



Cummins South Pacific Pty. Ltd.

ABN NO. 42006332949

Wodonga
PO Box 174
Wodonga VIC 3690
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COPY

WORKSHOP TAX INVOICE

INVOICE NUMBER

9796837

INVOICE DATE

07/06/23

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Invoice To

Customer

Engine Model:	SIGNATURE/ISX/QSX	Eng No:	79919700	Equip Make:	KENWORTH
FleetNo:		Reg No:	1GM2ML	Cust Ord NO:	1GM2ML
Date in Service:	15/12/16	KLMS:	1150187	HRS:	17113
Repair Date:	18/05/23	Chassis NO:	457011	Currency:	AUD
C.O.No.	6660496	Work ordNo.	2819962	Facility	325

Complaint:

Capped Price Rebuild

Complaint: Pressurising cooling system

Cause:

Number 1 counterbore fretted and broken shim, cause liner to drop to .006" (spec .007")

Correction:

Klms: 1,150,187

Hrs: 17,113

Fuel Burn: 639,144

Correction:

Connect laptop & download ECM image.

Disconnect water pump belt and coolant vent line between engine and header tank.

Start engine and find combustion gasses bubbling from coolant vent line.

Suspect head gasket blown allowing combustion gasses to enter cooling system.

Drain cooling system.

Test coolant EG 15% , Found diluted with water.

Drain engine oil.

Found oil contaminated with Coolant.

Remove OEM components as necessary to gain access to engine.

Dis-assemble engine in chassis.

Find #1 to have blown head gasket

Clean cylinder block surfaces.

Measure liner protrusion. See sheet before attached

Find #1 cylinder on below specification At .006 (Spec 0.007)

Remove oil pan & stiffener plate.

Remove piston assemblies.

Remove cylinder liners.

Inspect lower counterbores.

Find #1 lower counterbore to be cracked. See photos attached

Find liners to already have .032 shims

Advised by supervisor to replace block

Remove OEM components as necessary to remove engine

Remove engine and place on stand to remove all components



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Description	Operation	Unit price	Qty	Extension
	Place new block on roll over stand Install crank into new block with new main bearings Fit front and rear housing to block Fit new front and rear mains seals Fit conrods with new pistons, piston pins, circlips and bearings Install Piston and conrod assembly Clean and inspect cylinder head, all ok Fit head Find 1 head bolt to have pitting, replace Inspect injectors, all ok Inspect turbo ok. Cut open oil filter, no contamination. Inspect oil pump. Find oil pump to have pitting on hard facing of the gears, replace Find Fuel actuator to be rusted, replace Find 1 engine brake slave to have pitting, replace Find engine brake top hat to have pitting replace Find exhaust manifold centre to be cracked, replace Find 3 stiffener plate bolts to be rounded, replace Find A/C idler to have noisy bearing, replace Find fan belt to be crack, replace Find heater taps to be leaking, replace Find vent line to be stiff, replace Find air filters to be blocked, replace Find Front and rear engine mounts to be split, replace Find top and bottom rad hoses to be perished, replace Find thermostat to be scored, replace with new seal Re-assemble engine to specifications as per QSOL. Replace coolant due to contamination. Replace engine oil and oil filter. Steam clean engine. Run in engine, all ok. Return vehicle to service.			

Description	Operation	Unit price	Qty	Extension
Labour	3		55.00	

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Description	Operation	Unit price	Qty	Extension
Material				
3823258	PAD CLEANING SCOTCHBRITE		4	
3391271	LUBRIPLATE 105 GREASE 100		1	
3163075	PAINT "300 APEX RED" 12.		4	
CSP05407	CONTACT CLEANER-FLAMMABLE		1	
8681	SYNPOWER WP SPRAY		1	
5693737	KIT, OVERHAUL		1	
5633631	KIT, MAIN BEARING		1	
5680039RX	RECON LUBE PUMP ISX		1	
1324.01	PREMIUM BLUE 8600 OIL (W/		55	
3688113	PLUG, GEAR COVER		1	
3678506	SCREW HEXAGON FLANGE HEAD		1	
89120	IDLER AC		1	
PGXLHD-20L	PGXL HD PREMIUM COOLANT,		3	
2882738	PISTON ENGINE BRAKE SLAVE		1	
275707	AIR GOVERNOR VALVE D-2		1	
WF2127	ESI WATER FILTER BLANK		1	
3680781	SCREW HEXAGON FLANGE HEAD		3	
4988280	GASKET HYDRAULIC PUMP		1	
4374074	SCREW, TWELVE POINT CAP		3	
3902116	SCREW HEXAGON FLANGE HEAD		1	
3103601	SPACER MOUNTING		1	
12PK2380	BELT V RIBBED DAYCO POLY		1	
V404P-10-6	VALVE		2	
4907448	GASKET EXHAUST MANIFOLD		1	
4907447	GASKET EXHAUST MANIFOLD		4	
3680199U	EXH MANIFOLD (CENTRE SECT		1	
3413137	GUIDE VALVE CROSSHEAD		1	
R5HT05K1200	BLEED HOSE		1	
3104119	GASKET COVER PLATE		1	
DCT110H1RW	TIE-CABLE BRAKE HOSE 19.2		15	
AF351KM	AIRFILT ONENGINE RGD OUTE		2	
FS19764	PLUS SIZE ELEMEX		1	
2866337	GASKET AFM DEVICE		2	
2881766	SET LOWER ENGINE GASKET		1	
Miscellaneous				
	CAPPED REBUILD DISC		1.00	
	Environmental Levy		1.00	



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Overtime 6.30

SUB-TOTAL 32838.03
G.S.T 3283.80
INVOICE TOTAL 36121.83