



901 West 94th Street
Minneapolis MN 55420-4236



MINNESOTA	952-888-4121	800-352-2812
IOWA	515-957-3800	800-342-7002
MISSOURI	515-957-3800	800-342-7002
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Page: 1

Invoice Number: SW500159037

Date: 6/12/14

Account No.: 0126380

Ship To:

Sold To:

Invoice Information

WO Number: WA28893
 WO Date: 4/14/14
 Store: DES MOINES
 Payment Terms: CHARGE
 P/O Number:
 Ship Via:
 Invoice Type: 1F1F1F

Make: CATERPILLAR
 Model: D8RII
 Serial: 06YZ01024
 PIN:
 Id No:
 Cust Unit:
 Meter: 10221.0

Invoice Summary

Parts: 35,756.48
 Labor: 23,121.42
 Misc: 942.50
 Taxes: 1,601.81
 Invoice Total: 61,422.21

Amount Due: \$61,422.21

DUE BY 10TH OF THE NEXT MONTH
 A service charge of 1 1/2 % per month will be assessed on all past due accounts.

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



Account Number: 0126380
 Invoice Number: SW500159037
 Invoice Date: 6/12/14

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Please remit to:
 ZIEGLER INC.
 SDS 12-0436
 PO BOX 86
 MINNEAPOLIS, MN 55486-0436

Amount Due:

\$61,422.21

Amount Enclosed:



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Quantity	Item	N/R	Description	Unit Price	Extended
COMPLETE PRE-SAFETY CHECK PERFORMED PRE-SAFETY INSPECTION. MACHINE LOCATION - WARREN CO. IOWA					
SEGMENT AA TOTAL					.00 T

TROUBLESHOOT TRANS & DIFFERENTIAL UNIT CUSTOMER CONCERN: MACHINE LOCATION - MAHASKA CO. IOWA. BRAKES ARE COMING ON WHILE TRACKING. REPAIR PROCESS COMMENTS: REMOVED PRIORITY VALVE & SCREEN ON VALVE HAS IRON IN IT. INSTALLED NEW VALVE, PROBLEM STILL PERSISTS. CHECKED BRAKE PRESSURES AND FOUND TO BE OK UNTIL YOU PUT TRANSMISSION IN GEAR. BRAKES WILL APPLY & BRAKE PRESSURE DROPS DRASTICALLY. DURING BRAKE TESTING, THE POWERTRAIN FILTER BY-PASS WENT OFF. REMOVED FILTER AND FOUND ALOT OF DEBRIS. FILTER HAD LESS THAN A HOUR ON IT. TRANSMISSION HAS APPARENTLY FAILED.					
TOTAL LABOR				SEG. 01	412.00 *
SEGMENT 01 TOTAL					412.00 T

REPAIR MACHINE CUSTOMER CONCERN: REMOVED TRANSMISSION, TORQUE, FINALS, DIFF. STEER UNIT, BRAKES, INSTALL OIL COOLER. REPAIR PROCESS COMMENTS: REMOVED AND INSTALLED TRANSMISSION, TORQUE CONVERTOR, FINAL DRIVES AND BRAKE ASSY., DIFF STEER UNIT. INSTALLED NEW POWER TRAIN HOSES, FLUSHED MAIN FRAME AND ALL TUBE ASSEMBLIES. RE-SEALED ALL LINES. FLUSHED FLYWHEEL HOUSING. NEW MUFFLER, NEW POWER TRAIN OIL COOLER. NEW FILTERS. CUSTOMER SUPPLIED OILS, ALL CAT BRAND. GOT MACHINE RUNNING, WARMED TO TEMP., CALIBRATED TRANSMISSION PRESSURES AND FILL CALIBRATION. WRAPPED TRACKS AND ADJUSTED, SECURED BELLY PANS. CUSTOMER TEST RAN MACHINE WITH NO PROBLEMS. INSTALLED FAN DRIVE BELTS ON D6H.					
1	0R-5549		CORE GP-OIL	S5 1568.81	1568.81
1			CORE CHARGE	S5 649.96	649.96
1			CORE CREDIT	S5 649.96	649.96-
2	1H-7339		SEAL	S5 3.73	7.46
3	1P-3705		SEAL	S5 2.80	8.40
1	1W-3088		CLAMP	S5 48.54	48.54
1	2H-6184		SEAL	S5 3.86	3.86
1	2W-8951		VEE BELT SET	S5 105.35	105.35
1	3J-1907		SEAL	S5 .85	.85
1	3N-0759		RING	S5 27.55	27.55
1	4C-6796		MINERAL SPIR	S5 85.45	85.45
6	4J-0520		SEAL-O-RING	S5 1.94	11.64
10	4J-0522		SEAL-O-RING	S5 2.16	21.60
4	4J-0524		SEAL-O-RING	S5 2.54	10.16
4	4J-0527		SEAL O RING	S5 2.95	11.80
2	4J-5573		SEAL	S5 2.28	4.56
1	4W-9972		SENDER	S5 26.18	26.18



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Quantity	Item	N/R	Description	Unit Price	Extended
1	5J-2383		SEAL O RING	S5 5.68	5.68
4	5M-2894		WASHER	S5 .29	1.16
6	6F-6673		SEAL	S5 1.88	11.28
2	6J-2680		SEAL O RING	S5 3.48	6.96
1	7M-4710		VEE BELT SET	S5 103.08	103.08
1	123-7843		HOSE AS	N5 119.23	119.23
2	126-1768		SOCKET	S5 1.90	3.80
2	132-8876		TRANS FILTR	S5 46.65	93.30
1	155-2270		PLUG KIT	S5 3.98	3.98
1	159-6132		HOSE AS	N5 130.79	130.79
1	160-1823		SENDER AS-FU	N5 194.40	194.40
1	165-0486		HOSE AS	N5 108.02	108.02
1	198-4607		VALVE GP	S5 171.11	171.11
1	200-3199		MUFFLER AS	S5 816.00	816.00
1	424-4907		KIT GASKET	N5 110.70	110.70
TOTAL PARTS				SEG. 02	3821.70 *
TOTAL LABOR				SEG. 02	4841.00 *
SEGMENT 02 TOTAL					8662.70 T

RECONDITION BEFORE FAILURE TRANS & DIFFERENTIAL UNIT
 INSPECT TRANSMISSION FOR BRASS DEBRIS.

CAUSE OF FAILURE:
 ROTATING SEALING RINGS WAS WORN VERY THIN. THE
 BRASS BUSHINGS IN THE OUTPUT SHAFT HAD DE BONDED
 AND SHRUNK FROM HEAT.

RESULTANT DAMAGE:
 ROTATING CLUTCH WAS BURNT. INPUT SHAFT WAS SCORED
 FROM THE OUTPUT SHAFT BEARINGS. ALL PLANETARY
 GEARS AND SUN GEARS WERE DAMAGED FROM DEBRIS.

REPAIR PROCESS COMMENTS:
 DISASSEMBLED AND INSPECTED THE TRANSMISSION.
 ROTATING CLUTCH WAS BURNT. INPUT SHAFT WAS SCORED
 FROM THE OUTPUT SHAFT BEARINGS. ALL PLANETARY
 GEARS AND SUN GEARS WERE DAMAGED FROM DEBRIS. JOB
 WAS TURNED INTO A RECONDITION BEFORE FAILURE SO I
 REMOVED THE BEARINGS AND CLEANED ALL PARTS.
 ASSEMBLED THE PLANETARY SETS. RESEALED ALL
 PISTONS AND ASSEMBLED THE ROTATING GROUP.
 INSTALLED NEW BEARINGS ONTO DIFFERENTIAL GEARS
 THEN ASSEMBLED THE DIFFERENTIAL. SET THE END
 PLAYS TO .004 AND SET GEAR BACK LASH TO .018.
 RESEALED THE VALVING AND INSTALLED NEW MANUAL
 MODULATING SOLENOIDS. INSTALLED THE VALVING ONTO
 THE ROTATING GROUP. INSTALLED SPEED SENSORS AND
 WIRE HARNESS. SET THE DIFFERENTIAL ONTO THE
 ROTATING GROUP AND TORQUED CASE BOLTS TO 100 FOOT
 POUNDS. FLIPPED TRANSMISSION UP AND INSTALLED
 COVERS AND SCREEN. INSTALLED TEST FITTINGS. THEN
 HOOKED TRANSMISSION UP TO THE TEST BENCH. ALL
 FLOWS AND PRESSURES WERE WITHIN SPECIFICATION.
 STAMPED TRANSMISSION WITH WORK ORDER NUMBER.
 WRAPPED THE TRANSMISSION. SENT A SIX PACK OF SOS
 OIL SAMPLE BOTTLES WITH TRANSMISSION. CLEANED UP
 ASSEMBLY BAY.

DPT

 2 YEAR/2000 HOUR WARRANTY. CUSTOMER MUST PERFORM
 SCHEDULED MAINTENANCE AND SOS. 1 HOUR AFTER
 INSTALLATION AND EVERY 250 HOURS THEREAFTER IN
 ORDER TO VALIDATE WARRANTY. FAILURE TO DO SO MAY
 VOID WARRANTY.



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Quantity	Item	N/R	Description	Unit Price	Extended

1	0S-1569		CAP SCREW	S5	
2	0S-1594		CAP SCREW	S5	
5	3S-2093		TIE	S5	
23	5D-0353		BOLT	S5	
1	5G-8836		RING	S5	
1	6I-8500		PLATE	S5	
7	6V-0852		CAP	S5	
3	7G-2343		SPRING	S5	
3	8P-1964		PLATE	S5	
1	8S-9130		SCREEN	S5	
4	8T-2501		BOLT	S5	
10	9P-7390		DISC A	S5	
1	030-8538		BOLT	S5	
3	031-0218		BOLT	S5	
1	131-4091		SEAL-RING	S5	
1	191-9323		BEARING KIT	S5	
1	262-4333		KIT - DT GAS	N5	
5	328-4374		DISC-FRICTIO	S5	
4	328-4375		DISC-FRICTIO	S5	
1	SOS006		SOS 6 PACK	S5	
			F/R ALL		11537.64 *
			SEGMENT 30 TOTAL		11537.64 T

 EXTRA PARTS/LABOR/MIS FOR TRANS & DIFFERENTIAL UNIT
 MACHINE DRIVE SHAFT YOKE.
 CAUSE OF FAILURE:
 FOUND AT OVERHAUL.
 RESULTANT DAMAGE:
 SEAL RIDE DIAMETER ON DRIVE SHAFT YOKE GROOVED.
 REPAIR PROCESS COMMENTS:
 SET UP TRANSMISSION YOKE IN LATHE AND DIAL IN.
 POLISH GROOVED SEAL RIDE DIAMETER SMOOTH. BUFF
 MOUNTING SURFACE. CLEAN AND MARK PART.
 DPT

4	3K-2511		PIN	S5	25.15	100.60
1	5P-8194		RINGORETAIN	S5	54.35	54.35
10	6I-9788		GEAR PLANET	N5	118.46	1184.60
1	6V-9875		CONNECTOR	S5	14.81	14.81
1	6Y-4846		CARRIER	N5	1341.94	1341.94
4	7T-6578		GEAR	N5	118.05	472.20
1	7T-9369		GEAR-SUN	N5	208.42	208.42
4	8P-1916		GEAR	S5	91.47	365.88
1	9P-8626		GEAR	S5	175.54	175.54
1	061-6711		RING	S5	5.30	5.30
1	144-7878		MANIFOLD	N5	933.80	933.80
1	231-8855		SHAFT AS-INP	N5	1810.72	1810.72
5	244-3114		VALVE GP-MDL	S5	191.18	955.90
4	283-5209		GEAR-CLA	N5	37.46	149.84
4	283-5209		GEAR-CLA	N5	37.46	149.84
1	346-2033		PLATE	N5	257.08	257.08
			TOTAL PARTS	SEG. 31		7881.14 *
			TOTAL LABOR	SEG. 31		120.00 *
			SEGMENT 31 TOTAL			8001.14 T

 REBEARING & RESEAL TORQUE CONVERTER
 RECONDITION THE TORQUE CONV.
 CAUSE OF FAILURE:



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Quantity	Item	N/R	Description	Unit Price	Extended
BEARING FAILED IN THE PLANETARY. RESULTANT DAMAGE: THE PLANETARY WAS WORN FROM THE BEARING MATERIAL GETTING BETWEEN IT AND THE THRUST WASHER. THE PLANETARY GEARS WERE PITTING. THE BEARINGS HAD DENTS FROM THE DEBRIS. THE SEALS WERE HARD AND FLAT. REPAIR PROCESS COMMENTS: DISASSEMBLED THE TORQUE CONV AND INSPECTED. FOUND THAT THE PLANETARY WAS WORN FROM THE BEARING MATERIAL GETTING BETWEEN IT AND THE THRUST WASHER. THE PLANETARY GEARS WERE PITTING. THE BEARINGS HAD DENTS FROM THE DEBRIS. THE SEALS WERE HARD AND FLAT. CLEANED UP THE GOOD PARTS AND ASSEMBLED WITH NEW BEARINGS, SEALS, AND PLANETARY GEARS. TORQUED ALL THE BOLTS TO SPEC. DID NOT HAVE THE RELIEF VALVE TO RESEAL OR TO TEST. DPT					
3	2A-3746		PLUG	S5	
4	3J-1907		SEAL	S5	
2	3K-0360		SEAL	S5	
1	7X-3188		BOLT	S5	
1	8J-4351		SEAL-O-RING	S5	
1	8M-4992		SEAL O RIN	S5	
1	8M-8157		SEAL O RING	S5	
1	260-6492		KIT-DT BEARI	N5	
1	262-4332		KIT - DT GAS	N5	
			F/R ALL		4179.86 *
			SEGMENT 32 TOTAL		4179.86 T

EXTRA PARTS/LABOR/MIS FOR TORQUE CONVERTER REPAIR PROCESS COMMENTS: SET UP TORQUE CONVERTER YOKE IN LATHE AND DIAL IN. POLISH GROOVED SEAL RIDE DIAMETER SMOOTH. BUFF MOUNTING SURFACE. CLEAN AND MARK PART. DPT					
2	1T-1589		RACE	N5	65.30 130.60
2-	1T-1589		RACE	N5	65.30 130.60-
4	2L-3650		PIN	N5	4.40 17.60
4-	2L-3650		PIN	N5	4.40 17.60-
3	3T-4008		GEAR	S5	106.22 318.66
1	9H-0362		BEARING	N5	167.28 167.28
1-	9H-0362		BEARING	N5	167.28 167.28-
1	156-5137		CARRIER-PLAN	N5	1101.13 1101.13
1	169-4740		CARRIER-STAT	N5	722.07 722.07
1	262-4333		KIT - DT GAS	N5	810.67 810.67
1-	262-4333		KIT - DT GAS	N5	810.67 810.67-
1	318-1178		SENSOR GP-SP	S5	122.43 122.43
			TOTAL PARTS	SEG. 33	2264.29 *
			TOTAL LABOR	SEG. 33	155.00 *
			SEGMENT 33 TOTAL		2419.29 T

REBEARING & RESEAL FINAL DRIVE OFF MACHINE CUSTOMER COMPLAINT: REPAIR RIGHT FINAL DRIVE CAUSE OF FAILURE: METAL CONTAMINATION					



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Quantity	Item	N/R	Description	Unit Price	Extended
<p>RESULTANT DAMAGE: BEARINGS DAMAGED REPAIR PROCESS COMMENTS: DISASSEMBLED RIGHT FINAL DRIVE. CLEANED AND INSPECTED PARTS. BEARINGS DIDN'T LOOK VERY GOOD FROM METAL DEBRIS RUNNING THROUGH THEM. QUOTED PARTS AND AFTER CUSTOMER APPROVAL ORDERED NEW BEARINGS AND SEALS. ASSEMBLED FINAL DRIVE, BUILT PLANETARYS AND INSTALLED. MARKED WITH WORK ORDER AND TAGGED.</p>					
DPT					
15	5K-8454		BOLT	S5	
4	6Y-9373		DISC	S5	
3	7T-6994		PLATE	S5	
1	9W-3232		RETAINER	S5	
16	034-3557		BOLT	S5	
1	134-5500		BRG KIT FD	S5	
					F/R ALL 4446.07 *
SEGMENT 34 TOTAL					4446.07 T

<p>REBEARING & RESEAL FINAL DRIVE OFF MACHINE METAL CONTAMINATION RESULTANT DAMAGE: BEARINGS DAMAGED REPAIR PROCESS COMMENTS: DISASSEMBLED LEFT FINAL DRIVE. CLEANED AND INSPECTED PARTS. BEARINGS DIDN'T LOOK VERY GOOD FROM METAL DEBRIS RUNNING THROUGH THEM. QUOTED PARTS AND AFTER CUSTOMER APPROVAL ORDERED NEW BEARINGS AND SEALS. ASSEMBLED FINAL DRIVE, BUILT PLANETARYS AND INSTALLED. MAGNETIC PLUG WAS LOOSE AND NEW ONE HAD TO BE ORDERED. MARKED WITH WORK ORDER. AND TAGGED.</p>					
DPT					
15	5K-8454		BOLT	S5	
1	6V-3298		PLUG	S5	
4	6Y-9373		DISC	S5	
3	7T-6994		PLATE	S5	
1	9W-3232		RETAINER	S5	
16	034-3557		BOLT	S5	
1	134-5500		BRG KIT FD	S5	
1	269-4739		SEAL-LIP TYP	S5	
					F/R ALL 4446.07 *
SEGMENT 36 TOTAL					4446.07 T

<p>REPAIR GEAR PUMP INSPECT TRANSMISSION PUMP. CAUSE OF FAILURE: DEBRIS IN THE SYSTEM. RESULTANT DAMAGE: DEBRIS SCORED ALL THE HOUSINGS EXCEPT FOR TWO. ALL GEARS WERE DENTED OR SCORED FROM DEBRIS EXCEPT FOR TWO. REPAIR PROCESS COMMENTS: INSPECTED PARTS AND FOUND IT WAS MORE COST EFFECTIVE TO BUY A NEW PUMP VERSUS REPAIRING THE OLD PUMP. NEW PUMP WAS ONLY OPTION NO REMAN PUMP'S AVAILABLE.</p>					



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Quantity	Item	N/R	Description	Unit Price	Extended
			DPT		
1	118-7226		SENSOR GP	143.79	143.79
1	160-1835		PUMP GP-GR 3	3712.14	3712.14
			TOTAL PARTS	SEG. 38	3855.93 *
			TOTAL LABOR	SEG. 38	118.00 *
			SEGMENT 38 TOTAL		3973.93 T

REBEARING & RESEAL DIFFERENTIAL DRIVE & BRAK
REPAIR BRAKES
REPAIR PROCESS COMMENTS:
DISASSEMBLED THE LEFT SIDE DIFFERENTIAL DRIVE AND BRAKE. CLEANED, INSPECTED, AND QUOTED PARTS.
ASSEMBLED THE LEFT SIDE SERVICE BRAKE WITH NEW SPRING DISC 6Y-2704 AND SEALS. INSTALLED NEW FRICTION DISCS 6Y-9373 AND PLATES 7T-6994.
ASSEMBLED THE PLANETARY CARRIERS WITH NEW BEARINGS, THRUST WASHERS, AND ROLL PINS. ONE PLANETARY CARRIER WAS ASSEMBLED WITH NEW GEARS 6Y-0926, SHAFTS 3T-4568, BEARINGS AND THRUST WASHERS DUE TO PITTING. ASSEMBLED THE DIFFERENTIAL DRIVE WITH A NEW RING GEAR 6Y-0984 FROM PITTING. ASSEMBLED WITH ALL NEW BEARINGS, SEALS, AND TORQUED ALL BOLTS TO SPEC. CHECKED THE DIFF GEAR DRIVE BACK LASH IS SET AT 0.010 SPEC IS 0.008 +OR- 0.003. INSTALLED THE BRAKE ASSEMBLY ON THE FINAL DRIVE AND CHECKED TOUCH UP PRESSURE. PRESSURE IS AT 260 PSI, SPEC IS 260 PSI.

Quantity	Item	N/R	Description	Unit Price	Extended
			DPT		
1	2K-5069		CUP	S5	
1	2K-9295		CONE	S5	
1	2R-0098		SEAL O RING	S5	
1	3B-4124		CUP	S5	
2	3K-0360		SEAL	S5	
7	3S-2708		PIN	S5	
1	3T-6963		SEAL	S5	
3	5K-9107		BOLT	S5	
3	5M-0578		BEARING A	S5	
4	5M-7925		BEARING A	S5	
1	6D-9953		PIN	S5	
2	6F-6673		SEAL	S5	
1	6P-1735		LOCKWASHER	S5	
1	6P-1736		WASHER	S5	
1	6P-5317		RING	S5	
2	6T-0850		WASHER	S5	
1	6Y-4003		RING	S5	
2	7H-4566		CUP	S5	
1	8D-4771		SEAL	S5	
6	8E-8307		DISC	S5	
8	8E-8310		DISC-THRUST	S5	
1	8M-4438		SEAL O RING	S5	
1	8T-0072		CONE	S5	
2	005-4834		CONE	S5	
4	030-2135		BOLT	S5	

F/R ALL 3223.36 *

SEGMENT 40 TOTAL 3223.36 T

ORDER PARTS DIFFERENTIAL DRIVE & BRAK

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Quantity	Part	N/R	Description	Unit Price	Extended
<p>CUSTOMER COMPLAINT: MACHINE BRAKE CARRIER. CAUSE OF FAILURE: FOUND AT OVERHAUL. DERBIES UNDER THRUST WASHERS. RESULTANT DAMAGE: THRUST FACES FOR PLANETARY GEARS IN CARRIER ROUGH AND STEPPED. REPAIR PROCESS COMMENTS: SET UP CARRIER 3T-5021 ON MILL AND DIAL IN. MACHINE ONE SIDE OF ALL FOUR PLANETARY GEAR THRUST FACES FLAT AND SMOOTH. MACHINED FACES TO ACCEPT ONE ADDITIONAL THRUST WASHER. DE BURR ALL EDGES. CLEAN AND MARK CARRIER. DPT</p>					
3	3T-4568		SHAFT	S5 73.08	219.24
4	6T-0064		SHAFT	S5 78.23	312.92
3	6Y-0926		GEAR	S5 116.61	349.83
1	6Y-0984		GEAR	S5 548.93	548.93
1	6Y-2704		SPRING	S5 196.79	196.79
5	8E-8310		DISC-THRUST	S5 7.08	35.40
1	292-2016		GEAR AS. - S	S5 587.30	587.30
TOTAL PARTS				SEG. 41	2250.41 *
TOTAL LABOR				SEG. 41	395.00 *
SEGMENT 41 TOTAL					2645.41 T

<p>REBEARING & RESEAL PLANETARY & BRAKE REPAIR BRAKES REPAIR PROCESS COMMENTS: TESTED TOUCH UP PRESSURE BEFORE DISASSEMBLY. 260PSI. DISASSEMBLED THE RIGHT BRAKE. CLEANED AND INSPECTED PARTS AND ORDERED PARTS. ASSEMBLED THE RIGHT SIDE SERVICE BRAKE WITH A NEW SPRING DISC 6Y-2704 AND SEALS. PREFORMED SERVICE MAGAZINE MEDIA NUMBER SEDP0786. MACHINED THE PLANETARY CARRIER AND INSTALLED NEW SUN GEAR 198-4410 AS PERFORMED FOR SERVICE MAGAZINE. ASSEMBLED THE PLANETARY ASSEMBLY WITH NEW BEARINGS, THRUST DISCS, AND ROLL PINS. FINISHED ASSEMBLY OF THE BRAKE WITH NEW BEARINGS AND NEW FRICTION DISCS 6Y-9373 AND PLATES 7T-6994. TORQUED ALL BOLTS TO SPEC. INSTALLED THE SERVICE BRAKE ON THE FINAL DRIVE AND TESTED THE TOUCH UP PRESSURE. TOUCH UP PRESSURE IS 260 PSI SPEC IS 260 PSI.</p>					
1	2R-0098		SEAL O RING	S5	
2	3K-0360		SEAL	S5	
3	3S-2708		PIN	S5	
6	5M-0578		BEARING A	S5	
1	6D-9953		PIN	S5	
2	6F-6673		SEAL	S5	
1	6P-5317		RING	S5	
1	6Y-4003		RING	S5	
1	8D-4771		SEAL	S5	
6	8E-8307		DISC	S5	
1	8M-4438		SEAL O RING	S5	
2	9W-7925		BEARING	S5	
2	9W-7926		BEARING	S5	
				F/R ALL	2234.08 *
SEGMENT 42 TOTAL					2234.08 T



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Quantity	Item	N/R	Description	Unit Price	Extended

EXTRA PARTS/LABOR/MIS FOR PLANETARY & BRAKE MACHINE BRAKE CARRIER FOR UPDATE. CAUSE OF FAILURE: UPDATED SUN GEAR. RESULTANT DAMAGE: NONE, PRODUCT UPDATE. REPAIR PROCESS COMMENTS: SET UP BRAKE CARRIER IN LATHE AND DIAL IN. MACHINE INSIDE DIAMETER AND FACE OF CARRIER TO ACCEPT IMPROVED SUN GEAR. DE BURR ALL EDGES. BUFF ALL SURFACES. CLEAN AND MARK PART.					
		DPT			
1	6Y-2704		SPRING	S5 196.79	196.79
1	6Y-3986		PISTON	N5 981.14	981.14
1	7T-8136		SHAFT	S5 86.50	86.50
1	306-0278		GEAR AS.-SUN	S5 513.42	513.42
			TOTAL PARTS	SEG. 43	1777.85 *
			TOTAL LABOR	SEG. 43	180.00 *
			SEGMENT 43 TOTAL		1957.85 T

TRAVEL TO/FROM MACHINE					
			TOTAL LABOR	SEG. 99	978.50 *
270.00			TRAVEL MILEAGE		202.50
			TOTAL MISC CHGS	SEG. 99	202.50 *
			SEGMENT 99 TOTAL		1181.00 T

			SERVICE SUPPLIES AND ENVIRONMENTAL CHARGES		500.00 T
			TAX EXEMPTION LICENSE 26-2443210		
			IOWA SALES TAX - 5%		1144.15 T
			IA LO LABOR MAHASKA		228.83 T
			IA SI LABOR MAHASKA		228.83 T
			DUE BY 10TH OF THE NEXT MONTH		
			INVOICE TOTAL		61,422.21