

\*\*\*\*\*SNGLP  
LONDON FLATS INC  
PO BOX 12

12



Quantity	Description	Units Price	Totals
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NMC GERING SHOP  
TROUBLESHOOT ENGINE COOLING SYSTEM  
**CUSTOMER CONCERN**  
TRUCK CAME WITH EXCESSIVE SMOKE AND PRESSURE IN  
THE COOLING SYSTEM  
**REPAIR COMMENTS**  
TROUBLESHOT AND FOUND THAT THE CYLINDER HEAD  
GASKET WAS BLOWN OUT IN BETWEEN CYLINDERS FOUR AND  
FIVE AND THAT THE COUNTER BORE WAS NEEDED.

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IN FRAME OVERHAUL ENGINE  
PLATINUM O.H.KIT  
**CUSTOMER CONCERN**  
CUSTOMER BROUGHT TRUCK IN WITH THE PROBLEM OF  
PRESSURE IN THE COOLANT.  
**REPAIR COMMENTS**  
TOOK THE VALVE COVERS OFF, TOOK OFF OVERHEAD. TOOK  
OIL PAN OFF ALONG WITH OIL PUMP, OIL PICK-UP TUBE,  
AND THE OIL PLATE. PROCEEDED TO TAKE THE CYLINDER  
HEAD OFF AND DISCOVERED ON THE SPACER PLATE THAT  
BETWEEN CYLINDERS 4 AND 5 THE PLATE WAS WEARING  
SIGNIFICANTLY. TOOK THE CYLINDER PACKS OUT AND  
INSPECTED THE INSIDE BORE CAREFULLY. DISCOVERED  
THAT THERE WAS SCORING AND THAT THE CROSS HATCHING  
WAS NO LONGER IN A COUPLE CYLINDERS. PROCEEDED TO  
CLEAN THE CYLINDER HEAD COMPLETELY TO GET RID OF

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Quantity

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DEBRIS AND DUST. ONCE CYLINDER HEAD WAS CLEANED, PROCEEDED TO START TO COUNTER BORE THE BLOCK DECK .AFTER COUNTER BORE WAS DONE WENT AHEAD AND STARTED REPLACING THE MAIN BEARINGS ON THE CRANKSHAFT. REPLACED THE BEARINGS ON CRANKSHAFT AND TORQUED THE BEARING CAPS TO SPEC. PUT THE CORRECT SHIMS IN PLACE WHERE THE BLOCK WAS COUNTER BORED AND STARTED TO PUT THE NEW CYLINDER PACKS IN TO THE CYLINDERS. PUT NEW BEARINGS ON RODS AND TORQUED THE ROD CAPS TO SPEC. PUT SPACER PLATE GASKET THEN SPACER PLATE, AND THEN THE HEAD GASKET ONTO ENGINE BLOCK ALONG WITH WATER GROMMETS AND STUDS. PLACED NEW CYLINDER HEAD ONTO ENGINE BLOCK. PUT NEW HEAD BOLTS ON THE HEAD AND TORQUED TO SPEC. INSTALLED CAM GEAR AND IDLER GEAR AND MADE SURE BOTH WERE IN TIME. PUT NEW OVER HEAD ON AND TORQUED AND ADJUSTED ACCORDING TO SPEC. REPLACED WATER PUMP, NEW FUEL LINE FROM BACK OF CYLINDER HEAD TO FILTER HOUSING, ALSO REPLACED THE OIL PUMP. INSTALLED BELLY PAN, OIL PICK-UP TUBE AND OIL PAN WITH NEW OIL PAN GASKET. PUT OVERHEAD BACK ON AND TORQUED TO SPEC, AND THEN INSTALLED THE VALVE COVERS.

SEGMENT 02 TOTAL

REPLACE SPACER PLATE

**CUSTOMER CONCERN**

THE SPACER PLATE IS DAMAGED IN BETWEEN CYLINDER FOUR AND FIVE.

**REPAIR COMMENTS**

CLEANED AND INSPECTED THE SPACER PLATE. FOUND DAMAGE AND ORDERED A NEW PLATE.

1 6I-4421

PLATE SPACER S  
00000

TOTAL PARTS SEG. 03

SEGMENT 03 TOTAL

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SHIP TO

LONDON FLATS INC

Quantity	Description	Units Price	Totals
REPLACE BROKEN BOLTS			
<b>CUSTOMER CONCERN</b>			
FOUND THAT WERE BAD HEAD BOLTS			
<b>REPAIR COMMENTS</b>			
CLEANED AND INSPECTED THE HEAD BOLTS FOUND THAT 21			
OF THE BOLTS WERE BAD AND NEEDED TO BE REPLACED.			
ORDERED AND INSTALLED THE NEW BOLTS.			
3	124-1854	BOLT 12PT S	
		00000	
12	124-1855	BOLT 12PT S	
		00000	
6	151-5925	BOLT-OIL JET S	
		00000	
		TOTAL PARTS	SEG. 04
		SEGMENT 04 TOTAL	
-----			
ADD'L CHGS- PARTS			
99	9X-2373	HOSE 1130 -6 IN S	
		00000	
1	9Y-4104	HOSE S	
		00000	
		TOTAL PARTS	SEG. 05
		SEGMENT 05 TOTAL	
-----			
COUNTERBORE CYLINDER BLOCK			
<b>CUSTOMER CONCERN</b>			
THE CYLINDER BLOCK DECK NEEDED TO HAVE THE			
CYLINDER COUNTER BORES CUT.			
<b>REPAIR COMMENTS</b>			
ONCE CYLINDER HEAD WAS CLEANED, PROCEEDED TO START			
TO COUNTER BORE THE CYLINDER BLOCK. COUNTER BORED			
EACH CYLINDER TO SPEC. AND MEASURED.			
1	6I-4363	INSERT SET S	
		00000	
5	9Y-3368	INSERT LR S	
		00000	
		TOTAL PARTS	SEG. 06
			F/R LBR
		SEGMENT 06 TOTAL	

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REMOVE & INSTALL TURBOCHARGER

**CUSTOMER CONCERN**

OVERHAUL

**REPAIR COMMENTS**

SEPERATED TURBO FROM THE EXHAUST MANIFOLD AND  
FOUND THAT THE CENTER SECTION ON THE EXHAUST OF  
THE TURBO WAS CRACKED. REPLACED TURBO AND THE  
CENTER SECTION OF THE EXHAUST MANIFOLD. PUT ONTO  
CYLINDER HEAD.

1	10R-2962	TURBO GP BAS	S	
		00000		
1		CORE DEPOSIT	S	
		00000		
1-		CORE RETURN	S	
		00000		
		TOTAL PARTS		SEG. 01
		SEGMENT 07 TOTAL		

REMOVE & INSTALL EXHAUST MANIFOLD

1	146-9445	MANIFOLD-EXH	S	
		00000		
2	180-3399	PACKING	S	
		00000		
		TOTAL PARTS		SEG. 08
		SEGMENT 08 TOTAL		

WARRANTY

1.00		OPT 3 YEAR		00000
		TOTAL MISC CHGS		SEG. 09
		SEGMENT 09 TOTAL		

WARRANTY

1.00-		NAT-ENG-225REB		00000
		TOTAL MISC CHGS		SEG. 10
		SEGMENT 10 TOTAL		

ADD'L CHGS- PARTS

1.00-		NMC DISCOUNT TRK		00000
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LONDON FLATS INC

Quantity	Description	Units Price	Totals
	TOTAL MISC CHGS	SEG. 11	
	SEGMENT 11 TOTAL		
	NE SALES TAX		
	GERING SALES TAX		
	NET 15 DAYS		

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(USD)

\$19,370.82

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