



3151 Charleston Hwy
West Columbia, SC 29172

credit@blanchardmachinery.com
Phone : (866) 313-0432

PLEASE REMIT TO: BLANCHARD MACHINERY CO. P.O. BOX 402197 Atlanta, GA 30384-2197	
CUSTOMER NUMBER	9PF3470
CUSTOMER ORDER NUMBER	
INVOICE NUMBER	FF05350
INVOICE DATE	03/26/2020
DUE 04/25/2020	15,311.39

SOLD TO

WARRANTY-NEW,OTHER,GOV
PIONEER - FLORENCE
SERVICE DEPT
DIRECT EXPENSE
BMC-INTERNAL SC

SHIP TO

MAKE	MODEL	SERIAL NUMBER	EQUIPMENT NUMBER	METER READING	MACH. ID NO.
AA	C18	0WRH05848		4688.0	
QUANTITY	ITEM	DESCRIPTION	UNIT PRICE	EXTENSION	
		REPAIR ENGINE COMPLAINT: COMPRESSION IN RADIATOR PUSHING COOLANT OUT. CAUSE:BLOWN HEAD GASKET AT #5 CYLINDER. RESULTANT DAMAGE: CYLINDER HEAD, COUNTER-BORE AND LINER. CORRECTION: PRESSURE TESTED COOLING SYSTEM, UNABLE TO PRODUCE PRESSURE DUE TO LEAKAGE, VERIFIED NO COOLANT GETTING INTO CRANKCASE, REMOVED SHEET METAL AND COMPONENTS TO GAIN ACCESS TO ENGINE, UNABLE TO REMOVE HEAD IN THE MACHINE, REMOVED ALL EXHAUST AND INTAKE COMPONENTS, DISCONNECTED ALL HOSES AND WIRING, REMOVED CLUTCH HOUSING BOLTS, REMOVED ENGINE MOUNTING BOLTS, REMOVED ENGINE FROM MACHINE, BLOCKED UP ENGINE AND REMOVED CYLINDER HEAD, FOUND HEAD GASKET WAS BLOWN AT #5 CYLINDER, LINER, HEAD AND BLOCK DAMAGED DUE TO LINER MOVEMENT,REMOVED CYLINDER PACK, SENT HEAD TO MACHINE SHOP, CLEANED ALL PARTS AND ORDERED WHAT WAS REQUIRED TO REPAIR, REPAIRED COUNTER-BORE AND SET LINER PROTRUSION, TORQUED ROD BOLTS, AND ASSEMBLED OIL PAN, INSTALLED NEW HEAD SPACER PLATE, GASKET AND CYLINDER HEAD, INSTALLED COMPONENTS REMOVE FOR HEAD REPLACEMENT, INSTALLED ENGINE BACK IN MACHINE, TIGHTENED MOUNTING BOLTS, INSTALLED BOLTS FOR CLUTCH HOUSING, CONNECTED ALL WIRING AND HOSES, ASSEMBLED EXHAUST AND AIR INTAKE SYSTEM, INSTALLED ALL REMOVED COMPONENTS AND SHEET METAL, FILLED FLUID LEVELS, RAN TO TEST FOR			
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LEAKS, NONE WERE FOUND, RECHECKED FLUID LEVELS , RAN AGAIN TO CHECK OPERATION AND PERFORMANCE, RETURNED MACHINE TO SERVICE.					
2	1R-1808	FILTER-ENGINE OIL S	29.79	59.58	
1	1S-9540	DOWEL S	5.90	5.90	
8	2N-2765	BOLT-HIGH TEMP S	9.00	72.00	
16	2N-2766	LOCK NUT S	5.09	81.44	
24	3E-6772	SEAL-WATER S	2.77	66.48	
1	3P-1155	SEAL-O-RING S	6.44	6.44	
30	3S-2093	TIE S	.18	5.40	
1	4N-1114	COVER N	21.62	21.62	
1	4N-1650	DOWEL S	5.26	5.26	
1	5E-8771	O RING S	16.99	16.99	
26	5H-1504	WASHER S	1.17	30.42	
2	5P-0840	SEAL-O-RING S	4.31	8.62	
1	5P-5846	SEAL O RING S	12.43	12.43	
1	5P-8068	SEAL S	11.61	11.61	
1	6I-1055	DOWEL N	3.70	3.70	
1	6I-4421	SPACER PLATE S	419.54	419.54	
1	6V-3683	SEAL O RING S	6.13	6.13	
20	7K-1181	TIE S	.33	6.60	
2	7M-7273	GASKET S	8.33	16.66	
4	8C-5230	SEAL O RING S	13.21	52.84	
1	8J-4351	SEAL-O-RING S	9.54	9.54	
6	8S-9191	BOLT S	1.27	7.62	
6	9X-7317	SEAL O RING S	3.42	20.52	
1	9Y-6089	GASKET S	3.68	3.68	
1	061-9455	SEAL S	10.04	10.04	
1	101-3125	GASKET S	5.30	5.30	
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1	109-0077	SEAL 0 RING S	9.78	9.78	
2	112-3540	SEAL 0 RING S	8.46	16.92	
2	113-5304	SEAL 0 RING S	15.52	31.04	
1	117-8801	SEAL 0 RIN S	18.31	18.31	
3	121-0145	SEAL - 0-RIN S	3.29	9.87	
1	122-3772	SEAL 0 RING S	11.34	11.34	
10	124-1854	BOLT 12PT S	16.70	167.00	
16	124-1855	BOLT 12PT S	15.17	242.72	
1	125-0434	SEAL S	16.05	16.05	
2	126-4935	SEAL S	9.33	18.66	
1	142-2329	SEAL - DRAIN N	13.76	13.76	
18	149-7378	GROMMET S	4.79	86.22	
1	155-0696	SUPPORT AS N	72.96	72.96	
1	155-0698	SUPPORT AS N	60.62	60.62	
1	160-7037	SEAL - INTEGRA N	8.78	8.78	
1	160-7271	SEAL - PRESS S	36.23	36.23	
1	167-4407	SEAL - 0-RIN S	3.02	3.02	
2	188-0210	GASKET - RAI S	17.18	34.36	
2	197-8419	GASKET S	2.49	4.98	
1	20R-0631	CYL PCK AS N	607.19	607.19	
1		CORE DEPOSIT N	190.07	190.07	
1-		CORE RETURN N	190.07	190.07-	
1	214-7568	SEAL 0 RING S	3.53	3.53	
1	227-1204	GASKET S	51.81	51.81	
6	230-3728	SEAL S	6.62	39.72	
6	230-3775	SEAL S	8.65	51.90	
24	238-8648	CAT ELC S	12.29	294.96	
3	242-9537	GASKET - VALVE COVERS	41.45	124.35	
1	272-0390	SEAL S	85.54	85.54	
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1	326-1643	FILTER-FUEL	S	38.03	38.03
1	330-3517	SEAL-O-RING	S	8.39	8.39
1	341-1429	SEAL-PIP	S	6.46	6.46
1	359-0908	GASKET-CYL HEAD	S	103.16	103.16
10	5153973	15W40 ULS DEO OIL	S	17.36	173.60
1	85400	SINGLE SOS	S	12.88	12.88
		TOTAL PARTS	SEG. 01		3430.50 *
	FLOR/DARL	WARRA 9.18 RT HOURS			1069.10
	FLOR/DARL	WARRA 13.64 RT HOURS			1588.51
	WARRANTY	8.00 RT HOURS			931.68
	PMC CAT W	36.00 RT HOURS			4192.57
	PMC CAT W	21.35 RT HOURS			2486.42
		TOTAL LABOR	SEG. 01		10268.28 *
		SEGMENT 01 TOTAL			13698.78 T

	INSPECT CYLINDER HEAD ASSEMBLY				
	REMOVED EXHAUST MANIFOLDS, EXHAUST STUDS, LIFTING				
	BRACKETS, AND 2 SENSORS. WASHED AND PRESSURE				
	TESTED HEAD. NO LEAK WAS FOUND. CLEANED AND				
	INSPECTED DECK SURFACE. DECK WAS FLAT BUT HAD SOME				
	FRETTING BETWEEN #5 & 6 CYLINDERS. CHECKED VALVE				
	RECESSION AND FOUND 1 INTAKE VALVE THAT WAS				
	RECESSED WELL BEYOND THE SPEC. CLEANED WORK AREA.				
	WARRANTY	4.02 RT HOURS			468.17
		TOTAL LABOR	SEG. 03		468.17 *
		SEGMENT 03 TOTAL			468.17 T

	REPAIR CYLINDER HEAD ASSEMBLY				
	REMOVED INTAKE VALVES FROM #1 CYLINDER. ONE OF THE				
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VALVES AND SEATS HAD WORN EXCESSIVELY. CLEANED ALL GASKET SURFACES. INSTALLED 1 INTAKE SEAT AND VALVE, 2 VALVE SEALS, AND 4 LOCKS. REPLACED ALL EXHAUST STUDS AND NUTS. CLEANED AND INSTALLED EXHAUST MANIFOLDS.					
2	2A-4429	RETAINER/KEEPER S	.70	1.40	
12	2N-2766	LOCK NUT S	5.09	61.08	
12	106-1792	STUD-TAPERLOCK S	10.58	126.96	
2	163-2478	SEAL-VALVE S	2.07	4.14	
1	280-3979	INSERT-VALVE S	15.00	15.00	
6	281-8261	SLEEVE AS EXHAUST S	21.20	127.20	
1	490-7198	VALVE-INTAKE S	54.00	54.00	
		TOTAL PARTS	SEG. 04	389.78	*
	WARRANTY	4.87 RT HOURS		567.16	
		TOTAL LABOR	SEG. 04	567.16	*
		SEGMENT 04 TOTAL		956.94	T

RESURFACE CYLINDER HEAD ASSEMBLY SET UP HEAD ON MILL. RESURFACED HEAD, REMOVED .012". DEBURRED AND WASHED HEAD AFTER MACHINING. HAD TO REMOVE THE NEW INTAKE VALVE AND GRIND ENOUGH OFF OF THE FACE TO GET THE RECESSON BACK IN SPEC AFTER MACHINING. CLEANED MACHINE AND WORK AREA.					
	WARRANTY	1.61 RT HOURS		187.50	
		TOTAL LABOR	SEG. 05	187.50	*
		SEGMENT 05 TOTAL		187.50	T

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