



This (2 Page) Packing Slip Must Go In Your Shipping Box

Name: _____ Business Name: _____

Phone Number: () - Email: _____

Year: _____ Make: _____ Model: _____

Your Return Address:

Leave special notes about your requested repairs here:

Before you ship your parts for repair to VHM, you must do the following:

- Please remove all muck buildup. Do not sent parts covered in oil, clay, dirt, mud etc or an additional cleaning fee may be applied for the extra shop time to clean prior to servicing.
- Inspect your parts closely for damage - Examples: Damaged bolt/screw threads, previous poorly performed repairs, cracked covers/cases, cam journal scoring on heads, welded repairs, missing components, broken off bolt/studs etc.
- We can assist with almost any concern you have, but it is best everyone is aware prior to you shipping – see above
- Contact VHM with any questions or concerns about your project. Phone, text, or email are all appreciated.
- Hi quality photos and a conversation before you ship questionable parts out can be the difference between you sending us a paperweight or a part that will be refurbished and ready for another generation of riding.
- Package up your parts very securely in a quality box and carry insurance for your contents.

VHM's Pledge to You:

- All services will be performed in our facility by licensed master motorcycle mechanics and skilled machinists.
- Professionalism and excellent communication will be provided.
- Documented quality control checkpoints throughout the repair process will be provided.
- Final testing and measurement readings performed to make sure everything is in spec will be documented.
- Hi-resolution pictures and detailed documentation supporting your part(s) repairs, when applicable, will be provided.

VHM Contact Information and Repairs Shipping Address

- Owner: Josh Eule
- Cell Phone: 540-207-9170
- Email: JoshEule@gmail.com

Ship to:
Josh Eule – VHM Repairs
1358 Saffron Circle
Traverse City, MI 49696

VHM Cylinder Boring and Honing Service

VHM can machine 1.54"-2.44" (39mm-62mm) single iron bore cylinders

****Cylinders must be machined to the piston being installed****

- VHM cannot service electroplated cylinder walls (Nikasil or similar) – We focus on iron cylinders walls.
- VHM cannot properly machine a cylinder without having the piston in hand.
- VHM can supply the piston or you may supply your own if you are sure of your correct piston needs.
- VHM recommends a second over piston to machine out any defects from your original cylinder walls.
- VHM stocks quality piston kits for Honda the CT70 , Z50, and QA50, others would need to be ordered in.
- VHM can order other pistons if necessary, but turnaround time will be contingent on needed parts arrival.
- After VHM blasts your cylinder clean, if exterior is left unpainted, the cast iron **can develop flash rust.**

Please Check Off All Services and Piston Kits Wanted (Check Boxes Below):

LABOR – Blast Clean + Bore + Plateau Hone Cylinder

- ☐ **4-Stroke Bore and Hone Service for Cast Iron Cylinder, w/ iron sleeve – \$120.00**
- ☐ **4-Stroke Bore and Hone Service for Cast Aluminum Cylinder w/ iron sleeve - \$160.00**
- ☐ **2-Stroke ONLY – Port chamfering labor is required – ADD \$30.00 to above**

Labor includes:

- * Degreasing + blasting clean and **machining up to .020" (.50mm) over existing bore**
 - ◆ Remove remaining gasket material and oils
 - ◆ Note - Aluminum cylinders (Example XR75, CRF110, Grom/MSX) include the premium vapor hone cleaning step for a final satin raw aluminum finish
- * Iron cylinder painting is NOT included in this price, see additional services below to add "Painting Service"
- * Take measurements on cylinder bore + take measurements on piston skirt
- * Precision bore to required piston skirt to cylinder wall clearance
- * Inspect for defects in cylinder wall, bore again only if needed
- * Precision plateau hone process (Multiple grit stone process for proper control of the cross hatch peaks and valleys)
- * Ensure ring gaps meet needed specifications
- * Provide photos of process and written documentation of the before vs final measurements

ADDED LABOR - Additional service charges beyond what is described above

- ☐ Cylinders requiring machining of .0201" - .040" (.51mm-1.00mm) over existing bore – **\$15.00**
- ☐ Cylinders requiring machining of .0401" + (1.01mm +) over existing bore – **\$30.00**
- ☐ Excessive cleaning labor (Please pre clean to avoid) - 15 Minutes Intervals – **\$25.00 (Shop Rate is \$100/hr)**
- ☐ Painting Service - Mask, paint, and (bake) cure paint. Hi-temp paint, choose Black or Silver – **\$30.00**

PARTS – VHM's supplied piston kits include the rings, wristpin and circlips

- ☐ Honda CT70 6V domed piston kit (47.50mm 2nd over) – **\$32.00, in stock**
- ☐ Honda Z50 6V domed piston kit (39.50mm 2nd over) – **\$32.00, in stock**
- ☐ Honda QA50 piston kit (42.50mm 2nd over) – **\$65.00, in stock**
- ☐ Honda XR Series piston kit (Wiseco Forged Offering) – **Please inquire**
- ☐ Honda CT90 piston kit (TBD) – **Please inquire**
- ☐ **Other cylinders from 2 stroke and 4 stroke singles welcome (Max 62mm) – Please inquire**
- ☐ **Gasket kits and more – Please inquire**

Return Shipping will be tracked and insured – Typically \$20.00

Revision: October 2026