



INVOICE 92314280 *T42-1 MAY*

REMIT TO: STRONGCO LIMITED PARTNERSHIP  
1640 ENTERPRISE ROAD  
MISSISSAUGA ONTARIO L4W 4L4  
TEL: (905) 670-5100 FAX (905) 670-7869

Invoice Date	Terms
April 05, 2023	Net 30

PAYER: 144287

SHIP TO: P1087

KOWAL CONSTRUCTION ALTA. LTD.  
BOX 788  
CROSSFIELD AB T0M 0S0

Strongco Red Deer  
6 Burnt Lake Crescent  
Red Deer AB T4S 2L4

*K7208RT*

Customer PO: 72010

Originating Plant: Red Deer ( 403 346-3473 )

Strongco Ref #: 8000341371

Ship Via:

Delivery #:

Strongco Equip #: 2030770

Make: VOLVO

Model: A25D

Mfg.Serial Number: A25DV72010

Cust Unit #:

Hour Meter: 13870

Part Number	Description	QTY B/O	QTY Shipped	Price/Unit	Amount
JOB 8000341371 SERVICE WORK:					
CALLED IN BY: Carter Kowal					
Install brake line and bleed					
Labour Discounted 10% on SO					
Care inspection parts rebate 10% on account					
Hooked up the laptop to the machine - Read diagnostic codes (no active codes) - Found alarm on dash for the brake circuit - Read the brake pressures and found the output brake pressure sensor for the load unit is reading full pressure with the key on (sensor fault) - Raised the engine hood - Performed a valve set (all valves out of spec / injector preloads not set) - Re-assembled the engine - Programed the injector trim codes as they were incorrect - Started the engine and let warm up - Replaced the broken brake line on the mid axle, right rear caliper - Attempted to bleed the brakes (no fluid coming from the brake master cylinder) - Removed the air line to the brake pot and applied the brake - Good supply of air to the brake pot - Removed the hydraulic line from the master cylinder - Applied the brake (no oil coming from the cylinder) - Will have to replace the cylinder - Removed the floor panels					

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Table with 6 columns: Part Number, Description, QTY B/O, QTY Shipped, Price/Unit, Amount. Description text: as an air leak was heard - Found the left hand brake pot was leaking air and oil (must be replaced) - Informed the customer - Travelled home - Updated job documentation. Unit was brought to red deer shop to have additional work done as excessive play was noted at hitch assembly, Set up machine to remove center hitch pins and bearings. Remove hitch pins. Remove steering cylinders from hitch. Try to cage park break but bolt is seized in holder. Hooked up air to release park brake. Started to split machine with assistance from tech. Remove bearing caps. Had to grind bolts off of lower cap as they were worn off. Start removing bearings. Remove hitch bearings. Clean grease off of hitch. Remove 7 of 8 broken bearing cap bolts. Hitch will need machining. Prepped to remove hitch assembly. Cage park brake. Remove muffler for access to line bore. Clean up and make parts list for hitch and countershaft. Install box safety stand. Remove park brake assembly. Remove driveshaft and center shaft yokes remove brake disc. Center shaft and hitch bearing retainer bolts were seized in place and very hard to remove but after a bit of help parts were removed. Started to remove the center hitch from the trailer which was very stuck but managed to remove. - Remove hitch from rear of machine. Cleaned up the rear hitch assembly as it had grease all over it, Removed intermediate shaft assembly from hitch to have repairs done, Disassembled the intermediate shaft assembly from the rear hitch assembly. Inspected the old parts and the housing, put the hitch assembly onto a pallet and moved it into the wash bay, washed the hitch assembly as it was very dirty, moved it back into the work bay and inspected further. - Gathered the parts from warehouse, Prepped for shipping to a machinist. - Load hitch assembly for transport to Machine shop and explain what all needs to be done. Received hitch assembly back from machine shop - Rigged up to the hitch assembly and lifted it to the work bay, cleaned up hitch assembly. - Finished disassembling hitch - Removed the worn out bearing races and started to prep the assembly for installs. - Removed the worn out bearing races from the trailer end of where the hitch is positioned on the trailer. Updated Job documentation.

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Main table with columns: Part Number, Description, QTY B/O, QTY Shipped, Price/Unit, Amount. Description contains a long paragraph of work notes.

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	<p>setting the bearing at its end position with the bearing cover bolts, while rotating the hitch and moving the hitch up and down, with the crane. Continued with this process until proper preload and torque was achieved then installed the lock nuts. Re-positioned the intermediate shaft bearing cover and adjusted the crush on the bearings. Installed a grease zerk into the backup spacer ring and greased the hitch bearings and housing cavity. Supported the driveshaft to roll the rear frame forward. Worked at rolling the rear frame towards the front frame. Aligned the pin bore for the right steering cylinder and inserted the pin. Ordered the O-rings for the caps. Worked on getting the steering wheel to move, while moving the steering cylinders. Got the steering cylinder retracted. Prepped the bearing in the hitch for pinning. Installed the seals and covers. Worked at rolling the trailer forward and to the left. Aligned the pin bores. Worked at installing the articulation pins. Pulled in the pins. Removed the trailer jack assemble from under the front of the trailer frame. Installed the rubber bushing into the A-stay arm on the front frame. Installed and torqued the bolts for the pins. Worked at connecting the steering cylinders to the hitch steering bearing mounts. Articulate the machine to install the short driveshaft between the hitch and the front frame. Got assistance lining up the trailer to the truck, pressed in new pin's in the center bearing's, installed the steering cylinder's to the rear hitch assembly. Worked at getting the short driveshaft inserted between hitch and the front frame. Got a few bolts started and snugged up. Articulated the machine to start the remaining bolts. Worked at torquing the bolts up. Worked at aligning the short driveshaft u-joints to center it. Worked at installing the flange/rotor for the parking brake. Used a longer bolt and the soft dead blow hammer to start the flange. Pulled the flange on and torqued it up. Mounted the driveshaft to the flange/rotor. Installed the parking brake assembly and connect the air line. Installed the park brake cover. Installed the muffler and rear cab guard. Installed the exhaust stack. Removed the slings from the front axle. Removed the steering cylinder pin caps and replaced the O-rings. Re-installed the caps and tightened down the bolts. Wrap the hydraulic, air lines and electrical harnesses for the rear trailer. Put them into the support</p>				

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Main invoice table with columns: Part Number, Description, QTY B/O, QTY Shipped, Price/Unit, Amount. Description text: clamp and chain. Paint the front and rear frames at the articulation pins. Worked at greasing the articulation pins, short driveshaft u-joints ad the steering pins. Worked at changing the second trailer master cylinder. Worked at cleaning the top bleeder screws on all the brake calipers. Gravity bleed the rear drive axle and the front calipers of the front drive axle. Inspected the hoses and lines. Backed off the brake booster, then changed the booster as the push rod was engaging the master cylinder plunger. Bled the rear calipers on the front drive axle. Used air on the boosters to bleed out the drive axles. Worked on the tractor axle, found the line for the front left caliper broken. Worked at removing the broken line. Found the Tee fitting plugged. Removed the flex brake hose off the Tee and it was plugged as well. Tried to push out the dirt, but the brake pressure was not enough. Worked at trying to get the other end of the flex hose off to check the line from the master cylinder. No issues found at master cylinder. Gravity bled the back calipers on the tractor axle. Worked at removing the left front brake pipe and the brake Tee. Cleaned out the Tee, but it is very corroded inside. Worked at reviewing the info for the brake warning in the display. Checked out the brake booster stroke indicators and reset them. Checked the out the switches on the brake boosters, found the front right brake booster under the cab closed. Removed the switch and removed the switch from the back of the machine. Installed the rear switch into the front right brake booster. Cleaned up the plunger on the other switch with lube and sand paper. Installed it at the rear brake booster. Retested the brake booster switches - okay. Made up a parts list to quote out. Worked at installing the Tee bulkhead fitting into the bracket. Connect the right front brake pipe to the tee bulkhead fitting. Worked at replacing the O-ring on the top straight bulkhead fitting for the flex hose. Connected the flex hose to the top bulkhead fitting. Worked at connecting the flex hose to the Tee bulkhead fitting. Installed the brake pipe. Had to twist and turn it to install the pipe around the axle and the shocks. Gravity bleed the calipers. Had Steve help with bleeding the brakes. Noted reservoir to be emptying fast and upon further inspection found the pipe from the master cylinder broke completely. Quoted parts and ordered a new master cylinder pipe. Worked

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Table with 6 columns: Part Number, Description, QTY B/O, QTY Shipped, Price/Unit, Amount. Description text: at accessing the master cylinder brake pipe. Lifted the hood up. Removed the inner fender cover. Removed the washer fluid reservoir. Removed the floor mats. Removed the bolts for the middle cab floor access cover. Lifted the seat up and slid the cover and seat forward. Worked at loosening the brake pipe from the master cylinder. Lifted the machine up on the left side and supported the drive unit frame. Removed the bolts for the hand rail on the front fender. Gained access between the tire and the fender. Worked at removing the bolts for the tube clamps. Had to modify tooling to reach and hold the nut for the rear tube clamp. Loosened and removed the brake pipe from the flex hose bulkhead fitting. Worked at removing the brake pipe from the machine and installed the new brake pipe. Installed new tube clamps. Bleed out the calipers. Installed and tightened the backing plate access covers. Worked at mounting the washer fluid reservoir. Connect the hose and the electrical. Installed the rear axle brake access covers, the other covers were missing. Worked at installing the bent front brake access cover. Had to twist the cover and plate to start the bolts. Installed the two rear floor mats. Reached down under the cab floor to connect the air lines for the brake boosters. Closed the hood. Put a booster on the batteries to start the machine. Lifted the box up and removed the box support bracket. Lowered the box down. Test the brakes before backing out of the shop with no issues noted. Test drive the machine around the yard and noted some smoke entering the cab. Drove the machine back into the shop bay and inspected where the smoke was coming up into the cab from. Suspect the brake fluid was burning off on the right side exhaust pipe as no smoke was noted upon inspection in shop. Put the battery charge on the batteries. Removed battery charger and moved the machine into the wash bay. Wash off the residue brake fluid on the exhaust pipe and metal filings from the machining on the hitch. Test drive the machine around the yard once more and still noted a bit of smoke so inspected the machine and found an oil residue from the left rear harness passage on the head. Also looks like the valve cover is seeping on the back along the right side. Has the wrong bolts at the back of the valve cover. Think the machine is also vaporizing the oil through the oil separator. The smoke wouldn't

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	happen with the machine at a faster idle, only driving. Worked at returning the unused parts. Finalized job documentation. Unit is good to go. Complete.				
RR-BF-1	DOT 3 BRAKE FLUID 1L		6 EA	17.85	107.10
	Above part includes an environmental fee of \$0.60				
VOE11060536	BEARING		1 EA	2,604.24	2,604.24
VOE11060537	WASHER		1 EA	117.11	117.11
VOE11060548	BEARING		2 EA	534.29	1,068.58
VOE11060840	SPACER RING		1 EA	168.83	168.83
VOE11060905	PIN		1 EA	847.68	847.68
VOE11060940	WASHER		2 EA	147.23	294.45
VOE11063640	MASTER CYLINDER		2 EA	1,460.03	2,920.05
VOE11064598	O-RING		2 EA	10.33	20.66
VOE11064602	O-RING		4 EA	112.79	451.16
VOE11113069	O-RING		1 EA	29.00	29.00
VOE11113070	O-RING		1 EA	29.92	29.92
VOE11119541	BRAKE HOSE		1 EA	122.48	122.48
VOE11190274	BRAKE PIPE		1 EA	197.98	197.98
VOE11190534	BACK-UP RING		1 EA	1,846.54	1,846.54
VOE11190761	RADIAL SEAL		1 EA	60.26	60.26
VOE11190762	RADIAL SEAL		1 EA	149.06	149.06
VOE11190832	PIN		1 EA	500.38	500.38
VOE11191245	DIAPHRAGM CYLINDER		2 EA	458.36	916.71
VOE11191916	BRAKE PIPE		1 EA	322.97	322.97
VOE11192843	BACK-UP RING		1 EA	1,003.29	1,003.29
VOE11193682	BEARING COVER		1 EA	539.32	539.32
VOE11193687	BEARING		1 EA	407.46	407.46
VOE11194360	SPACER RING		1 EA	206.26	206.26
VOE11194361	SPACER RING		1 EA	168.78	168.78
VOE11194516	SEALING		1 EA	64.14	64.14
VOE11194540	SEALING		1 EA	53.09	53.09
VOE11195444	BEARING COVER		1 EA	2,286.49	2,286.49
VOE11195452	SET SCREW		10 EA	12.40	123.95

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VOE11195539	SCRAPER		2 EA	86.72	173.44
VOE11195820	BEARING COVER		1 EA	319.55	319.55
VOE11195821	BEARING COVER		1 EA	325.37	325.37
VOE11195849	BEARING		2 EA	278.65	557.29
VOE11196275	O-RING		2 EA	3.78	7.56
VOE11198405	SPACER RING		2 EA	65.38	130.76
VOE11701338	SPIDER		2 EA	1,223.26	2,446.51
VOE16807282	STUD		1 EA	44.97	44.97
VOE16810574	RUBBER ELEMENT		1 EA	1,133.35	1,133.35
VOE16953530	SCRAPER RING		2 EA	45.81	91.62
VOE17221580	ROLLER BEARING		1 EA	2,395.13	2,395.13
VOE17462668	BEARING		1 EA	310.46	310.46
VOE23469624	U-JOINT KIT		1 EA	624.95	624.95
VOE60111981	WASHER		10 EA	2.96	29.60
VOE60112977	HEX. SOCKET SCREW		16 EA	3.92	62.67
VOE60113171	FLANGE LOCK NUT		10 EA	8.87	88.70
VOE914167	LUBRICATING NIPPLE		2 EA	4.50	8.99
VOE927989	FLANGE NUT		1 EA	14.51	14.51
VOE936004	ELBOW NIPPLE		1 EA	29.90	29.90
VOE936005	T-NIPPLE		1 EA	40.34	40.34
VOE940375	PLUG		2 EA	11.92	23.83
VOE970882	HEXAGON SCREW		10 EA	3.52	35.20
VOE990737	O-RING		2 EA	2.92	5.83
SUBLET	CAGE BOLT (BRAKE POD)				15.72
	Parts				26,544.19
	Labour				28,128.37
	Travel Labour				309.75
	Mileage		222 KM		444.00
	Consumables Fees				1,301.85
	Enviromental fees				200.00

Total Before Tax 56,928.16  
 GST ( 847064128RT0001 ) 2,846.45

Invoice Total (CAD) 59,774.61

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