



Arnold's of St. Cloud
 2995 Quail Rd. NE. • Sauk Rapids, MN 56379
 Phone: (320) 251-2585 • Fax: (320) 251-9232
 www.arnoldsinc.com

Ship To: Mark Huselid
 763-438-7605

Invoice To: HD Enterprises Inc
 1007 40th Ave N
 Moorhead MN 56560

Branch		
ST. CLOUD		*REPRINT*
Date	Time	Page
10/26/20	23:32:48 (B)	01
Account No	Phone No	Inv No
HDENT001	7634387605	W01897
Ship Via	Purchase Order	
Tax ID No		
	Salesperson	
	MR1	

SERVICE INVOICE

STK#/FLEET#		HRS	PIN/EIN	WARRANTY DATE	HRS
F004737	tractor	3807	ZBRD02299		
	290 MAGNUM				

SEGMENT# 1 C EF040 NA 09/25/20 09/08/20
 290 trans repair

CORRECTION:

Brought tractor in shop; troubleshot DEF fault - tractor was D-rated; hooked up EST - found fault code for DEF temp sender; found sender bad - replaced sender; cleared all fault codes; unlocked D-rate; test ran tractor - got fault for knock sensor; troubleshot - found sensor was just unplugged - plugged in; test ran - no fault came back; troubleshot unit having no reverse; ran leakage test - found low pressure in reverse about 200 pounds - spec should be about 330; removed left duals; removed DEF tank and fuel tank; removed batteries; unhooked lines on side of the transmission to remove speed valve block and transmission cover; inspected transmission - found reverse clutch packs burnt; removed right duals; removed DPF and right fuel tank; unhooked all electrical and hydraulic lines to remove cab; took cab off tractor; removed chassis harness from transmission; disconnected all hydraulic lines; split range transmission from speed housing; split speed transmission from front frame; disassembled speed transmission; removed and disassembled clutch packs - found creeper clutch pack clutches burnt; found reverse clutch packs burnt also; found piston seal on reverse clutch pinched and torn - looked like was incorrect - installed when it was apart once before; also found fifth range clutch burnt; ordered new parts for speed transmission; rebuilt clutch packs; replaced all sealed clutches, plates and springs; installed new bearings;

CONTINUED ON PAGE 02

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Kimball	Willmar	Glencoe	St. Martin	Mankato	Alden	St. Cloud
320-398-3800	320-235-4898	320-864-5531	320-548-3285	507-387-5515	507-874-3400	320-251-2585



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	290 MAGNUM				

reinstalled in speed housing and shimmed shaft to spec;
 reinstalled speed housing onto engine; reinstalled range
 trans and rear axle on speed housing; installed updated
 jumper tubes; cleaned and installed all valve bodies;
 installed all hydraulic lines; installed electrical chassis
 harness - made repairs on wiring as needed; reinstalled cab
 fuel tanks, def tanks and steps; installed new transmission
 filter; filled with new oil; hooked up all electrical;
 started and tested - tractor at 320 6 lb of pressure in all
 gears; ran tractor and got up to operating temperature;
 calibrated transmission three times; rechecked all fluid
 levels; installed duals; found surge tank was leaking -
 replaced surge tank.

FRT	FREIGHT	1	9.50	9.50
HTBQ	QT/H-T FLUID	147	4.10	602.70
J286499	HOSE	2-	20.00	40.00-
R32551	DEF, 2.5 FLUID	2	11.75	23.50
ST863	CUP BRG.*	1	19.50	19.50
104033C2	SMS #10-16 X 3/	1	3.80	3.80
105497H	CUP BRG	1	13.00	13.00
114979H	BEARING, CUP	2 M	35.00	70.00
128483A1	O-RING <GREEN>	1	2.40	2.40
1285996C1	RING, SNAP	1 M	26.00	26.00
1285997C1	BEARING, NEEDLE	1 N	79.00	79.00
1286016C1	BEARING, NEEDLE	3 N	66.00	198.00
1286024C1	RING	6 M	8.50	51.00
1286026C1	RING	5 S	8.80	44.00
1286042C1	WASHER, THRUST	8 N	11.75	94.00
1286043C1	WASHER, THRUST	15 N	15.00	225.00
1286052C1	RING	7 M	12.00	84.00

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1286064C1	SHIM			1 N 13.00	13.00
1286073C1	SHIM			2 M 11.00	22.00
1286076C1	RING			7 O 8.10	56.70
1286079C1	RING			7 O 11.00	77.00
1286081C1	O-RING			7 O 10.00	70.00
1286083C1	O-RING			7 O 16.00	112.00
130282	O-RING			4 .91	3.64
1342645C3	DISC, CLUTCH			7 S 64.00	448.00
1455023	FW M8			4 .05	.20
1491074	M8-1.25X25M 8.8			2 .20	.40
1492064	M10-1.5X20M 8.8			2 .21	.42
1492164	M10-1.5X70M 8.8			2 .51	1.02
165202	O-RING			1 .94	.94
16587625	FB M10 X 59.2			1 2.40	2.40
166258	CONE BRG			1 30.00	30.00
1997888C1	WASHER, THRUST			1 N 28.75	28.75
2007968	NUT M8-1.25 8.8			2 .11	.22
2007969	NUT M10-1.5 8.8			2 .17	.34
2008252	M20-2.5X130M8.8			1 6.42	6.42
2008277	FW M10			4 .09	.36
2010473	FFW 5/16X 1-1/4			1 .09	.09
205369R91	NEEDLE BRG.			1 O 26.00	26.00
214-1408	HOSE CLAMP			2 2.60	5.20
217408	O-RING			1 4.00	4.00
219530H1	CONE BRG			2 M 75.00	150.00
228273A1	M20 BOLT X110			1 15.00	15.00
242492A5	PISTON			2 N 68.75	137.50
280250	CK 3/32 X 3/4"			1 .13	.13
300827A1	TUBE			1 14.00	14.00
396-31081	WASHER 13/16" I			1 3.30	3.30

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47512698	SENSOR	1		425.00	425.00
47599749	HOSE, DEF W/ENDS	1		91.25	91.25
47747093	TUBE	2 N		15.00	30.00
47747094	TUBE	1 N		16.75	16.75
47749402	TUBE	4 N		42.25	169.00
47776660	HOSE FUEL	1 M		40.50	40.50
47833564	HYD. FILTER	1		60.75	60.75
48107652	RING SNAP	2 M		4.80	9.60
48176060	RING	5 N		32.75	163.75
511356	O-RING	2		2.00	4.00
51437460	GASKET	1		12.50	12.50
51508555	HYD. FILTER	1		98.50	98.50
572182R1	THRUST NEEDLEBR	8 N		11.00	88.00
66805	O-RING	1		2.00	2.00
73341738	A-FREEZE (OAT) 1-	1		13.80	13.80
76088905	WASHER 24MM ID	3		5.40	16.20
80136811	BEARING, ROLLER	1 M		43.00	43.00
80604928	CUP BRG	1 M		34.00	34.00
80906C1	BEARING ASSY	1 N		101.00	101.00
80907C1	BEARING, NEEDLE	3 N		45.00	135.00
81823621	CONE BRG	1		56.00	56.00
84276099	BOTTLE	1 M		48.50	48.50
84356191	TAPERED BEARING	1 M		46.25	46.25
84480600	DEF HOSE W/ENDS	1		91.25	91.25
86625021	HOSE CLAMP	1		2.40	2.40
86987597	PISTON	2 M		54.75	109.50
86990276	DISC, FRICTION	61 O		16.00	976.00
87012543	THRUST NEEDLEBR	4		8.90	35.60
87016255	RING SNAP	6 N		7.00	42.00
87016951	O-RING	1		16.75	16.75

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87399290	GASKET	2		15.25	30.50
87425389	SPRING, BELLEVI	63 S		14.00	882.00
87433655	GASKET	1		52.75	52.75
87439339	HOSE-ORANGE	2		43.25	86.50
87490214	UNION, DEF	1		36.25	36.25
87622084	DISC	55 M		14.50	797.50
87670757	M22 BOLT 10.9	2		9.40	18.80
87738316	DISC	3 M		16.00	48.00
92793C1	RING	1 N		23.50	23.50
93297C1	SPACER	1 N		18.00	18.00
9827059	O-RING* <GREEN>	1		1.45	1.45
9992298	O-RING	9		.75	6.75
				PARTS	7715.28
				LABOR	9000.00
11100007				SEGMENT TOTAL==>	16715.28

***** WORK ORDER TOTALS *****
 PARTS 7715.28
 LABOR 9000.00
 SHOP SUPPLIES 75.00
 SUB TOTAL==> 16790.28
 MN SALES TAX 7.375% 568.37
 ON ACCOUNT 17358.65

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