



4484 S. Desert Color Parkway
St. George, UT 84790
(435) 688-8000
(888) 691-1600
Fax (435) 688-1394

Remit To:
Kenworth Sales Company
Dept.# 001
PO Box 27088
Salt Lake City, UT 84127-0088

REPAIR INVOICE

Terms: Net10th Prox

Bill To:

Date: 03/07/2022

Open Date: 3/4/2022 10:52:02 AM

W. O. #:

P.O. #:

Acct #:

Page #: 1 of 2

Written By:

Released By:

Department:

Account:

Ordered By:

Phone:

Year: 2017
Mileage: 548043
Eng H:

Make: Kenworth
Model: T680
Unit: 103

Serial #: 1XKYD49X9JJ194994
Eng Serial #: 79975054
DIS: 5/5/2017

Operation: 1

Complaint: REPLACE BRAKES ON ALL 3 AXLES

Note: **Customer is responsible for re-checking the lug torque within 1 week or 200 miles of operation. Fasteners were torqued to manufacturer's specification as part of this repair but need re-checked within this time.**

Correction:

Labor Amount

BEGAN BRAKE OPERATION, REMOVED ALL CHROME ACCESORIES, LIFTED FRONT AXLE OFF OF GROUND, PLACED FRONT AXLE ON JACKSTANDS, REMOVED STEER TIRES, REMOVED BRAKE SHOES, DRIVE SIDE STEER HUB CAP WAS LEAKING, REPLACED GASKET, INSTALLED NEW BRAKE SHOES, REPEATED PROCCES FOR OPPOSING SIDE, INSTALLED STEER TIRES, PERFORMED BRAKE ADJUSTMENT, TIGHTENED DOWN ALL THE WAY AND BACKED OFF 3/4 OF A TURN, MOVED TO DRIVE AXLES, REMOVED ALL CHROME ACCESORIES. WENT TO RIGHT FORWARD DRIVE AND REPLACED SHOES AND DRUM. ADJUSTED BRAKES. WENT TO LEFT FORWARD DRIVE AND REMOVED WHEELS AND BACKED OFF SLACK ADJUSTER.. REPLACED SHOES AND DRUM. REINSTALLED WHEEL AND ADJUSTED BRAKES. REPAIR COMPLETE

1,240.00

Item	Description	Quantity	Price	Credit	Amount
HA4024	HUBCAP-OIL, STEER, 4024, 4.5	1	\$28.05	\$0.00	\$28.05
Operation 1 Total					1,268.05

Operation: 2

Complaint: REPLACE LEFT FRONT DRIVE WHEEL SEAL

Note: **Customer is responsible for re-checking the lug torque within 1 week or 200 miles of operation. Fasteners were torqued to manufacturer's specification as part of this repair but need re-checked within this time.**

Correction:

Labor Amount

REMOVED WHEELS ON FORWARD REAR DRIVER SIDE AXLE, REMOVED BRAKE SHOES, REMOVED HUB, CLEANED THROUGHLY WITH HUB COMPONENTS IN PARTS CLEANER, AFTER CLEANING INSTALLED SEAL WITH SEAL DRIVER, INSTALLED HUB, INSTALLED HUB COMPONENTS, TORQUED AXLE NUT TO SPEC, 450 FT LBS, BACK OFF HALF TURN, INSTALLED AXLE SHAFT GASKET, INSTALLED AXLE SHAFT, INSTALLED TIRES, PEFORMED BRAKE ADJUSTMENT, INSTALLED BRAKES AND TIRE. REPAIR COMPLETE

387.50

Item	Description	Quantity	Price	Credit	Amount
380003AFDM	SEAL-TEFLON	1	\$58.16	\$0.00	\$58.16
03-01568	GASKET-AXLE	1	\$5.30	\$0.00	\$5.30
OIL	75W90 SYN GEAR	2	\$12.00	\$0.00	\$24.00
Operation 2 Total					474.96



STGRO5048868



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Date: 03/07/2022

Open Date: 2/22/2022 10:51:13 AM

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NEED TO FUTHER DIAGNOSE. NEED TO PULL CYLINDER HEAD TO CHECK HEAD AND HEAD GASKET FAILURE. DRAINED THE COOLING SYTEM. PREPARED THE COOLING PACKAGE FOR REMOVAL. RECOVERED AC. REMOVED THE COOLING PACKAGE. REMOVED FAN, BELTS, AND FAN HUB. REMOVED TURBO AND ALL ASSOCIATED PIPING. REMOVED ALTERNATOR AND ALTERNATOR BRACKET. REMOVED FRONT COVER. REMOVED CAMSHAFT GEAR AND IDLER GEAR. REMOVED ALL NECESSARY ITEMS OFF OF THE LEFT SIDE OF THE ENGINE AND THE RIGHT SIDE. PULLED THE VALVE COVER. PULLED ALL ROCKER SHAFT ASSEMBLIES AND INSPECTED THE SHAFTS AND ROLLERS FOR ANY DAMAGE. THEY ALL LOOKED OK. PULLED OUT THE CAMSHAFT AND INSPECTED, ALL OK THERE AS WELL. SUCKED THE EXCESS OIL OUT OF THE CYLINDER HEAD AND REMOVED HEAD BOLTS. REMOVED THE AIR CLEANER BRACKETS OFF THE FIREWALL FOR CLEARANCE. DOUBLE CHECKED ON EVERYTHING BEING REMOVED FOR THE HEAD REMOVAL. REMOVED CYLINDER HEAD. INSPECTED THE HEAD GASKET AND FOUND EXHAUST SIDE OF #5 CYLINDER WAS BLOWN. CLEANED OFF THE ENGINE BLOCK TO GET READY FOR LINER PROTRUSION CHECK. CLEANED UP THE CYLINDER HEAD. CLEANED UP ALL NEEDED PARTS. REMOVED THERMOSTAT HOUSING AND CLEANED UP. INSTALLED NEW THERMOSTAT SEAL AND THERMOSTAT. INSTALLED HOUSING WITH NEW GASKET. LIFTED THE HEAD AND FINISHED CLEANING THE MATING SURFACE. INSTALLED CYLINDER HEAD WITH NEW CYLINDER HEAD GASKET. CLEANED UP ALL HEAD BOLTS. TORQUED ALL HEAD BOLTS TO SPEC. CLEANED UP FRONT GEARS. INSTALLED OIL SEAL PLATES IN FRONT GEAR HOUSING AND INSTALLED AND TIMED FRONT GEAR TRAIN-CAM GEAR AND IDLER GEAR. ALL TIMED AND TORQUED TO SPEC. INSTALLED THE FRONT GEAR COVER WITH NEW SEAL AND FRONT BRACKET. INSTALLED ALL VALVE BRIDGES AS WELL AS INJECTOR AND ENGINE BRAKE HARNESS. INSTALLED BOTH ROCKER SHAFT ASSEMBLIES AND TORQUED TO SPEC. RAN FULL OVERHEAD ADJUSTING BOTH INTAKE AND EXHAUST VALVES AS WELL AS THE ENGINE BRAKES. CLEANED VALVE COVER AND INSTALLED. INSTALLED MOST OF THE ACCESSORIES ON BACK, FRONT AND BOTH SIDES OF THE ENGINE,. INSTALLED COOLING PACKAGE AND HOOKED UP ALL COOLANT HOSES,. EVERYTHING INSTALLED EXCEPT A FEW PIPE, OIL PAN AND AIR CLEANER. INSTALLED AND TORQUED OIL PAN. FILLED WITH OIL. CHANGED OIL FILTER, AND BOTH FUEL FITERS. VACUUMED THE AC SYSTEM AND DID LEAK TEST. PASSED. CHARGED AC. FILLED SYSTEM WITH COOLANT. PRIMED FUEL SYSTEM. STARTED AND RAN THE ENGINE. CHECKED FOR ANY LEAKS. COOLANT LEAK FOUND. GOOD OIL PRESSURE. ZIP TIED UP ALL LOOSE WIRING AND HOSES. INSTALLED FRONT BUMPER.



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Model: T680

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Eng H:

Unit: 103

DIS: 5/5/2017

Item	Description	Quantity	Price	Credit	Amount
5298564CUM	SHIM	6	\$53.14	\$0.00	\$318.84
5693832	KIT,OVERHAUL	1	\$6,950.00	\$0.00	\$6,950.00
FREIGHT IN	RLS FROM CUMMINS SLC	1	\$138.00	\$0.00	\$138.00
3678506CUM	SCREW,HEX FLAN	2	\$22.55	\$0.00	\$45.10
EC3501	COOLANT-TRP EL RED	12	\$11.08	\$0.00	\$132.96
K37-1021	FILTER	1	\$47.48	\$0.00	\$47.48
OIL	15W40	49	\$6.50	\$0.00	\$318.50

Operation 1 Total 10,881.93

Operation: 2 Complaint: LINER PRETRUSION TEST
Note:

Correction: **Labor Amount**
MEASURED EACH CYLINDER LINER AND RECORDED MEASUREMENTS. CYLINDERS 4 310.00
AND 5 ARE OUT OF SPEC WITH MEASUREMENTS AS LOW AS .005
MARKED EACH CYLINDER TO KNOW WHICH MEASUREMENT IS WHICH.

Item	Description	Quantity	Price	Credit	Amount
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Operation 2 Total 310.00

Operation: 3 Complaint: BLOCK CUT
Note:

Correction: **Labor Amount**
STARTED BLOCK CUTTING. FINISHED CUTTING COUNTERBORES. ALL 6 930.00
COUNTERBORES ARE ALL NOW CUT AND READY FOR LINERS.

Item	Description	Quantity	Price	Credit	Amount
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Operation 3 Total 930.00



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Operation: 4
Note: Complaint: INFRAME REBUILD

Correction:

Labor Amount

CLEANED OUT ALL BOLT HOLES MORE IN DEPTH FOR COUNTERBORE CUTTING TOOL. TAPED UP ROD JOURNALS TO ENSURE NO DEBRIS WILL ENTER. BEGAN TO INSTALL NEW CYLINDER LINERS. FINISHED CLEANING UP CRANK. CLEANED UP ORIGINAL RODS AND INSPECTED. ALL OK. PUT TOGETHER #6 PISTON AND ROD ASSEMBLY. INSTALLED #6 ASSEMBLY AND TORQUED ROD CAP TO SPEC. FINISHED PUTTING TOGETHER THE REMAINING 5 PISTON AND ROD ASSEMBLIES. INSTALLED ALL ASSEMBLIES SO NOW ALL 6 ASSEMBLIES ARE IN AND TORQUED. INSTALLED ALL 6 PISTON COOLING NOZZLES. REPLACED ALL CRANKSHAFT MAIN BEARINGS AND TORQUED TO SPEC. INSPECTED AND CLEANED CRANK IN THE PROCESS. CRANK MAIN JOURNALS LOOK GREAT. CLEANED AND INSPECTED OIL PUMP AND INSTALLED. INSTALLED BLOCK STIFFENER PLATE AND OIL SUCTION TUBE WITH NEW O-RING. FINISHED INSTALL ON OTHER OPERATION.

4,960.00

Item	Description	Quantity	Price	Credit	Amount
51813PTX	GASKET MAKER	1	\$13.98	\$0.00	\$13.98
105FBC	GREASE-WHITE	1	\$7.41	\$0.00	\$7.41

Operation 4 Total 4,981.39

Operation: 5
Note: Complaint: COMBUSTION GAS TEST

Correction:

Labor Amount

PERFORMED COMBUSTION GAS TEST. FAILED. FLUID TURNED GREEN QUICKLY

155.00

Item	Description	Quantity	Price	Credit	Amount
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Operation 5 Total 155.00



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Operation: 6
Note: Complaint: PRESSURE TEST EGR COOLER

Correction:	Labor Amount
PRESSURE TESTED THE EGR COOLER. PUT 100 PSI INTO COOLER AND LEAK DOPWN TESTED IT. NO LEAKS DETECTED. EGR COOLER IS GOOD.	116.25

Item	Description	Quantity	Price	Credit	Amount
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Operation 6 Total 116.25

Operation: 8
Note: Complaint: TRIAGE COOLANT LEAK

Correction:	Labor Amount
THERE IS A COOLANT LEAK AT THE BACK OF THE CYLINDER HEAD. INSPECTED AND LOOKED LIKE THE LEAK WAS COMING FROM BEHIND THE HOSE CLAMP INDICATING THAT THE HOSE ITSELF MAY BE TORN BEHIND IT. DRAINED COOLANT. REMOVED EGR PIPING IN FRONT OF THE CLAMP. REMOVED CLAMP AND FOUND HOSE WAS TORN. INSTALLED NEW COOLANT LINE. INSTALLED CLAMPS. INSTALLED THE EGR OUTLET PIPE WITH NEW CLAMP. FILLED COOLING SYSTEM. RAN THE ENGINE AND NO LEAKS. STEAM CLEANED ENGINE. CLEANED UP BAY.	387.50

Item	Description	Quantity	Price	Credit	Amount
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80-075-25	HEATER HOSE - 80 SERIES	2	\$3.65	\$0.00	\$7.30
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3683144CUM	CLAMP-EGR	1	\$55.17	\$0.00	\$55.17
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Operation 8 Total 449.97