



SERVICE INVOICE

INVOICE NUMBER SCINV774125
INVOICE DATE 12/21/2023
PO NUMBER 007

BILL TO
MFC Trucking LLC
4400 NE 77th Ave Ste 275
Vancouver, WA 98662
USA

SHIP TO
MFC Trucking LLC
101 Quarry Drive
Milford, MA 01757
USA

SERVICE CALL		INVOICE ACCOUNT	ORDER ACCOUNT	STORE		SALESPERSON		PAGE
CSR0820741		8033322	8033322	Milford - Power Systems		Dockrey, Tom		1 of 9
MAKE	MODEL	SERIAL NUMBER	CUSTOMER EQUIPMENT NUMBER	MILTON CAT EQID	SMU	DIVISION		
AA	C15 TRK	NXS11952		EQ267062	900000	Engine		
QTY	TRANS	DESCRIPTION			UNIT PRICE	EXTENDED PRICE		

01 TROUBLESHOOT - ENGINE

Make: AA Model: C15 TRK Serial Number: NXS11952 SMU: 900000

Customer complaint: Using Coolant
Resultant damage: Using Coolant
Cause of failure:
Repair process comments: 9/8/23 --- 0441 --- Connect electronic service tool. Create warranty report. Customer reports that the engine is using coolant, approx 3 gallons a day. There are low coolant level codes logged. Pressure test cooling system. No external leaks present. Run engine & perform bottle test to check for air/combustion in the cooling system. There are a lot of bubbles present at 1200 rpms within 45 seconds. Disconnect air compressor coolant lines. Run engine & perform bottle test again. There are a lot of bubbles present. The cylinder head needs to be removed. Disconnect batteries. Drain engine oil. Drain coolant. Remove air cleaner line & aftercooler lines.
9/11/23 --- 0441 --- Remove air inlet pipe, turbo duct work, turbo cold housings & turbo oil lines. I noticed that the intake valve actuator oil supply line has been removed. Remove middle valve cover. The intake valve actuator is installed & the solenoids are plugged into the harness. The ECM has a 625HP flash file# 3298557 installed in it. The engine was rerated to 550HP April 7 2021.
The current flash file must not look at/require intake valve actuator operation or there would be codes for the system logged.
I don't want to continue to disassemble the engine any further with out a plan on how these issues will be addressed. The engine should be put back to the proper flash file & what ever has been altered/tempered should be put back to original CAT spec
Instructed to disassemble the engine.
9/12/23 --- 0441 --- Remove high pressure turbo, coolant diverter valve, turbo precooler, turbo precooler mounting bracket, radiator support rods, upper radiator hose, thermostat housing, belts, belt tensioners, coolant/fuel manifold, fuel lines, coolant lines, OEM wiring, CAT wiring, cam gear cover, cam idler gear, cam gear, cam gear adapter, coolant expansion tank, valve covers, intake valve actuator/engine brake housings, rocker shaft assemblies, valve bridges, injectors & valve cover base. Remove cyl head & spacer plate. The head gasket is bad/burnt between several of the cylinders. Between cyl #5 & #6 is the very bad. The cyl head is cracked between the exhaust valve in cylinders #2, #3, #4, #5. Remove car carrier support crossmember from under the truck. The support & crossmember are cracked in a few areas & has been welded in other areas. Remove oil pan, oil pump oil lines, oil pump & block stress plate.
9/13/23 --- 0441 --- Remove turbo outlet pipe, low pressure turbo & low pressure turbo mounting bracket. Remove piston cooling jets & piston/liner assemblies. The liners have areas that are glazed/polished. Clean engine block deck & cylinder bores. Rethread cyl head bolt mounting holes. Get parts quote.
9/14/23 --- 0441 --- Clean parts.
9/15/23 --- 0441 --- Clean & paint parts.
9/25/23 --- 0441 --- Remove oil cooler front elbow/bonnet, oil cooler & oil filter housing. Clean parts. Disassemble oil filter housing. Assemble oil filter housing with new springs, relief valves & seals. Disassemble thermostat housing. Install new thermostats/seals. Clean parts. Assemble thermostat housing. Disassemble coolant diverter valve. Clean parts. Install new seals/diaphragm. Assemble coolant diverter valve.
9/26/23 --- 0441 --- Clean & paint reman cyl head. Transfer components from old cyl head to reman cyl head. Install reman camshaft in reman cyl head.
9/27/23 --- 0441 --- Install exhaust manifold onto cyl head with new exhaust packings/shields. Install new block plugs. Clean & paint parts.
9/28/23 --- 0441 --- Install new main bearings & thrust bearings, torque to spec.
9/29/23 --- 0441 --- Install .030" liner shins/inserts in the cyl block for each cylinder. Install 6 reman piston/liner assemblies with new rod bearings, torque to spec. Measure liner height projection. All liner height measurements are .004" to .005", all within spec. Install piston cooling jets, torque to spec, reman oil pump, block stress plate & oil pump oil lines. Install new spacer plate & reman cyl head with new head bolts, torque to spec. Install cam gear adapter, cam gear, cam idler gear & cam gear cover. Install 6 reman injectors with new hold down bolts, torque to spec. Replace all rocker arms with reman rocker arms on new rocker shafts. Install new valve bridges, rocker shaft assemblies with new mounting bolts,

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Customer Number: 8033322
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Agreement Number: SCINV774125

Please make checks payable to:

Amount Due: 49,446.04
Amount Enclosed:

Southworth-Milton, Inc.
P.O. Box 3851
Boston, MA 02241-3851

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AA	C15 TRK	NXS11952		EQ267062	900000	Engine
QTY	TRANS	DESCRIPTION		UNIT PRICE	EXTENDED PRICE	

torque to spec.
10/2/23 --- 0441 --- Adjust intake/exhaust valves & injectors. Install valve cover base & intake valve actuator/engine brake housings. Adjust intake valve actuators & engine brakes. Install coolant/fuel manifold, fuel lines, coolant lines & valve covers. Install new coolant lines, oil line & air line for the air compressor. Install oil filter housing, rear oil cooler bonnet/elbow, reman oil cooler & front oil cooler bonnet/elbow. Install low pressure turbo mounting bracket & turbo precoolers mounting bracket.
10/3/23 --- 0441 --- Install oil pan, new oil filter, thermostat housing, low pressure turbo, turbo outlet pipe, low pressure turbo oil lines, high pressure turbo, high pressure turbo oil lines, turbo precoolers, turbo cold housing, turbo duct work, coolant expansion tank & air cleaner line. Add engine oil. Install new primary & secondary fuel filters. Connect batteries.
10/5/23 --- 0441 --- Run engine. Road test. Check engine brake operation, OK. During road test code 285-7 Intake valve actuator #1 not responding properly became active. Perform intake valve actuator solenoid test to check all of the intake valve actuator solenoids. #1 Intake valve actuator Not OK. Need to replace the intake valve actuator solenoids on the #1, #2 intake valve actuator housing they are to be replaced as pairs.
10/9/23 --- 0441 --- Remove front valve cover. Install reman intake valve actuator solenoids for cyl #1, #2. Install valve cover. Clear code. Run engine to temp. Perform intake valve actuator solenoid test. All cylinders OK. Road test, OK.

Miscellaneous

1	Environmental Services	0.00	0.00
		Total Segment Parts	0.00
		Total Segment Labor	0.00
		Total Segment Miscellaneous	0.00
		Segment 01 Total:	0.00

Purchase Order 007

11 ALLOCATED - PARTS

Make: AA Model: C15 TRK Serial Number: NXS11952 SMU: 900000

Parts

1	0546233	Spacer	15.84	15.84
2	0617540	Seal O Ring	12.24	24.48
7	08179-112	3M Pro Care Brake Cleaner	4.70	32.90
1	0S1576	Bolt	2.67	2.67
2	1028802	Recptacle Kt	5.16	10.32

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QTY	TRANS	DESCRIPTION		UNIT PRICE	EXTENDED PRICE	

1	1029089	Cover		22.89	22.89
2	1046202	Clip Ladder		7.43	14.86
3	1070583	Bolt Locking		0.29	0.87
2	1090077	Seal O Ring		14.08	28.16
1	1124387	Elbow		13.86	13.86
2	1135304	Seal		22.34	44.68
6	1185068	Seal O Ring		2.81	16.86
3	1190036	Screw		2.90	8.70
1	1250434	Seal		23.12	23.12
3	1261756	Locking Bolt		0.44	1.32
6	1440367	Clamp		18.24	109.44
10	1556198-200	110197 DEO 10W30 BUL		19.86	198.60
1	1584220	Harness		27.83	27.83
4	1616963	Clamp		0.54	2.16
1	1653929	Bolt-Hex Hea		0.81	0.81
2	1653935	Bolt-Hex Hea		1.90	3.80
4	1687800	Locknut		3.11	12.44
1	1723443	Hose As		44.32	44.32
1	1723450	Tube As		73.87	73.87
2	1724702	Clamp		1.69	3.38
2	1780481	Film-Tradema		18.14	36.28
1	1780482	Film-Tradema		18.54	18.54
1	1979631	Grommet		19.20	19.20
1	1A5350	Clip		3.36	3.36
8	1B2790	Cap Screw		0.49	3.92
4	1P4278	Clamp		2.01	8.04
1	2201206	Hose As		43.70	43.70
1	2242642	Hose		6.56	6.56
1	2284801	Valve Gp-Sol		179.86	179.86
1	2313269	Coil As-Top		23.07	23.07
1	2351842	Tube As		38.61	38.61
1	2355678	Seal-O-Ring		1.05	1.05
2	2385081	Seal-O-Ring		6.74	13.48
2	2385084	Seal-O-Ring		9.69	19.38

Continued

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AA	C15 TRK		NXS11952				EQ267062	900000	Engine
QTY		TRANS		DESCRIPTION			UNIT PRICE		EXTENDED PRICE

1	2388253	Hose	7.64	7.64
1	2388648	Coolant-Elc	17.72	17.72
2	2388649	Coolant-Elc	86.58	173.16
1	2470266	Hose	60.12	60.12
1	2545319	Brush Flap	58.48	58.48
1	2566453	Sensor Gp-Te	55.78	55.78
1	2568753	Filter As Se	31.38	31.38
1	2769507	Hose	26.39	26.39
2	2843502	Clamp-Band	5.59	11.18
1	2869133	Valve As-Che	59.60	59.60
8	2N2766	Lock Nut	7.34	58.72
1	3196059	Kit-Diaphrag	196.32	196.32
1	3217384	Hose As	54.24	54.24
1	3401286	Hose As-Supp	158.38	158.38
1	3441950	Clip-Half Sl	4.64	4.64
1	3441951	Clip-Half Ta	3.79	3.79
1	3460344	Spacer	2.09	2.09
2	3798578	Shield As	89.01	178.02
2	3805855	Seal As	102.27	204.54
2	3929208	Plunger-Reli	27.68	55.36
5	4589582	Paint-Primer	13.48	67.40
1	4858534	Tape-Masking	14.53	14.53
1	4C8420	Insert Pkg	18.14	18.14
2	4N8150	Spring	11.10	22.20
4	4P7581	Clip	5.13	20.52
4	4P8134	Clip	5.37	21.48
1	5900184	Paint-Black	13.43	13.43
2	5900196	Paint-Yellow	13.48	26.96
2	6052193	Wiper	8.40	16.80
200	6K0806	Strap-Cable	0.44	88.00
1	6K3607	Connector	8.39	8.39
250	6V8523	Cm Hose Stk	0.09	22.50
50	7K1181	Strap Cable	0.48	24.00
1	7K9197	Elbow	6.92	6.92

Continued

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AA	C15 TRK	NXS11952		EQ267062	900000	Engine
QTY	TRANS	DESCRIPTION		UNIT PRICE	EXTENDED PRICE	

150	8C3681	Cm Hose Stk	0.21	31.50
2	8C5230	Seal O Ring	19.00	38.00
4	8T4984	Clamp	17.79	71.16
1	8T5917	Seal-O-Ring	2.20	2.20
2	8T6703	Clamp	17.79	35.58
5	9S8004	Plug	8.70	43.50
2	9S9334	Plug	9.46	18.92
1	LT40464-112	LOCTITE SI 593 BK AE	23.82	23.82
1	LT51147-112	LOCTITE LB 8008 C5-A	14.94	14.94

Miscellaneous

1	Environmental Services	0.00	0.00
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Total Segment Parts	3,221.67
Total Segment Labor	0.00
Total Segment Miscellaneous	0.00
Segment 11 Total:	3,221.67

Purchase Order 007

12 MACHINE/GRIND/MILL - ENGINE

Make: AA Model: C15 TRK Serial Number: NXS11952 SMU: 900000

Parts

6	6I4361	Insert Seat	97.16	582.96
---	--------	-------------	-------	--------

Labor

Total Labor	1,110.00
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Continued

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AA	C15 TRK	NXS11952		EQ267062	9000000	Engine
QTY	TRANS	DESCRIPTION		UNIT PRICE	EXTENDED PRICE	

Miscellaneous

1

Environmental Services

45.51

45.51

Total Segment Parts582.96

Total Segment Labor1,110.00

Total Segment Miscellaneous45.51

Segment 12 Total:

1,738.47

Purchase Order 007

13 REPROGRAM - ELECTRONICS

Make: AA Model: C15 TRK Serial Number: NXS11952 SMU: 900000

Miscellaneous

1 SVC_Re-rate

1 Flat Rate Miscellaneous Re-rate

1 Environmental Services

Total Segment Parts0.00

Total Segment Labor197.00

Total Segment Miscellaneous0.00

Segment 13 Total:

197.00

Purchase Order 007

15 RECONDITION - RADIATOR

Make: AA Model: C15 TRK Serial Number: NXS11952 SMU: 900000

Parts

2 1440367

Clamp

18.24

36.48

Continued

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QTY	TRANS	DESCRIPTION		UNIT PRICE	EXTENDED PRICE	

2	3E9861	Locknut	5.31	10.62
4	3K6060	Nut	0.84	3.36
4	6N8863	Washer	1.16	4.64
4	9X6458	Washer Hard	0.73	2.92

Labor
Total Labor
1,355.00

Miscellaneous				
1	SVCOWM_035	Radiator support rod bushings (6)`	200.45	200.45
1	SVCOWM_10	Inspect and reseal radiator	1,303.50	1,303.50
1		Environmental Services	55.56	55.56
Total Segment Parts				58.02
Total Segment Labor				1,355.00
Total Segment Miscellaneous				1,559.51
Segment 15 Total:				2,972.53

Purchase Order 007

99 TROUBLESHOOT - ENGINE

Make: AA Model: C15 TRK Serial Number: NXS11952 SMU: 900000

Parts				
1	0R9449	Pump Gp Oil	838.41	838.41
1	0R9449CC	Pump Gp Oil- Core Ch	1,220.99	1,220.99
-1	0R9449WC	Pump Gp Oil- Worn Co	1,220.99	-1,220.99
6	10R1273	Inj Gp Fuel	870.34	5,222.04
6	10R1273CC	Inj Gp Fuel- Core Ch	281.67	1,690.02
-6	10R1273WC	Inj Gp Fuel- Worn Co	281.67	-1,690.02
1	10R2112	Core As Oil	1,264.50	1,264.50
1	10R2112CC	Core As Oil- Core Ch	501.46	501.46

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-1	10R2112WC	Core As Oil- Worn Co	501.46	-501.46
1	10R7302	Actuator Kit	361.69	361.69
1	10R7302CC	Actuator Kit- Core C	117.06	117.06
-1	10R7302WC	Actuator Kit- Worn C	117.06	-117.06
1	10R9923	Kit Eng Over	7,155.57	7,155.57
1	10R9923CC	Kit Eng Over- Core C	2,045.29	2,045.29
-1	10R9923WC	Kit Eng Over- Worn C	2,045.29	-2,045.29
10	1241854	Bolt 12Pt	24.05	240.50
16	1241855	Bolt 12Pt	21.85	349.60
1	20R2647	Head Gp Cyl	5,223.74	5,223.74
1	20R2647CC	Head Gp Cyl- Core Ch	4,497.46	4,497.46
-1	20R2647WC	Head Gp Cyl- Worn Co	4,497.46	-4,497.46
1	20R9064	Kit Camshaft	4,499.63	4,499.63
1	20R9064CC	20R9064- Core Charge	2,311.89	2,311.89
-1	20R9064WC	20R9064- Worn Core	2,311.89	-2,311.89
3	3078322	Shaft As-Rkr	424.93	1,274.79
1	6I4421	Plate Spacer	610.12	610.12

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Miscellaneous

1 Flat Rate Miscellaneous
Environmental Services

Total Segment Parts	27,040.59
Total Segment Labor	11,470.00
Total Segment Miscellaneous	0.00
Segment 99 Total:	38,510.59

Purchase Order 007

Total Invoice Parts	\$30,903.24
Total Invoice Labor	\$14,132.00
Total Invoice Miscellaneous	\$1,605.02

Massachusetts Sales Tax	\$2,805.78
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Thank you for doing business with Milton CAT! We value and appreciate your business. If your experience didn't meet your expectations, please call us at 508-634-5559. You may be contacted for a survey about your experience. Your feedback is important to us.

We are not responsible for damage, breakage, or delay after we have taken transportation company's receipt. Interest, at legal rates will be charged on the amount of this invoice after its maturity. Gaskets and "O" rings are non-returnable. Other items are returnable only by prior authorization and in resalable condition.

Milton CAT is an equal opportunity employer and federal contractor or subcontractor. Consequently, the parties agree that, as applicable, they will abide by the requirements of 41 CFR 60-1.4(a), 41 CFR 60-300.5(a) and 41 CFR 60-741.5(a) and that these laws are incorporated herein by reference. These regulations prohibit discrimination against qualified individuals based on their status as protected veterans or individuals with disabilities, and prohibit discrimination against all individuals based on their race, color, religion, sex, or national origin. These regulations require that covered prime contractors and subcontractors take affirmative action to employ and advance in employment individuals without regard to race, color, religion, sex, national origin, protected veteran status or disability. The parties also agree that, as applicable, they will abide by the requirements of Executive Order 13496 (29 CFR Part 471, Appendix A to Subpart A), relating to the notice of employee rights under federal labor laws.

Pay This Amount	49,446.04
Credit Amount	

Payment Terms: Cash/Credit Card

Do You Want Electronic Billing? Send Request To ElectronicInvoicing@MiltonCAT.com

To ensure proper credit, please detach this portion and return with remittance.

MFC Trucking LLC
4400 NE 77th Ave Ste 275
Vancouver, WA 98662
USA

Please make checks payable to:

Southworth-Milton, Inc.
P.O. Box 3851
Boston, MA 02241-3851



Customer Number: 8033322
Invoice Date: 12/21/2023
Agreement Number: SCINV774125

Amount Due:	49,446.04
Amount Enclosed:	

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Check here for change of address. Please print the change on the back and return with remittance.