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Invoice To:

SERVICE INVOICE

STK#/FLEET#		HRS	PIN/EIN	WARRANTY DATE	HRS
E006746	HG4000 HORIZONTAL	1641	1VRC312H6E1000146		
	HG4000				

Tech then function tested machine again and found the infeed chain would still stop every 6-8 feet using only the hydraulic power of machine. After further inspection of the infeed chain; tech found several seized pins and cracked welds in chain plate hinges; decision was made to replace the infeed chain at this time. Tech started removal of infeed chain guards and heads of allan bolts to be worn flat (labor to extract bolts in segment 17); tech extracted all bolts; removed infeed chain guards; used cutting torch to cut existing infeed chain into pieces for removal; removed existing infeed chain; assembled new infeed chain on machine in 4ft sections; re-installed infeed chain guards and attached with new allan head bolts; adjusted chain tension as needed. Function tested; working normally.

Misc Charge for Welding Supplies

ADDITIONAL DESCRIPTION:

1. 3L00 - Frame Labor (3L00V)
2. 3641 - Infeed Chain Assembly R&R CMP (3641V)

Quantity

FRT	FRT NDA	1
163704627	INFEED CHAIN AS	RETAIL
		1 N
180007769	SCREW-SBHCS-.50	RETAIL
		60 N

PARTS
LABOR

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	HG4000				
		12010004		SEGMENT TOTAL==>	23706.50

SEGMENT# 5 C INTER 3371V 03/01/19 04/01/19

3371 - Belt Loadout Conveyor - R&R 8.25 HRS

COMPLAINT:

05 - (MG) Discharge/loadout conveyor belt is extremely worn and damaged

CAUSE:

Discharge conveyor is worn/damaged.

CORRECTION:

Tech removed conveyor belt splice with die grinder; rolled new conveyor belt out and attached to existing belt with chains so that new belt would follow existing belt through machine for ease of installation; once new belt reached bottom rollers the old belt came apart causing tech to have to feed new conveyor belt in machine manually (by hand).

Tech then spliced new belt and adjusted belt tension; tech used existing marks on tension plates and tape measure to adjust belt but after adjustment was complete the conveyor belt would walk to one side. Tech ran both adjusting bolts all the back in; inspected rollers for any damage or excessive wear; re-adjusted conveyor belt as needed.

Function tested; working normally.

1500001 SET COLLAR - 1/ RETAIL
2

163704304 BELT-V CLEAT-71 RETAIL
1 N

189099107 BRAKE CLEANER 2
PARTS
LABOR
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	HG4000				

CAUSE:

Drive motor is leaking.

CORRECTION:

Tech drilled and extracted one mounting bolt for removal of drive motor; removed failed drive motor; removed coupler and mounting bracket; straightened mounting bracket and painted; installed coupler and mounting bracket on new drive motor; installed drive motor on machine as needed.

Function tested; working normally.

ADDITIONAL DESCRIPTION:

1. 4L00 - HYDRAULIC LABOR (4L00V)	2.00
2. 4644 - Loadout Hydraulic Motor R&R CMP (4644V)	2.00
	=====

Quantity

x1

=====

4.00

FRT	FRT GND	1
163704264	MOTOR-HYD-19 CI	RETAIL
		1 N

PARTS

LABOR

SEGMENT TOTAL==> 1881.53

12010004

SEGMENT#14 C INTER MULTIPLE 03/01/19 04/22/19

4635 - Cylinder Deflector Cylinder R&R 3.50 HRS

COMPLAINT:

14 - (MG) TOD lift cylinder is leaking. Replace cylinder as needed.

CAUSE:

Cylinder is leaking.

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	HG4000				

extracted all seized bolts (see seg 17); installed new wear strips, plates, and hardware as needed. Function tested; working normally.

ADDITIONAL DESCRIPTION:

1. 3368 - Wear Strips Plates/ Belly Conveyor	6.00
R&R CMP (3368V)	
2. 3369 - Infeed Wear Strips R&R CMP (3369V)	6.00

=====

Quantity	x1
	=====
	12.00

FRT	1
FRT	1
FRT	1
0600000	2
148577001	RETAIL
	56 N
163683322	RETAIL
	1 N
163683379	RETAIL
	4 N
163683380	RETAIL
	2 N
163722754	RETAIL
	1 N
3/8-16-.75	56

PARTS

LABOR

SEGMENT TOTAL==> 4623.54

12010004

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E006746	HG4000 HORIZONTAL	1641	1VRC312H6E1000146		
	HG4000				
				PARTS	
				LABOR	
				SUBLET	
				ENVIRONMENTAL	
				OUTSIDE LABOR	
				WELDING SUPPLIE	
				INTERNAL TOTAL	43218.07

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STK#/FLEET#	HRS	PIN/EIN	WARRANTY DATE	HRS
E006746	1659	1VRC312H6E1000146		
HG4000				

Tech adjusted mill speed magnetic pickup as needed.

Function tested; working normally.

FRT	1	
163628352	SWITCH-PROX 18	RETAIL
		1 N

PARTS	
LABOR	
SEGMENT TOTAL==>	271.88

***** WORK ORDER TOTALS *****
INTERNAL CUSTOMER
PARTS
LABOR
SUBLET
ENVIRONMENTAL
INTERNAL TOTAL 15810.74

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	HG4000				

the process of removing the hammer a variety of techniques were used to remove including; the use of air hammer, penetrating oil, heating assembly; contacted factory for advise in removal, removed assembly by torching the components out of the drum; cleaned assembly of any nicks for reassembly, and welded up drum; assembled hammer, torqued; tech R & R all teeth for drum; tech straightened anvil, welded; after further diagnoses determined assembly needed to be replaced; tech R & R screen stops; tech R & R screens

ADDITIONAL DESCRIPTION:

1. 0000 - Diagnostic (0000V)	1.00		
2. 6026 - Hammer Assembly (each) R&R CMP (6026V)	2.00		
3. C045 - Hammer (all) R&R (C045V)	4.00		
4. 6L20 - R&R Screen Stops	1.50		
5. 6L20 - R&R Screen	1.00		
6. 6L20 - Additional Labor for 6026v	32.75		
FRT	FRT NDA	1	
SUBLETP	BOLTS AND NUTS	1	
163632345	BARREL NUT-5/8-	RETAIL	
		2 N	
163635589	HAMMER - 3lin D	RETAIL	
		1 N	
163679762	RAIL-SCREEN ADJ	RETAIL	
		1 N	
163694696	SCREEN-4" SQUAR	RETAIL	1
		2 N	
180008936	NUT-SMFLGTL-.88	RETAIL	
		36	
180012780	BLOCK-HAMMER BA	RETAIL	

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180018204	ASSEMBLY - WEDG		RETAIL	2 N	
1809013	NUT-SMFLGTL-.63		RETAIL	2 N	
250513001	NUT - 5/8NC GR8		RETAIL	2	
296300802	SCREW-HFS-.63-1		RETAIL	2 N	
296300803	SCREW HFS .6311		RETAIL	7 N	
296371054	TIP-BLOCK 7/8"		RETAIL	4 N	
5/8 F/W	5/8 FLAT WASHER		RETAIL	18	
5/8-11-2	5/8-11 X 2		RETAIL	7	
507613040	SCREW-HFS, M12-1		RETAIL	7	
510306070	SCREW HCS .63 1		RETAIL	3	
510311130	BOLT CARG .63 1		RETAIL	2 N	
521030	3/4-10X3"SKT.HD		RETAIL	4 N	
606160001	BOLT - 7/8-9X6		RETAIL	2 N	
		36			
			PARTS		
			LABOR		
			SUBLET		
10100001	49350404		SEGMENT TOTAL==>	9032.35	

05/16/19 05/16/19

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