red Shift 528 cams for 96, 103 or 107" TC engines are the industry's most powerful bolt-in cams for engines with unmodified heads. Power pulls cleanly from 2200 to 6000 RPM with super-strong low end and mid-range torque. Great valve train dynamics provide quiet operation. These cams take a stock engine and turn it into an extremely fun to ride, quick to accelerate performance machine.

**Part # 517-309 '07-'17 Twin Cam® Red Shift 528 Cams Zip Kit**  
**Part # 417-492 '07-'17 TC Cam Chest Upgrade for Zip Kit**



**Red Shift '07-'17 CVO Twin Cam® 587 Cam Zip Kit**  
 The Red Shift 587 cams are designed to be the best bolt-in cam for stock compression H-D® CVO® 110 engines. Unlike other cams, the RS587's are designed for superior valve train control with the 110's larger valves and heavier springs. Their specially designed cam lobe ramps ensure quiet operation, while the profiles take advantage of the high flow CVO heads. Where stock power flattens at 4500, the RS587's continue to build power to 6000 rpm for a true hot-rod feel. The difference is simply amazing!

**Part # 517-311 '07-'17 Twin Cam® Red Shift 587 Cams Zip Kit**  
**Part # 417-492 '07-'17 TC Cam Chest Upgrade for Zip Kit**

### Highly Recommended Option: Zipper's Red Shift Cam Chest Upgrade System

Our blueprinted cam chest upgrade includes our cam plate fully machined from billet and set up to accept our patented Red Shift Dual-Piston hydraulic chain tensioners. The bypass valve is hand-fit to ensure a full seal for improved hot, low RPM oil pressure. A high flow pump with oversize gerotors is supplied with quality USA-made Delphi® lifters. For '99-'06 engines, the factory spring-loaded cam chain tensioners used in those years run under such high spring tension that the pads tend to wear pretty quickly, so it becomes a gamble on just how long before they wear down to the metal and spread shrapnel throughout your engine. Changing to the Dual Piston Hydraulic tensioners erases that worry for good!

**For '07-'17 Twin Cam® # 417-492      For '99-'06 Twin Cam® # 417-494**



**Zipper's Performance Products**  
 Elkridge, MD, 21075 - USA  
 Phone: (410) 579-2828

[www.ZippersPerformance.com](http://www.ZippersPerformance.com)  
[Zippers@ZippersPerformance.com](mailto:Zippers@ZippersPerformance.com)

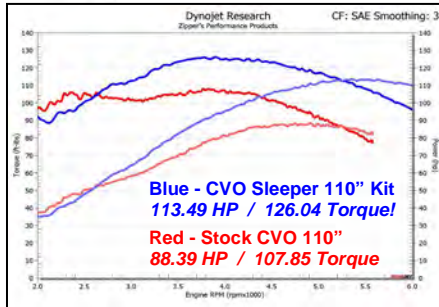
Products on this page are not for sale or use on pollution controlled vehicles.





# TC CVO SLEEPER 110

Wake up your CVO 110 with **Our Sleeper 110 Kit**. The 255 cams the factory installed in the 110 have a narrow profile that limits horsepower. Adding a broader profile cam allows the engine to rev more freely but also lowers the dynamic compression ratio and can hurt low end torque. We studied the issue and found that our Red Shift 576 grind, coupled with a small bump in compression (10:1) should boost power across the board - and it did, quite nicely! The Sleeper 110 kit includes forged, +4.2cc pistons, Red Shift 576 cams and Dual-Piston tensioners, Pro-Taper pushrods and E-Z Adjust covers (your choice, chrome or black finish), necessary gaskets. **Result: 28% gain in HP, 17% in torque!**



**# 517-970** Sleeper 110 kit for '07-'17 CVO TC engines

*This kit uses your factory cylinder cores sent in for modification.*

## ZIPPER'S BLUEPRINTED CAM CHEST UPGRADE

CVO engines are known for oil related issues, so our blueprinted cam chest upgrade is highly recommended. Our cam plate is fully machined from billet instead of a low grade, porous die-casting. The cams ride in bronze bushings, and the bypass valve is hand-fitted to ensure a full seal for improved hot, low RPM oil pressure. A high flow pump with oversize gerotors and full-compliment cam bearings are supplied with Fueling HP+ lifters. Along with Red Shift Dual-Piston cam tensioners and gaskets included with each engine kit, you'll have everything you'll need!

**# 417-498** Cam Chest Upgrade for '07-'17 TC Zipper's Engine Kits

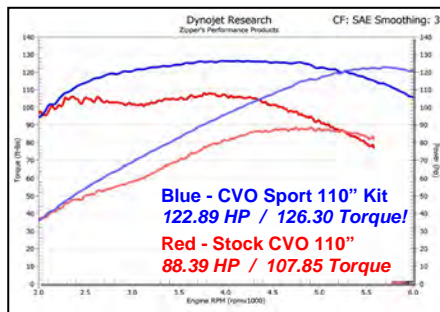


# TC CVO SPORT 110

**Zipper's Sport 110 kit greatly improves the 110's power all across the board.** Like the Sleeper 110, cam timing and compression are both increased for impressive power gains. We chose the popular Red Shift 577 cams, a more aggressive grind that responds well to compression.

After decking the gasket surface on your supplied cylinders, forged +10cc domed pistons (10.65:1) are precision-fitted to the cylinders using the latest Sunnen honing techniques. The kit also includes Red Shift Dual-Piston tensioners, Pro-Taper pushrods and E-Z Adjust covers (your choice of chrome or black finish), and all necessary gaskets. **Result: 39% gain in HP, 17% in big, broad torque!**

**# 517-971** Sport 110 kit for '07-'17 CVO TC engines



*This kit uses your factory cylinder cores sent in for modification*



**Zipper's Performance Products**  
Elkridge, MD, 21075 - USA  
Phone: (410) 579-2828

www.ZippersPerformance.com  
Zippers@ZippersPerformance.com

Products on this page are not for sale or use on pollution controlled vehicles.





# TC 110" CVO MUSCLE KIT

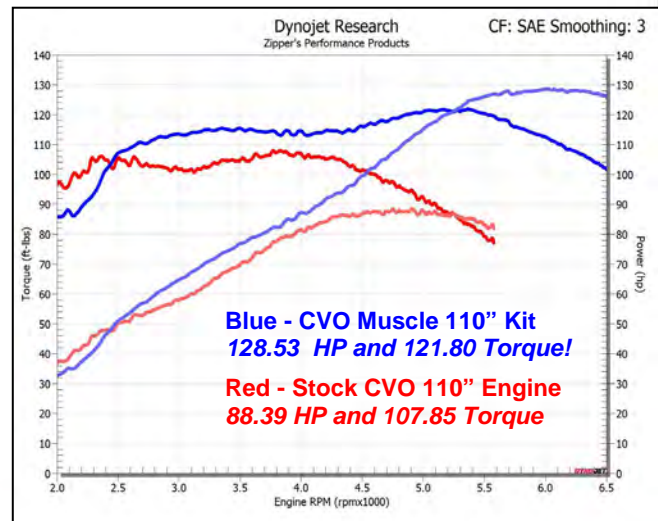


## Does your CVO 110 seem to run flat after 4,500 RPM?

It's true - the factory 110 engine is better at producing torque than HP. Zipper's Muscle 110 kit starts producing more torque at 2,500, then just when the factory engine starts leveling out at 4,250, the Muscle 110 takes a deep breath and charges hard to 6,200 RPM - making an astonishing 40 HP more! Peak torque occurs at 5,100 RPM, 34 ft/lbs more than stock, contributing to the hard pull felt on your arms. How do we do it? Stage 3 CNC CVO headwork, proprietary +10cc pistons and Red Shift 657 cams provide everything needed to produce the power. Valve springs and Red Shift Dual-Piston tensioners with Pro-Taper pushrods add stability and life to the unstable factory valve train. CVO engines are known for lifter and oil system issues, so our blue-printed cam chest upgrade is highly recommended.

**Whether you ride in short hops or long trips, you'll fall in love with your CVO again with the Muscle 110!**

#417-498



# 517-972 Muscle 110 kit for '07-'17 CVO TC engines  
No Cost Options - Chrome or Black Pushrod Covers  
# 417-498 Plate/pump/bearings/lifters upgrade

*This kit uses your factory head and cylinder cores sent in for modification.*



Zipper's Performance Products  
Elkridge, MD, 21075 - USA  
Phone: (410) 579-2828

www.ZippersPerformance.com  
Zippers@ZippersPerformance.com

Products on this page are not for sale or use on pollution controlled vehicles.





# TC 113" CVO MUSCLE KIT

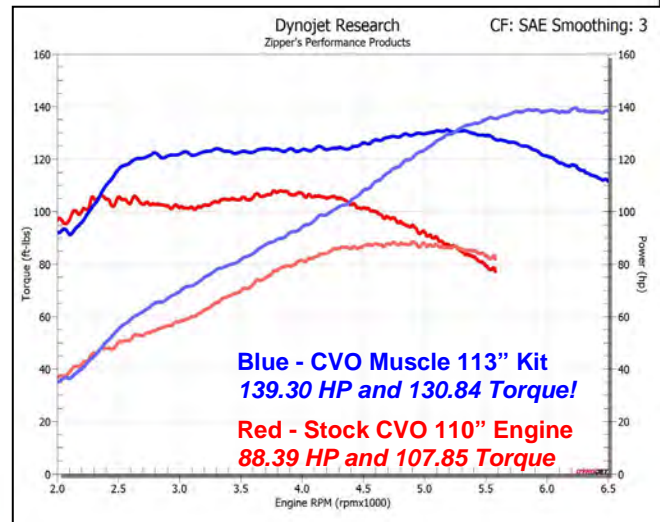


## What could be better than our Muscle 110 kit?

Adding 3 magical cubic inches to it, of course! By adding .060" to the bore and 2cc's to the pistons, a sweet spot was identified, and the **Muscle 113** was born - with nearly 11 more HP and 9 more ft/lbs of torque. The Muscle 113 has a very similar power curve when compared to the Muscle 110, just more of it, everywhere. 50 more horsepower and 42 ft/lbs of torque than stock! Stage 3 CNC CVO headwork, proprietary +12cc pistons and Red Shift 657 cams provide everything needed to produce the power. Upgraded valve springs and Red Shift Dual-Piston tensioners with Pro-Taper pushrods add stability and life to the unstable factory valve train, up through 6,500 RPM. CVO engines are known for lifter and oil system issues, so our blueprinted cam chest upgrade is highly recommended.

**Big Power awaits the CVO owner with this powerful top end and cam kit! M8 owners will respect the Twin Cam® Muscle 113!**

#417-498



- # 517-974 Muscle 113 kit for '07-'17 CVO TC engines  
**No Cost Options - Chrome or Black Pushrod Covers**
- # 417-498 Plate/pump/bearings/lifters upgrade

*This kit uses your factory head and cylinder cores sent in for modification.*



Zipper's Performance Products  
Elkridge, MD, 21075 - USA  
Phone: (410) 579-2828

www.Zipper'sPerformance.com  
Zipper's@Zipper'sPerformance.com

Products on this page are not for sale or use on pollution controlled vehicles.

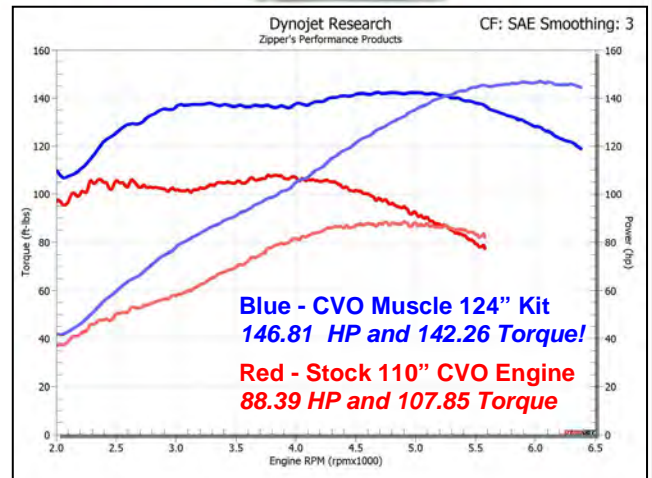




# TC 124" CVO MUSCLE KIT



**Raise the bar to the top level on your CVO Twin Cam®!** Zipper's CVO Muscle 124 engine kit improves the high-breathing CVO head with CNC porting and oversize valves, while our proprietary +7cc domed pistons raise compression to 10.75:1. A new 4-5/8" crankshaft adds a 1/4" more stroke, while new stress-relieved cylinders add an 1/8" more to the bore. Our Red Shift 657 cams are perfectly matched with the heads and piston to provide big torque & HP across the entire RPM range. Red Shift Dual-Piston cam tensioners are included with Pro-Taper pushrods and EZ-Adjust covers for a stable valve train, with all the gaskets needed for assembly. Case boring required for 4-1/8" cylinders; Timken® bearing conversion and cam chest/oil system upgrade highly recommended to improve durability and reliability. **Make your CVO run even faster than it looks!**



- # 517-976 Muscle 124 kit for '07-'17 CVO TC-A engines
- # 517-978 Muscle 124 kit for '07-'17 CVO TC-B engines
- No Cost Options - Chrome or Black Pushrod Covers**
- This kit uses your factory head cores sent in for modification.*
- # 417-498 Plate/pump/cam bearings/lifters upgrade



Zipper's Performance Products  
Elkridge, MD, 21075 - USA  
Phone: (410) 579-2828

www.ZippersPerformance.com  
Zippers@ZippersPerformance.com

Products on this page are not for sale or use on pollution controlled vehicles.



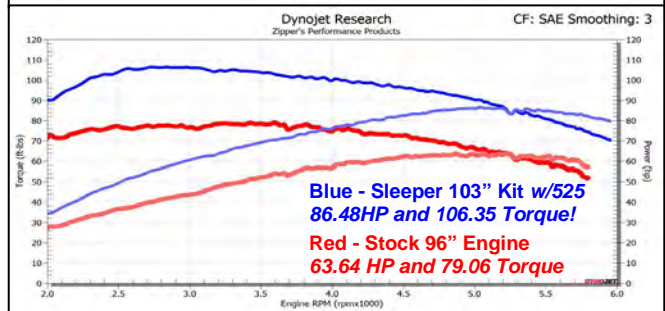
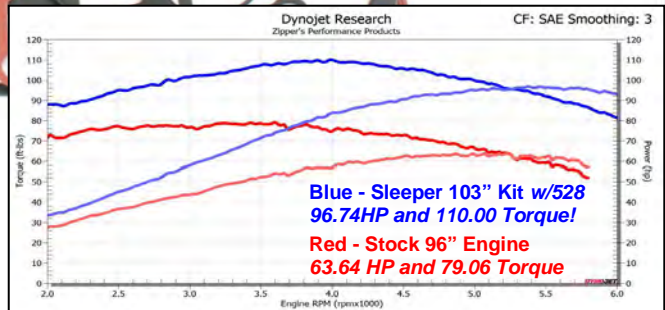


# TC 103" SLEEPER KIT



**Zipper's Sleeper 103 kit is an easy and affordable upgrade for 2007-up 96" Twin Cam® engines.** Your cylinders are precision-bored from 3.750" to 3.875" with forged 10.25:1 pistons to boost displacement to 103", while your stock cams are replaced with your choice of our Red Shift 525 or 528 grinds. The 525's are designed for heavily loaded bikes and build huge torque just off idle with less top end power, while the 528 cams shift power and torque to the right, across the entire RPM range with stock heads. Gain even more power with (1) Zipper's optional Stage 1 headwork and (2) improve longevity with critical oil system blueprinting by adding our cam chest upgrade that includes our billet cam plate, dual-piston cam tensioners, full-compliment cam bearings and quality USA lifters.

**With power peaking at 5,000 RPM, this kit is a great choice for the rider who rarely pegs the throttle to red line, but rather enjoys the super-strong pull of low & mid-range torque!**



# 517-960 Sleeper 103 kit '07-'13 96" Twin Cam®

# 517-751 Stage 1 Twin Cam® Headwork

# 417-499 Blueprinted '07-'17 TC Cam Chest Kit

*This kit uses your factory cylinder (and heads if Stage 1 option is chosen) cores sent in for modification. An exchange may be possible once your cores are cleaned, inspected and qualified for exchange.*



**Zipper's Performance Products**  
Elkridge, MD, 21075 - USA  
Phone: (410) 579-2828

www.Zipper'sPerformance.com  
Zipper's@Zipper'sPerformance.com

Products on this page are not for sale or use on pollution controlled vehicles.



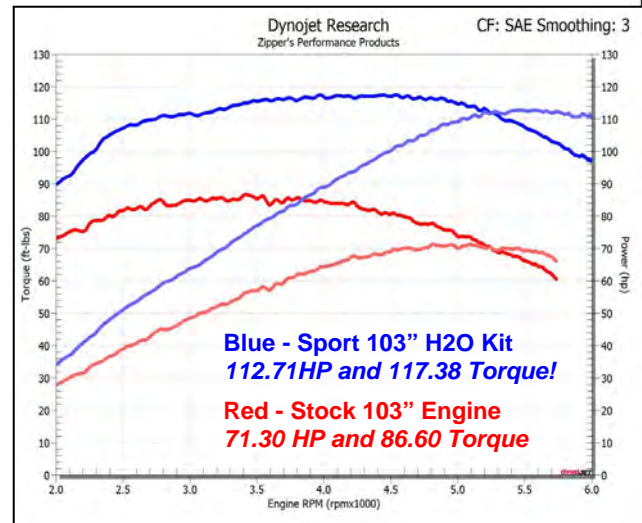


# 103" TC SPORT KIT



**Zipper's Sport 103" kit greatly improves the all-around power output of the 96 or 103" Twin Cam® engine.** A great choice for the rider who rides 2-up on a loaded bagger, who short-shifts and rarely revs the engine past 5,000 RPM. Over 100 ft/lbs of torque is available from 2,400 to 5,200 RPM, peaking at 115+ ft/lbs by 4,250. Horsepower is a linear line to 110+, peaking at just over 5,200 RPM. Your cylinders are decked and sized for 3.875" forged pistons, while your heads are modified with Zipper's high velocity Stage II CNC porting. Our Red Shift 575 cams and Dual-Piston Tensioners ensure valve train stability; Pro-Taper pushrods with EZ-Adjust covers are included with top quality gaskets. This kit delivers excellent results with the factory throttle body and injectors, keeping costs down. **Highly recommended option:** our 417-498 blueprinted cam chest/oil system upgrade for improved oil delivery, increasing reliability and durability. **With the Sport 103, you won't have to run the RPM's around the dial to move your big bike quickly and efficiently!**

#417-498



# 517-961 Sport 103 for '07-'17 Twin Cam® engines  
**No Cost Options - Chrome or Black Pushrod Covers**

# 417-498 Plate/HV pump/bearings/lifters upgrade kit

*This kit uses your factory head & cylinder cores sent in for modification. An exchange may be possible once your cores are cleaned, inspected and qualified for exchange.*



**Zipper's Performance Products**  
Elkridge, MD, 21075 - USA  
Phone: (410) 579-2828

www.ZippersPerformance.com  
Zippers@ZippersPerformance.com

Products on this page are not for sale or use on pollution controlled vehicles.



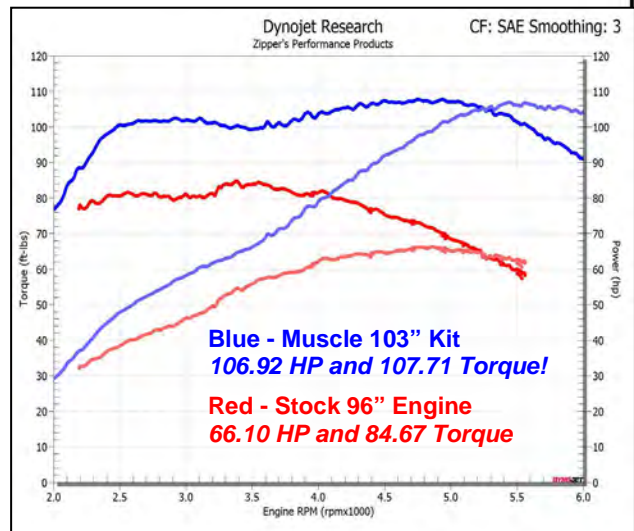


# TC 103" MUSCLE KIT



**Boost the power of your 96" Twin Cam® with our Muscle 103 kit!** The Muscle 103 is a top end and cam kit that gets its displacement boost by increasing the cylinder bore size to 3.875", while retaining the factory 4-3/8" stroke. Your cylinder tops are decked for trueness and new 10.5:1 forged pistons are precision-fit using the latest Sunnen equipment, while your heads receive Zipper's high-breathing Stage III treatment with CNC porting, new guides, oversize valves and performance springs. Zipper's Red Shift 577 cams are perfectly matched with the heads and piston to provide big torque & HP across the entire RPM range. Red Shift Dual-Piston cam tensioners are included with Pro-Taper pushrods for a stable valve train and EZ-Adjust covers, with all gaskets needed for assembly. **Highly recommended option:** Zipper's #417-498 blueprinted cam chest/oil system upgrade for improved oil delivery, increasing reliability and durability. **#417-498**

**This kit is also great for TC 103 owners that want to boost their power but wish to retain the 103" factory displacement.**



**# 517-962** Muscle 103 kit for '07-'17 Twin Cam® engines  
**No Cost Options - Chrome or Black Pushrod Covers**

**# 417-498** Plate/HV pump/bearings/lifters upgrade kit

*This kit uses your factory head & cylinder cores sent in for modification. An exchange may be possible once your cores are cleaned, inspected and qualified for exchange.*



**Zipper's Performance Products**  
Elkridge, MD, 21075 - USA  
Phone: (410) 579-2828

www.Zipper'sPerformance.com  
Zipper's@Zipper'sPerformance.com

Products on this page are not for sale or use on pollution controlled vehicles.



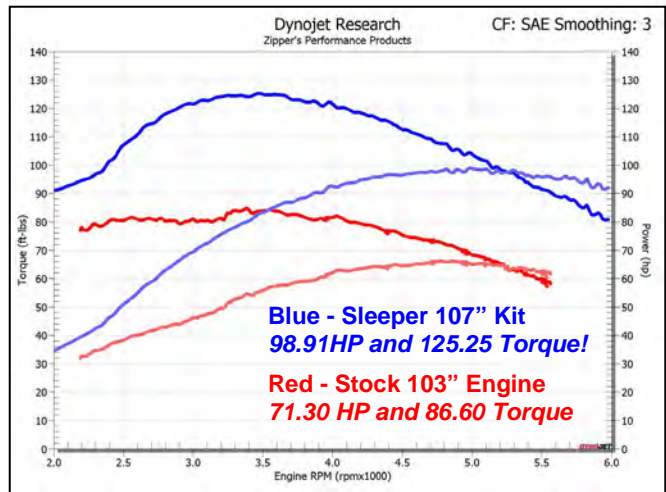


# TC 107" SLEEPER KIT



**The Sleeper 107 kit is an easy and affordable upgrade for 2007-up 96 or 103" Twin Cam® engines.** Your cylinders are precision-bored from 3.750" (96") or 3.875" (103") to 3.937" to boost displacement to 107", while your stock cams are replaced with our Red Shift 528 grind. The forged flat-top pistons used boost compression to 10.25:1, while the 528 cams yield impressive power and torque gains across the entire RPM range with stock heads. Gain even more power with (1) our optional Stage 1 headwork and (2) improve longevity with critical oil system blueprinting by adding our cam chest upgrade that includes our billet cam plate, dual-piston cam tensioners, full-compliment cam bearings and Feuling lifters.

**With power peaking at 5,000 RPM, this kit is a great choice for the rider who rarely pegs the throttle to red line, but rather enjoys the super-strong pull of low and mid-range torque!**



- # 517-963 Sleeper 107 kit for '07-'17 Twin Cam®
- # 517-751 Stage 1 Twin Cam® Headwork
- # 417-499 Blueprinted '07-'17 TC Cam Chest Kit

*This kit uses your factory cylinder (and heads if Stage 1 option is chosen) cores sent in for modification. An exchange may be possible once your cores are cleaned, inspected and qualified for exchange.*



**Zipper's Performance Products**  
Elkridge, MD, 21075 - USA  
Phone: (410) 579-2828

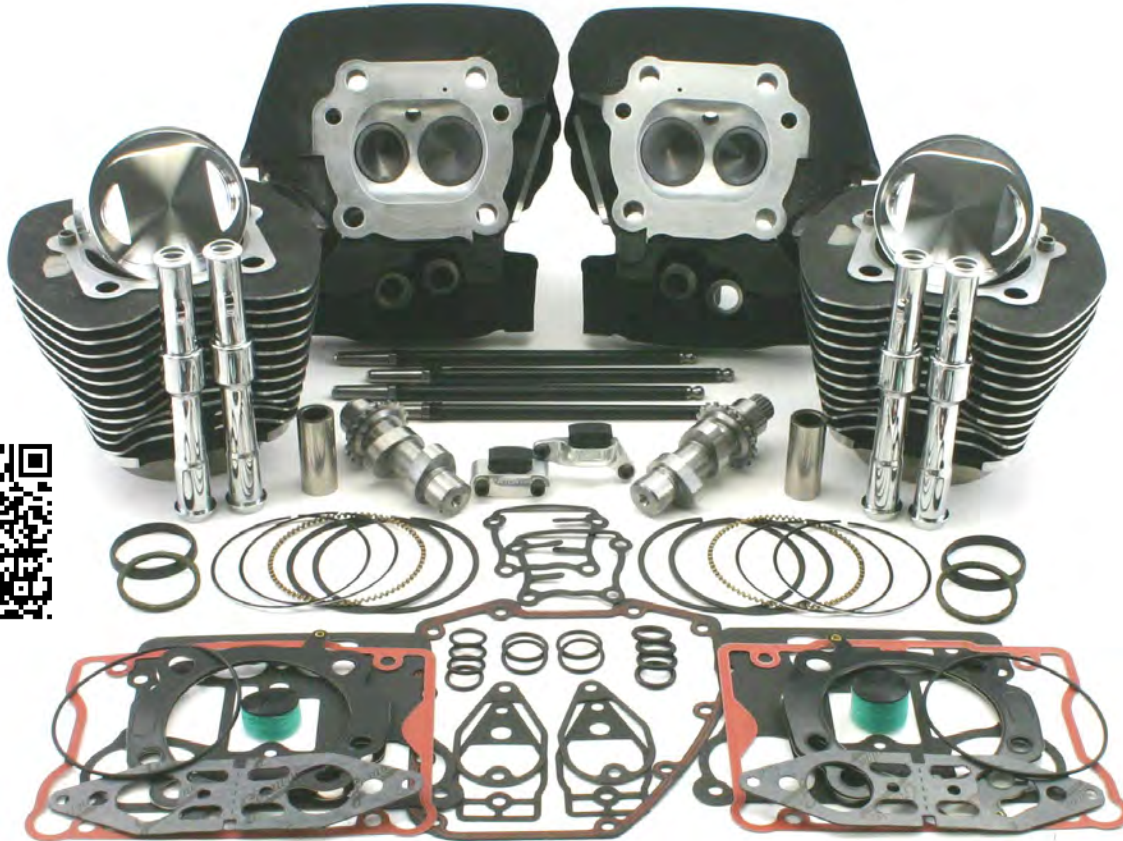
www.ZippersPerformance.com  
Zippers@ZippersPerformance.com

Products on this page are not for sale or use on pollution controlled vehicles.





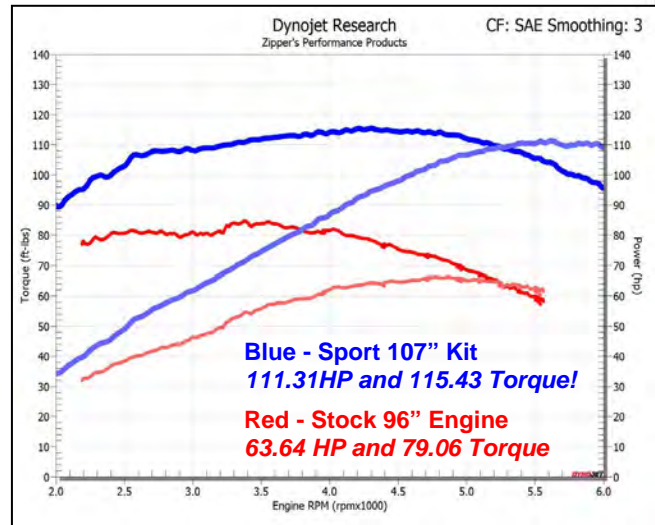
# 107" TC SPORT KIT



**Our Sport 107" kit greatly improves the all-around power output of the 96 or 103" Twin Cam® engine.** A great choice for the rider looking for strong acceleration. Over 100 ft/lbs of torque is available from 2,400 to 5,200 RPM, peaking at 115+ ft/lbs by 4,250. Horsepower is a linear line to 110+, peaking at just over 5,200 RPM - meaning you don't have to run the RPM's around the dial to move your big bike quickly and efficiently. Your cylinders are decked and sized for 3.937" forged pistons, while your heads are modified with our high velocity Stage 2 CNC portwork. Our Red Shift 575 cams and Dual-Piston Tensioners ensure valve train stability; Pro-Taper pushrods with EZ-Adjust covers are included with top quality gaskets. This kit delivers excellent results with the factory throttle body and injectors, keeping costs down. **Highly recommended option:** our 417-498 blueprinted cam chest/oil system upgrade for improved oil delivery, increasing reliability and durability.

#417-498

**The Sport 107 puts way more 'Sport' in your riding experience!**



**# 517-964 Sport 107 for '07-'17 Twin Cam® engines  
No Cost Options - Chrome or Black Pushrod Covers**

**# 417-498 Plate/HV pump/bearings/lifters upgrade kit**

*This kit uses your factory head & cylinder cores sent in for modification. An exchange may be possible once your cores are cleaned, inspected and qualified for exchange.*



**Zipper's Performance Products**  
Elkridge, MD, 21075 - USA  
Phone: (410) 579-2828

www.ZippersPerformance.com  
Zippers@ZippersPerformance.com

Products on this page are not for sale or use on pollution controlled vehicles.





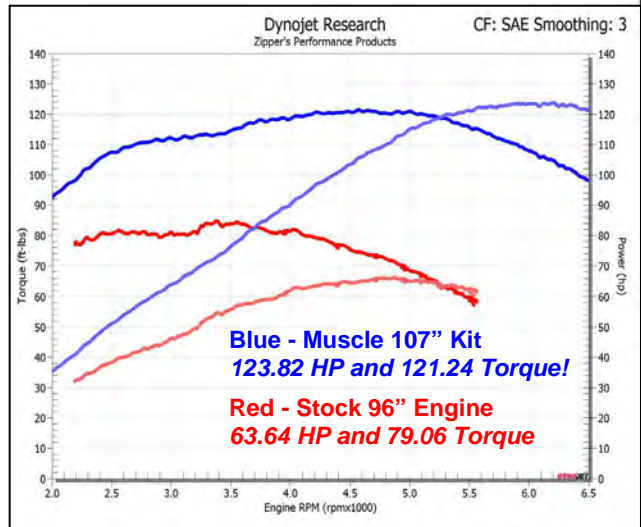
# TC 107" MUSCLE KIT



**Zipper's Popular Muscle 107" Kit for Twin Cam® 96/103" engines boost torque and horsepower north of 120!** The Muscle 107 is a top end and cam kit that gets its displacement boost by increasing the cylinder bore size to 3.937", while retaining the factory 4-3/8" stroke. Your cylinder tops are decked for trueness and new 10.6:1 forged pistons are precision-fit using the latest Sunnen equipment, while your heads receive our high-breathing Stage 3 treatment with CNC-porting, new guides, oversize valves and performance springs. Our Red Shift 577 cams are perfectly matched with the heads and piston to provide big torque & HP across the entire RPM range. Red Shift Dual-Piston cam tensioners are included with Pro-Taper pushrods for a stable valve train and EZ-Adjust covers, with all gaskets needed for assembly. **Highly recommended option:** our 417-498 blueprinted cam chest/oil system upgrade for improved oil delivery, increasing reliability and durability.

#417-498

**This kit is for the aggressive rider that likes to regularly twist the wick and run up front!**



# 517-965 Muscle 107 kit for '07-'17 Twin Cam® engines  
**No Cost Options - Chrome or Black Pushrod Covers**

# 417-498 Plate/HV pump/bearings/lifters upgrade kit

*This kit uses your factory head & cylinder cores sent in for modification. An exchange may be possible once your cores are cleaned, inspected and qualified for exchange.*



Zipper's Performance Products  
Elkridge, MD, 21075 - USA  
Phone: (410) 579-2828

www.Zipper'sPerformance.com  
Zipper's@Zipper'sPerformance.com

Products on this page are not for sale or use on pollution controlled vehicles.



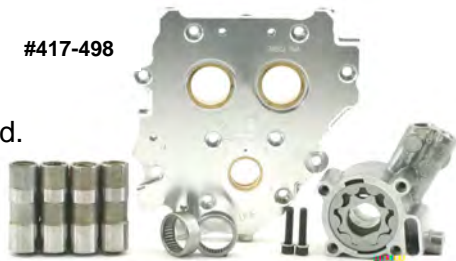


# TC 117" MUSCLE KIT

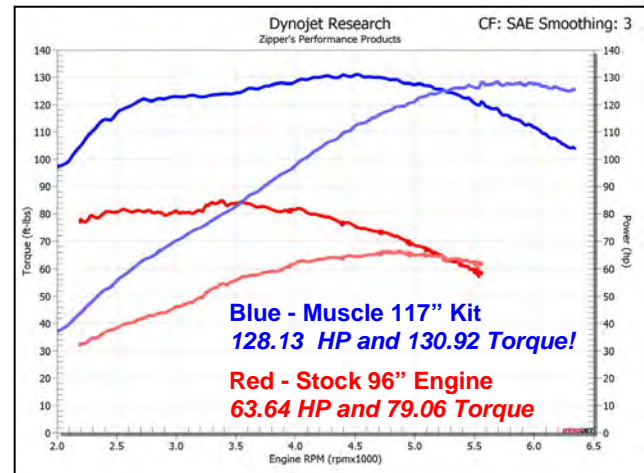


**Zipper's Muscle 117" Kit for Twin Cam® 96/103" engines increases displacement with new 4-1/8" bore cylinders while retaining the factory 4-3/8" stroke.** New cylinders are stress-relieved before being precision fit with 10.6:1 forged pistons using the latest Sunnen equipment, while your heads receive our high-breathing Stage 3 treatment with CNC-porting, new guides, oversize valves and performance springs. Our Red Shift 577 cams are perfectly matched with the heads and piston to provide big torque & HP across the entire RPM range. Red Shift Dual-Piston cam tensioners are included with Pro-Taper pushrods for a stable valve train and EZ-Adjust covers, with all the gaskets needed for assembly. Case boring required for 4-1/8" cylinders; Timken® bearing conversion and cam chest/oil system upgrade recommended.

#417-498



**Amazing increase in Power and Torque!**



- # 517-967 Muscle 117 kit for '07-'17 TC engines  
**No Cost Options - Chrome or Black Pushrod Covers**
- # 417-498 Plate/pump/bearings/lifters upgrade

*This kit uses your factory head cores sent in for modification. An exchange may be possible once your cores are cleaned, inspected and qualified for exchange.*



**Zipper's Performance Products**  
Elkridge, MD, 21075 - USA  
Phone: (410) 579-2828

www.ZippersPerformance.com  
Zippers@ZippersPerformance.com

Products on this page are not for sale or use on pollution controlled vehicles.





# TC 124" MUSCLE KIT



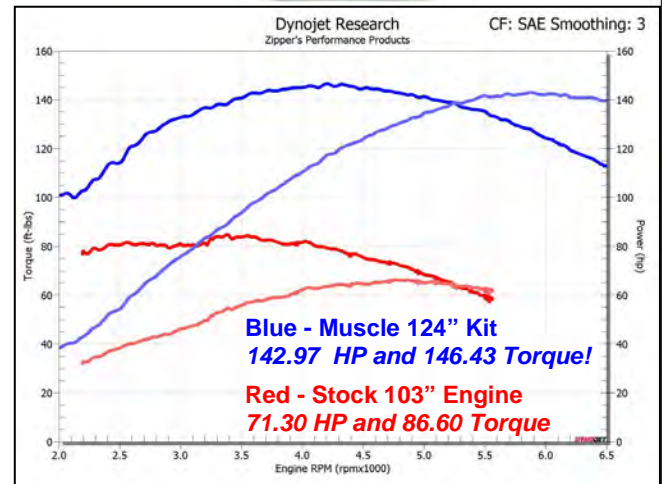
## Zipper's Muscle 124 Kit combines Big Bore with Big Stroke!

At the bottom, a 4-5/8" stroke crankshaft paired with 4-1/8" cylinders establishes the base for 124" of Big Power. An engine this size needs specialized cylinder heads, our ultra-high flow Stage 4 CNC-porting and highly modified chambers along with oversize, unshrouded valves delivers just that. New stress-relieved cylinders are precision-fit with durable forged pistons supplied with high quality 1-1-3mm rings. Red Shift 657 cams and dual-piston tensioners, Pro-Taper pushrods, longer head bolts and E-Z Adjust pushrod covers are provided with all the gaskets needed for assembly. Case boring required for 4-1/8" cylinders; Timken® bearing conversion, our blueprinted cam chest oil

system upgrade for rock solid stability and durability are highly recommended.

**Show 'em your rapidly fading tail light every pass, every time!**

#417-498



- # 517-968 Muscle 124 kit for '07-'17 TC-A engines
- # 517-969 Muscle 124 kit for '07-'17 TC-B engines
- No Cost Options - Chrome or Black Pushrod Covers**
- # 417-498 Plate/pump/bearings/lifters upgrade

*This kit uses your factory head cores sent in for modification. An exchange may be possible once your cores are cleaned, inspected and qualified for exchange.*



**Zipper's Performance Products**  
Elkridge, MD, 21075 - USA  
Phone: (410) 579-2828

www.ZippersPerformance.com  
Zippers@ZippersPerformance.com

Products on this page are not for sale or use on pollution controlled vehicles.

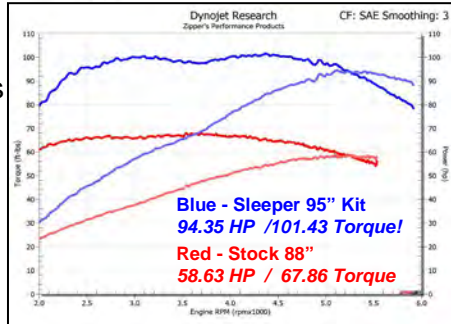




## '99-'06 TC SLEEPER 95

**Still riding that stock 88" TC? Give it a wake-up call with Zipper's Sleeper 95 Kit!** 95" kits are certainly nothing new, but we

took another look at this popular mod and added Zipper's newly designed Red Shift 511 grind, along with a bore size increase to 3.875". The results are fantastic - power is increased across the board, with horsepower well over 90 and torque breaking the century mark with stock size valves and no head porting! The Sleeper 95 kit includes forged 3-7/8" pistons precision-fit to your decked & trued cylinders, Red Shift 511 cams and all gaskets. Add our optional cam chest upgrade kit to update aging components with modern hydraulics. **Result: 60% gain in HP, 49% in torque!**



**# 517-940 Sleeper 95 kit for '99-'06 TC engines**

*This kit uses your factory cylinder cores sent in for modification.*



### ZIPPER'S BLUEPRINTED CAM CHEST UPGRADE

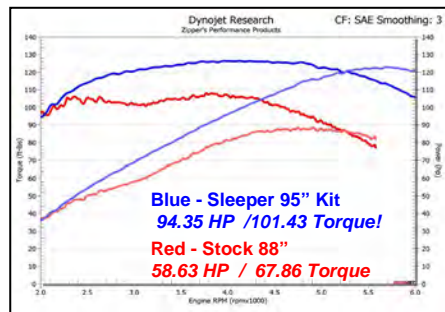
The spring-loaded cam chain tensioners used in '99-'06 TC engines run under such high spring tension that the pads tend to wear pretty quickly, so it becomes a gamble on just how long before they wear down to the metal and spread shrapnel throughout your engine. Our blueprinted cam chest upgrade includes our cam plate fully machined from billet and set up to accept our patented Red Shift Dual-Piston hydraulic chain tensioners. The bypass valve is hand-fit to ensure a full seal for improved hot, low RPM oil pressure. A high flow pump with oversize gerotors and new inner & outer cam bearings are supplied with quality USA lifters. A worthy update for the venerable TC!

**# 417-495 Cam Chest Upgrade for '99-'06 TC Zipper's Engine Kits**

## '99-'06 TC SLEEPER 98

**Zipper's Sleeper 98" kit adds 10 more cubic inches through an increase of the stock 88" 3.750" bore size to 3.937"!**

This is a similar kit to the 95" Sleeper kit, just 3 cubic inches larger via the bore size. Dyno sheet not available at press time, the curve will look nearly identical, just a bit more power everywhere. The Sleeper 98 kit includes forged 3.937" pistons precision-fit to your decked & trued cylinders, Red Shift 511 cams and all gaskets. Add Zipper's optional cam chest upgrade kit to update aging components with modern hydraulics.



**95" Dyno results shown. 98" kit is 3% larger, results will be approximately 97+ HP, 105 torque**



**# 517-941 Sleeper 98 kit for '99-'06 TC engines**

*This kit uses your factory cylinder cores sent in for modification*



**Zipper's Performance Products**  
Elkridge, MD, 21075 - USA  
Phone: (410) 579-2828

www.ZippersPerformance.com  
Zippers@ZippersPerformance.com

Products on this page are not for sale or use on pollution controlled vehicles.





Zipper'sPerformance.com

**ZIPPER'S**  
PERFORMANCE PRODUCTS

THE POWER OF EXPERIENCE

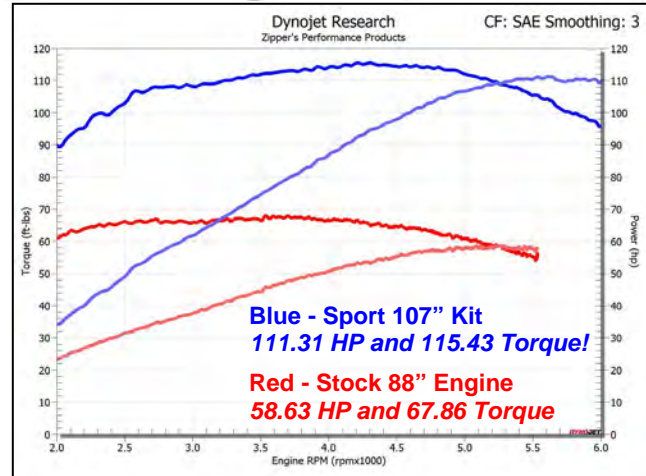
# '99-'06 TC SPORT 107" KIT



**Zipper's Sport 107" Kit for '99-'06 Twin Cam® 88" engines greatly improves the all-around power output of the 88" Twin Cam® engine.**

The Sport 107 is a great choice for the rider looking to give new life to a tired or failed engine. Over 100 ft/lbs of torque is available from 2,400 to 5,200 RPM, while Horsepower is a linear line to 110+. A new 4-3/8" stroke crankshaft replaces your factory 4" stroke crank. Your cylinders are decked and sized for 3.937" forged pistons, while your heads are modified with Zipper's high velocity Stage II CNC porting. Our Red Shift 575 cams and Dual-Piston Tensioners ensure valve train stability; Pro-Taper pushrods with EZ-Adjust covers are included with top quality gaskets. This kit delivers excellent results with the factory throttle body and injectors, keeping costs down. **Highly recommended option:** our # 417-495 blueprinted cam chest upgrade with our patented Red Shift Dual Piston hydraulic cam chain tensioners, blueprinted billet plate, HV oil pump, cam bearings and quality USA lifters for improved reliability and durability.

**Exciting New Life for the 88" Engine!**



- # 517-946 Sport 107 kit for '99-'06 Twin Cam® 'A' engines
- # 517-947 Sport 107 kit for '99-'06 Twin Cam® 'B' engines
- No Cost Options - Chrome or Black Pushrod Covers**

# 417-495 Blueprinted cam chest upgrade kit including Plate/HV pump/RS dual piston tensioners/bearings/lifters

*This kit uses your factory head & cylinder cores sent in for modification. An exchange may be possible once your cores are cleaned, inspected and qualified for exchange.*



Zipper's Performance Products  
Elkridge, MD, 21075 - USA  
Phone: (410) 579-2828

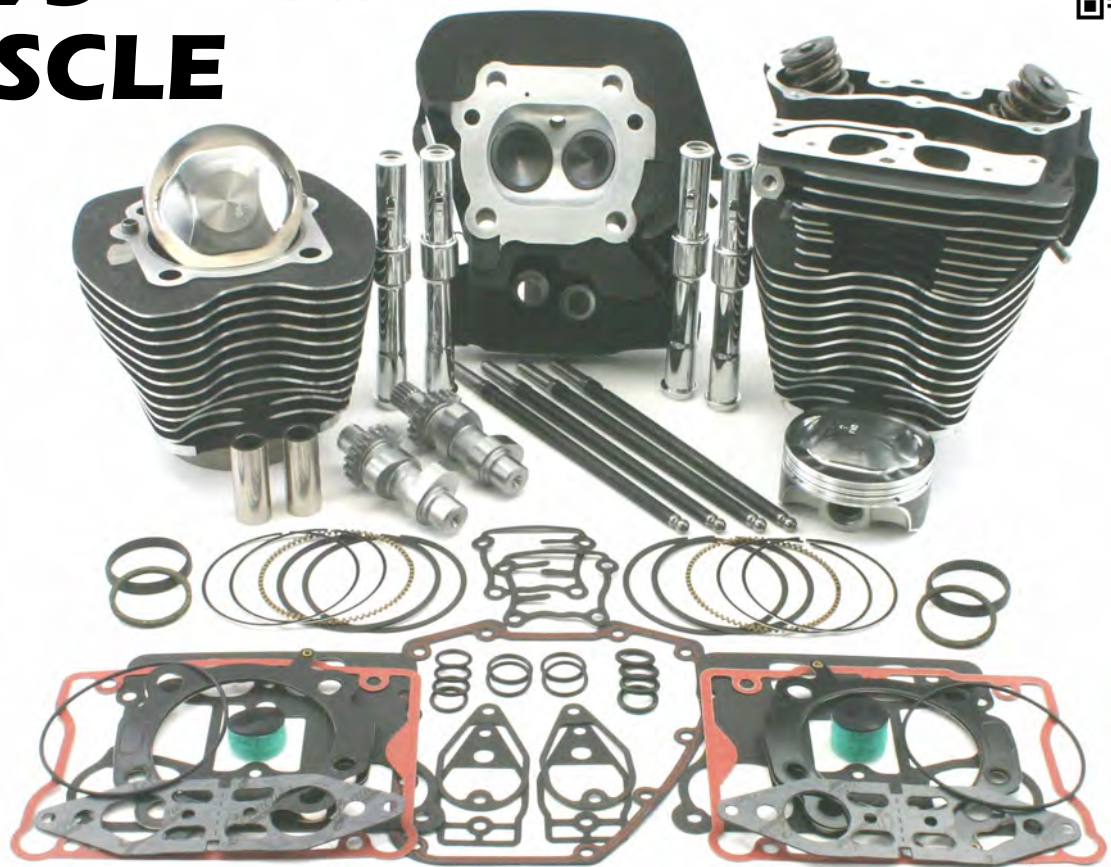
www.Zipper'sPerformance.com  
Zipper's@Zipper'sPerformance.com

Products on this page are not for sale or use on pollution controlled vehicles.





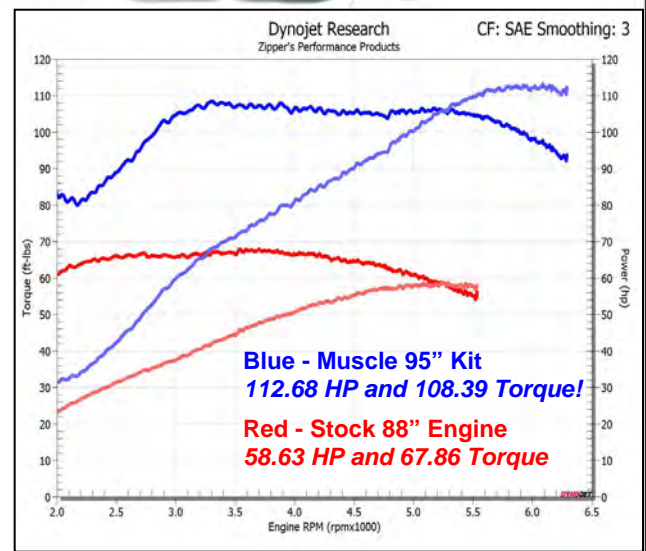
# '99-'06 TC 95" MUSCLE KIT



**Zipper's Original Muscle 95" Kit for '99-'06 Twin Cam® 88" engines has been providing great service for over 25 years!**

The Muscle 95 gets its displacement boost by increasing the cylinder bore size to 3.875" when paired with the factory stock 4" stroke crankshaft. Your cylinder tops are decked for trueness and new 10.5:1 forged pistons are precision-fit using the latest Sunnen equipment, while your heads receive Zipper's high-breathing Stage III treatment with CNC porting, new guides, oversize valves, performance springs and manual compression releases. Zipper's Red Shift 577 cams provide big torque & HP gains across the entire RPM range. Also included are Pro-Taper pushrods and EZ-Adjust covers, with all gaskets needed for assembly. **Highly recommended option:** Zipper's #417-495 blueprinted cam chest upgrade with our patented Red Shift Dual Piston hydraulic cam chain tensioners, blueprinted billet plate, HV oil pump, cam bearings and quality USA lifters for improved reliability and durability. # 417-495

**Zipper's Muscle 95" kit produces excellent, reliable Horsepower and Torque gains - year after year, mile after mile!**



**# 517-950** Muscle 95 kit for '99-'06 Twin Cam® engines  
**No Cost Options - Chrome or Black Pushrod Covers**

**# 417-495** Blueprinted cam chest upgrade kit including Plate/HV pump/RS dual piston tensioners/bearings/lifters

*This kit uses your factory head & cylinder cores sent in for modification. An exchange may be possible once your cores are cleaned, inspected and qualified for exchange.*



**Zipper's Performance Products**  
Elkridge, MD, 21075 - USA  
Phone: (410) 579-2828

www.ZippersPerformance.com  
Zippers@ZippersPerformance.com

Products on this page are not for sale or use on pollution controlled vehicles.



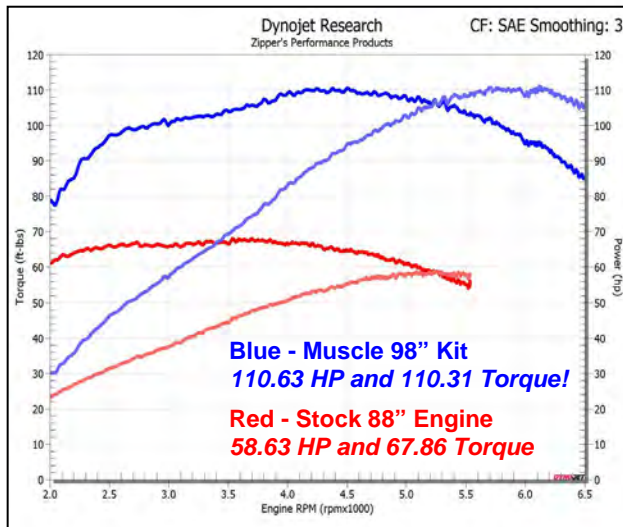


# '99-'06 TC 98" MUSCLE KIT



**Zipper's Muscle 98" Kit for '99-'06 Twin Cam® 88" engines boost torque and horsepower north of 110!** The Muscle 98 gets its displacement boost by increasing the cylinder bore size to 3.937" when paired with the factory stock 4" stroke crankshaft. Your cylinder tops are decked for trueness and new 10.5:1 forged pistons are precision-fit using the latest Sunnen equipment, while your heads receive Zipper's high-breathing Stage III treatment with CNC porting, new guides, oversize valves, performance springs and manual compression releases. Zipper's Red Shift 577 cams provide big torque & HP gains across the entire RPM range. Also included are Pro-Taper pushrods and EZ-Adjust covers, with all gaskets needed for assembly. **Highly recommended option:** Zipper's # 417-495 blueprinted cam chest upgrade with our patented Red Shift Dual Piston hydraulic cam chain tensioners, blueprinted billet plate, HV oil pump, cam bearings and quality USA lifters for improved reliability and durability. # 417-495

**The Muscle 98" kit produces 33% more Horsepower and 10% more Torque than a factory-stock 107" M8!**



# 517-952 Muscle 98 kit for '99-'06 Twin Cam® engines  
**No Cost Options - Chrome or Black Pushrod Covers**

# 417-495 Blueprinted cam chest upgrade kit including Plate/HV pump/RS dual piston tensioners/bearings/lifters

*This kit uses your factory head & cylinder cores sent in for modification. An exchange may be possible once your cores are cleaned, inspected and qualified for exchange.*



**Zipper's Performance Products**  
Elkridge, MD, 21075 - USA  
Phone: (410) 579-2828

www.ZippersPerformance.com  
Zippers@ZippersPerformance.com

Products on this page are not for sale or use on pollution controlled vehicles.





Zipper'sPerformance.com

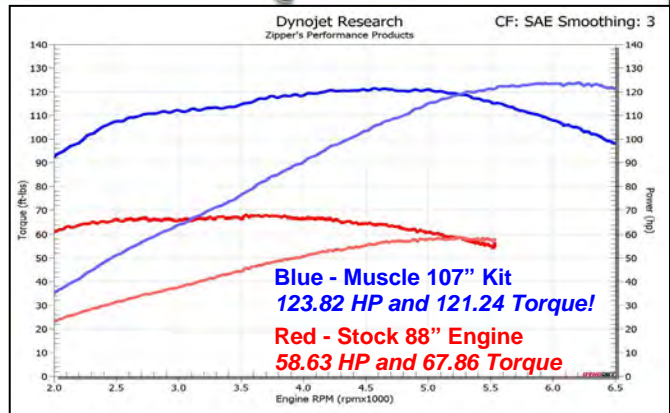
**ZIPPER'S**  
PERFORMANCE PRODUCTS

THE POWER OF EXPERIENCE

# '99-'06 TC MUSCLE 107" KIT



**Looking for a Big Power Boost for your '99-'06 Twin Cam?** Zipper's Muscle 107 kit will double the HP of a TC 88" engine - all while looking stock from the outside! A new 4-3/8" stroke crankshaft replaces the original 4" crank, while your cylinders are decked and precision fit with 3.937" 10.6:1 pistons. Your heads receive Zipper's Stage III CNC porting with new guides, oversize valves, performance springs and manual compression releases. Our Red Shift 577 cams provide big torque & HP gains across the entire RPM range. Also included are Pro-Taper pushrods and EZ-Adjust covers, with all gaskets needed for assembly. **Highly recommended option:** Zipper's #417-495 blueprinted cam chest upgrade with our Red Shift Dual Piston hydraulic cam chain tensioners, blueprinted billet plate, HV oil pump, cam bearings and quality USA lifters for improved reliability # 417-495 and durability. **Amazing New Life for the 1<sup>st</sup> Generation Twin Cam® - M8's BEWARE!**



- # 517-954 Muscle 107 kit '99-'06 Twin Cam® 'A' engines
  - # 517-955 Muscle 107 kit '99-'06 Twin Cam® 'B' engines
  - No Cost Options - Chrome or Black Pushrod Covers**
  - # 417-495 Blueprinted cam chest upgrade kit including Plate/HV pump/RS dual piston tensioners/bearings/lifters
- This kit uses your factory head & cylinder cores sent in for modification. An exchange may be possible once your cores are cleaned, inspected and qualified for exchange.*



Zipper's Performance Products  
Elkridge, MD, 21075 - USA  
Phone: (410) 579-2828

www.Zipper'sPerformance.com  
Zipper's@Zipper'sPerformance.com

Products on this page are not for sale or use on pollution controlled vehicles.



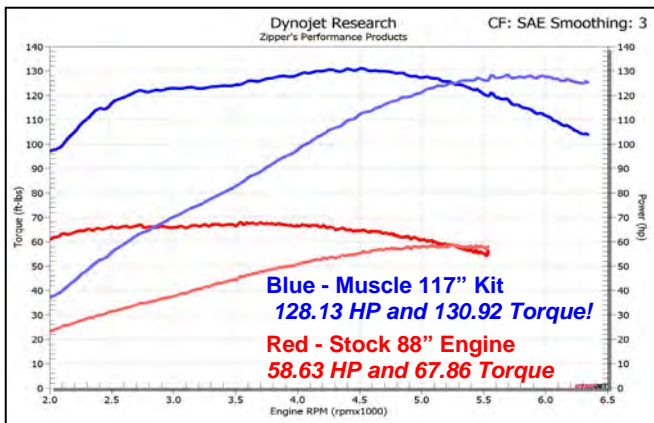


# '99-'06 TC MUSCLE 117" KIT



**Take your 88" Twin Cam to 117" with Zipper's Muscle 117 kit!** A new 4-3/8" stroke crankshaft replaces the original 4" crank; new stress-relieved 4-1/8" bore cylinders are precision fit with forged pistons set for 10.6:1 compression. Your heads receive Zipper's Stage III CNC porting with new guides, oversize valves, performance springs and manual compression releases. Our Red Shift 577 cams provide big torque & HP gains across the entire RPM range. Also included are Pro-Taper pushrods and EZ-Adjust covers, with all gaskets needed for assembly. **Highly recommended option:** our # 417-495 blueprinted cam chest upgrade with our Red Shift Dual Piston hydraulic cam chain tensioners, blueprinted billet plate, HV oil pump, cam bearings and quality USA lifters for improved reliability and durability. # 417-495 Case boring required, Timken recommended.

**Enjoy Big, Broad Power at every throttle position with the Muscle 117!**



# 517-956 Muscle 117 kit '99-'06 Twin Cam® 'A' engines  
# 517-957 Muscle 117 kit '99-'06 Twin Cam® 'B' engines  
**No Cost Options - Chrome or Black Pushrod Covers**  
# 417-495 Blueprinted cam chest upgrade kit including Plate/HV pump/RS dual piston tensioners/bearings/lifters  
*This kit uses your factory head cores sent in for modification. An exchange may be possible once your cores are cleaned, inspected and qualified for exchange.*



**Zipper's Performance Products**  
Elkridge, MD, 21075 - USA  
Phone: (410) 579-2828

www.ZippersPerformance.com  
Zippers@ZippersPerformance.com

Products on this page are not for sale or use on pollution controlled vehicles.



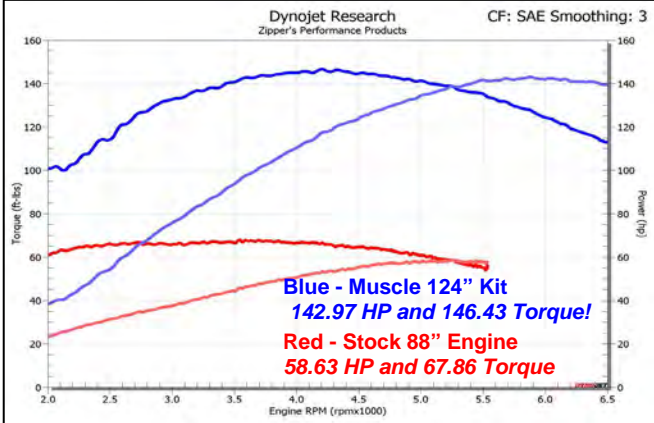


# '99-'06 TC MUSCLE 124" KIT



**Zipper's Muscle 124 kit delivers 140+ Twin Cam® HP & Torque!** A new 4-5/8" stroke crankshaft replaces the original 4" crank; new stress-relieved 4-1/8" bore cylinders are precision fit with forged pistons set for 10.75:1 compression. Your heads receive Zipper's Stage IV CNC porting with highly modified chambers, 2.0" intake, 1.630" exhaust valves, performance springs. Our Red Shift 657 cams provide stunning torque & HP gains across the entire RPM range. Also included are Pro-Taper pushrods and EZ-Adjust covers, with all gaskets needed for assembly. **Highly recommended option:** Zipper's #417-495 blueprinted cam chest upgrade with our Red Shift Dual Piston hydraulic cam chain tensioners, blueprinted billet plate, HV oil pump, cam bearings and quality USA lifters for improved reliability and durability. # 417-495 Case boring, Timken conversion required.

**CVO? M8? Make them all believers with Zipper's Muscle 124 Twin Cam®!**



# 517-958 Muscle 124 kit '99-'06 Twin Cam® 'A' engines  
 # 517-959 Muscle 124 kit '99-'06 Twin Cam® 'B' engines  
**No Cost Options - Chrome or Black Pushrod Covers**  
 # 417-495 Blueprinted cam chest upgrade kit including Plate/HV pump/RS dual piston tensioners/bearings/lifters  
*This kit uses your factory head cores sent in for modification. An exchange may be possible once your cores are cleaned, inspected and qualified for exchange.*



**Zipper's Performance Products**  
 Elkridge, MD, 21075 - USA  
 Phone: (410) 579-2828

www.ZippersPerformance.com  
 Zippers@ZippersPerformance.com

Products on this page are not for sale or use on pollution controlled vehicles.





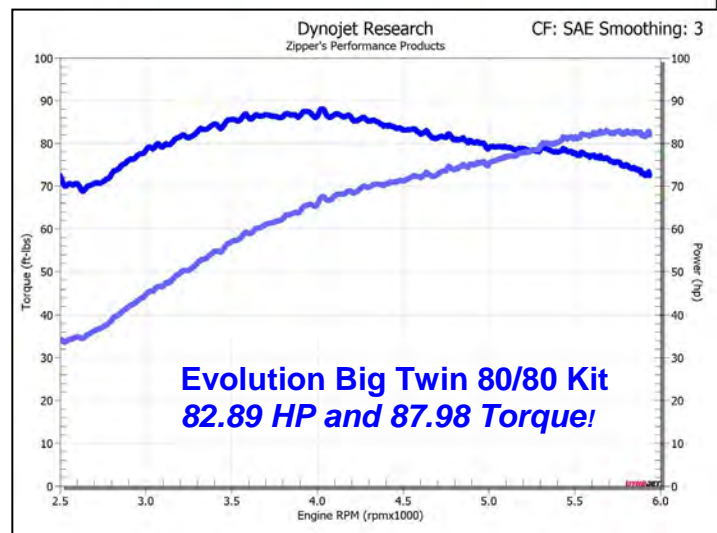
# 80/80 EV BIG TWIN KIT



**Zipper's 80/80 kit for Evolution Big Twins is still as popular as ever!** Its roots go back to the 80's, and we named it 80/80 due to the fact that it easily delivers over 80 HP from 80". Your cylinder base and head gasket surfaces are both decked true to stop those pesky leaks that EV's are known for. We precision-fit forged 10.5:1 pistons to them. Your heads receive CNC porting to Zipper's Stage III with 1.900" intake and 1.630" exhaust valves riding in Step-Lock guides with new valve springs and viton seals. Our Red Shift 559 cam is included with a new full compliment cam bearing; a steel breather gear replaces the factory plastic gear, and shims are included to set the end play on the cam and breather gear. Pro-taper pushrods control the valves and a top end/cam chest gasket set is included.

**Processing note:** Due to casting variations on early 80's heads, we may elect to add and dress a little welding to the spark plug side of the heads to prevent porting cut-through.

**This kit has remained a popular choice because it flat-out WORKS!**



**#517-930** '92-'99 Evolution® Big Twin 80/80 kit  
**#517-931** '84-'91 Evolution® Big Twin 80/80 kit

*This kit uses your factory head & cylinder cores sent in for modification.*



**Zipper's Performance Products**  
Elkridge, MD, 21075 - USA  
Phone: (410) 579-2828

www.ZippersPerformance.com  
Zippers@ZippersPerformance.com

Products on this page are not for sale or use on pollution controlled vehicles.





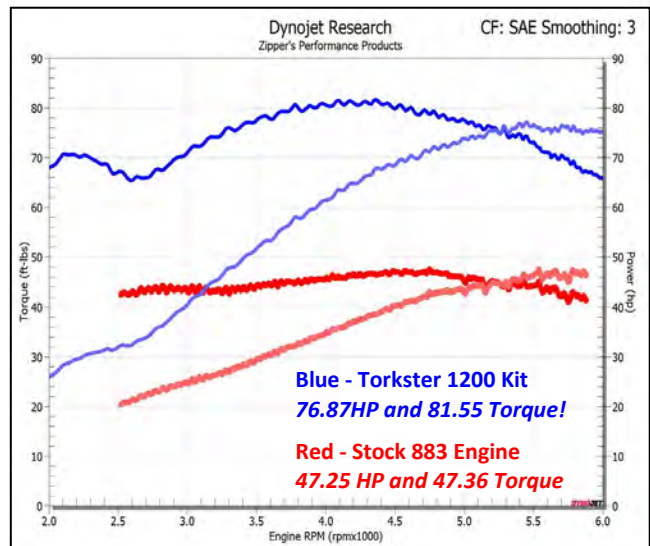
'91-'22 XL883  
Sportster®

# TORKSTER 1200 KIT



**Zipper's Torkster 883-1200 kit Increases Your 883's Horsepower output by 63% and its Torque by 72%!** The key to this huge increase is Zipper's High Velocity Stage II CNC headwork and carefully matched forged piston design. Your cylinders are decked on both ends, bored from 3" to 3.5" then honed on a state-of-the-art Sunnen SV-30. Heads receive CNC porting to Stage II specs and fitted with new Step Lock valve guides, stainless steel valves and upgraded valve springs. This combination promotes a great power curve, with torque topping 80 ft/lbs and HP over 75 - with factory camshafts! Supplied with a quality top end gasket set. **Easy to install, fantastic results!**

**Note regarding late 2009-up 883 cylinders:** Since the 883 was introduced in 1986, H-D® used a thick iron insert in the casting that allowed the 3" bore 883 cylinder to be safely bored to 3.5" for 1200cc displacement. Mid-year 2009, this changed. Less cast iron was used, and the cylinders can no longer be bored to 1200 (see cutaway photo). If you can see aluminum on the outside of the cylinder spigot (arrow), your cylinders can not be bored to 1200 due to the step circled in red. We try to keep used, earlier versions in stock that we can use for these applications, but this is subject to availability and finish. Contact our sales department for availability. An exact color may not be available and you may need to paint to match your engine. H-D® sells color-matching spray paint you can use for this. We do not recommend powder coating as the heat required to cure the PC will alter the precision-bored finish of the cylinders.



#517-910 '91-'E09 XL883 Torkster 1200 kit

#517-912\* 'L09-'22 XL883 Torkster 1200 kit

\*Includes reconditioned '04-'E09 cylinders

This kit uses your factory head & cylinder\* cores sent in for modification.



Zipper's Performance Products  
Elkridge, MD, 21075 - USA  
Phone: (410) 579-2828

www.Zipper'sPerformance.com  
Zipper's@Zipper'sPerformance.com

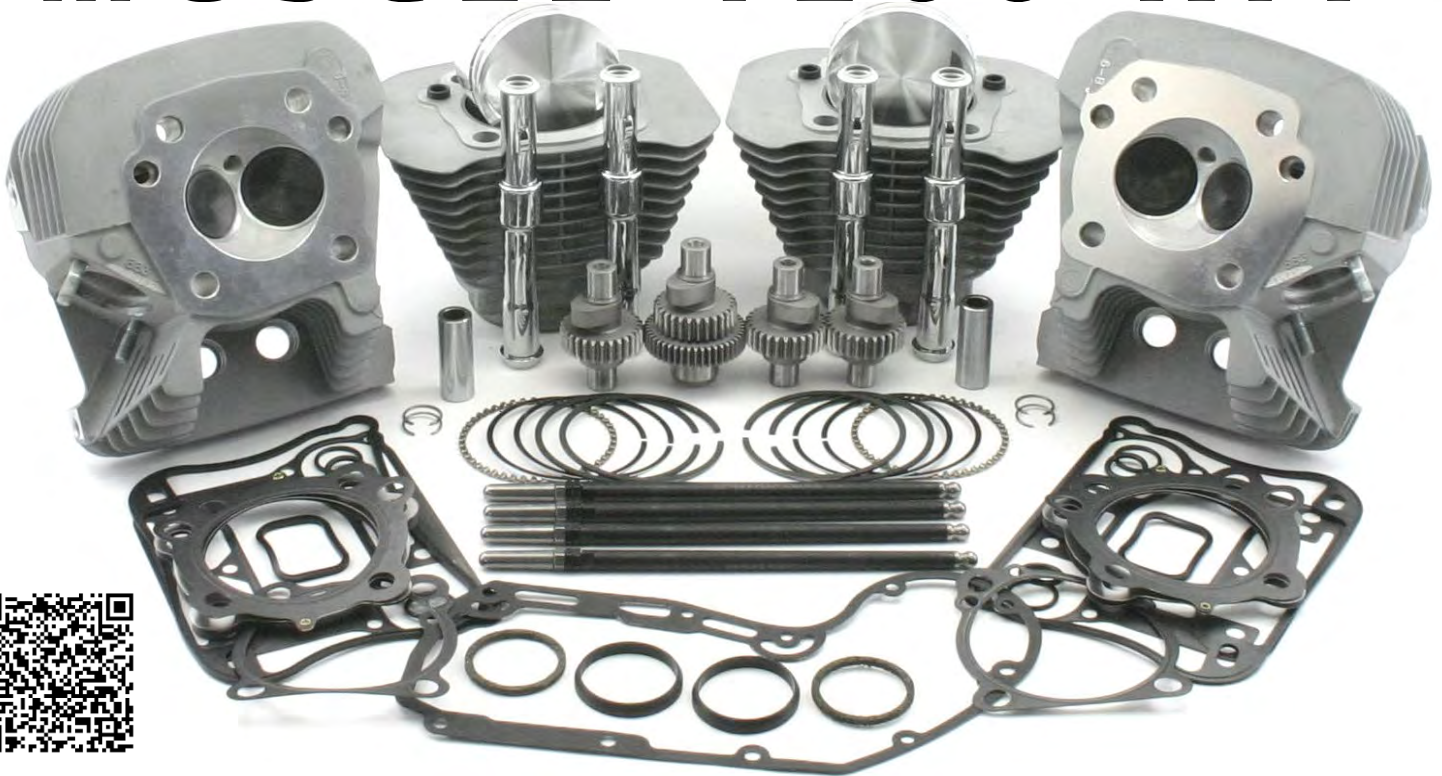
Products on this page are not for sale or use on pollution controlled vehicles.





'91-'22 XL883  
Sportster®

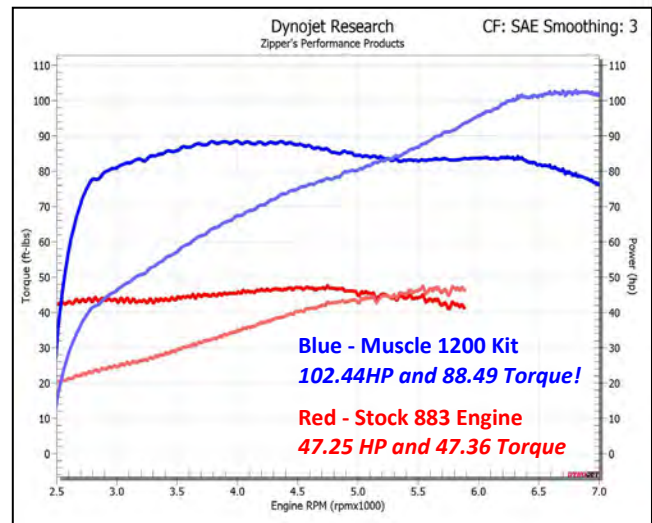
# MUSCLE 1200 KIT



**883's are great bikes for performance builds - they are light, plentiful, inexpensive and easy to add in some Muscle!**

Zipper's Muscle 1200 package puts real Sport in your Sportster®, and puts to rest the 'girl's bike' knock. The 883's small-chamber head makes a great base for a hot rod build. After CNC porting, we install new guides and add lightweight, larger (1.725" intake, 1.485" exhaust) 7mm valves with high lift conical springs. Forged 3.5" pistons bring the displacement to 1200cc, and along with Red Shift 575 cams, horsepower is increased by 116% and torque by 87% - HUGE gains! Also included are Pro-Taper pushrods, telescoping pushrod covers (your choice of chrome or black finish) and gaskets needed for assembly. **Leave those 883 stickers on the gas tank and have lots of fun hurting egos!**

**Note regarding late 2009-up 883 cylinders:** Since the 883 was introduced in 1986, H-D® used a thick iron insert in the casting that allowed the 3" bore 883 cylinder to be safely bored to 3.5" for 1200cc displacement. Mid-year 2009, this changed. Less cast iron was used, and the cylinders can no longer be bored to 1200 (see cutaway photo). If you can see aluminum on the outside of the cylinder spigot (arrow), your cylinders can not be bored to 1200 due to the step circled in red. We try to keep used, earlier versions in stock that we can use for these applications, but this is subject to availability and finish. Contact our sales department for availability. An exact color may not be available and you may need to paint to match your engine. H-D® sells color-matching spray paint you can use for this. We do not recommend powder coating as the heat required to cure the PC will alter the precision-bored finish of the cylinders.



- #517-914 '91-'03 XL883 Muscle 1200 kit
- #517-915 '04-'E09 XL883 Muscle 1200 kit
- #517-916\* 'L09-'22 XL883 Muscle 1200 kit

*\*Includes reconditioned '04-'E09 cylinders*

**No Cost Options - Chrome or Black Pushrod Covers.**

*This kit uses your factory head & cylinder\* cores sent in for modification.*



**Zipper's Performance Products**  
Elkridge, MD, 21075 - USA  
Phone: (410) 579-2828

www.Zipper'sPerformance.com  
Zipper's@Zipper'sPerformance.com

Products on this page are not for sale or use on pollution controlled vehicles.

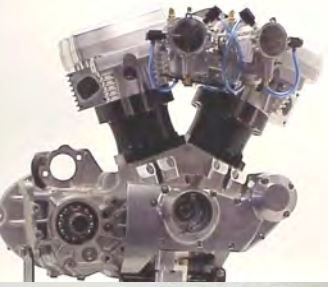




Zipper'sPerformance.com

# MAKING HARLEYS®

# GREAT SINCE 1981!!!



Zipper's Performance Products  
Elkridge, MD, 21075 - USA  
Phone: (410) 579-2828

www.Zipper'sPerformance.com  
Zipper's@Zipper'sPerformance.com

Products on this page are not for sale or use on pollution controlled vehicles.