

Sold To:

Ship To:

INVOICE # 07W00087766	08-21-19	CUSTOMER # C55617	07	G	1	2
REFERENCE # 0732506	06-04-19	10 10 10			8366027	
MAKE AA	MODEL D7F	SERIAL NUMBER 061G00216			9999999.0	

SEGMENT 02 TOTAL

248.00 T

REPLACE GASKET/RESEAL EXHAUST MANIFOLD

COMPLAINT: EXHAUST MANIFOLD LEAKS/TURBO TO MUFFLE  
FLANGE SEAL CRACKED.

CAUSE: GASKETS HARD/BRITTLE.

CORRECTION: REMOVE EXHAUST MANIFOLD, STUDS WERE  
REPLACED, PREP MANIFOLD SEALING SURFACE FOR  
REASSEMBLY, INSTALL EXHAUST MANIFOLD APPLY  
ANTI-SEIZE TO STUD AND TORQUE TO SPEC. AFTER HEAD  
WAS INSTALLED ON ENGINE ATTEMPT TO INSTALL THE  
REAR OUTER EXHAUST STUD BUT STUD HOLE WAS NOT  
ALIGNING, HAD TO LOOSEN EXHAUST MANIFOLD TO GET  
STUD STARTED, TORQUE TO SPEC. TORQUE MANIFOLD TO  
SPEC. FOUND SEAL TO BE BAD ON TURBO TO MUFFLER  
ADAPTER, REMOVE SEAL, CLEAN UP ADAPTER, INSTALL  
RING, APPLY HIGH TEMP SEALANT TO SEALS AND  
HOUSINGS, TO ASSIST IN SEALING DUE TO THE SEALING  
SURFACE BEING PITTED.

1	2M-2488	STUD	N	6.63
2	5L-8855	RING	S	11.66
5	5S-5880	LOCK NUT	N	10.70
2	5S-5881	LOCK NUT	N	10.20
12	8M-7145	WASHER	S	15.36
12	9S-8752	NUT	S	3.00
6	9Y-1979	GASKET	S	80.34

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INVOICE # 07W00087766	08-21-19	CUSTOMER # C55617	07	G	1	8
REFERENCE # 0732506	06-04-19	10 10 10			8366027	
MAKE AA	MODEL D7F	SERIAL NUMBER 061G00216			9999999.0	

SPEC, REPLACE ROD BEARINGS, APPLY WHITE LITHIUM ASSEMBLY LUBE TO ALL BEARINGS, APPLY OIL TO ROD CAP BOLT THREADS, TORQUE CAPS TO SPEC, ASSEMBLE OIL PUMP, FILL PUMP WITH ASSEMBLY LUBE, INSTALL OIL PUMP, INSTALL OIL SUCTION TUBES, INSTALL TWO PIECE OIL PAN.

2 1R-0739	FILTER AS	S	27.14
2 6N-8940	PLATE THR	N	64.82
1 7H-1796	GASKET	N	1.04
1 8M-0904	GASKET	N	.91
6 BN-8220	BEARING	N	141.90
1 9H-6067	SEAL	N	3.81
1 169-4199	GASKET-OIL	N	38.45
1 169-4200	GASKET	S	34.73
7 232-3233	BEARING-MAIN	N	233.59
	TOTAL PARTS	SEG. 21	546.39 *
		F/R LBR	806.00 *
	SEGMENT 21 TOTAL		1352.39 T

REPLACE CYLINDER LINER

COMPLAINT: LINER AND PISTON SCORED.

CAUSE: HEAD GASKET FAILURE AT #6 CYLINDER.

CORRECTION: WITH OIL PAN REMOVED DISCONNECT THE #6 PISTON ROD END CAP, USE TOOLING TO REMOVE CYLINDER

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REFERENCE # 0732506	06-04-19	10 10 10			8366027	
MAKE AA	MODEL D7F	SERIAL NUMBER 061G00216			9999999.0	

APPLY GASKET DRESSING TO VALVE COVER AND ONE SIDE OF VALVE COVER GASKET AND STICK TWO PIECES TOGETHER, INSTALL VALVE COVER AND TORQUE TO SPEC. CONNECT CONTROL LINKAGES AND BRACKETRY TO FIREWALL, INSTALL TURBO OIL LINES, CONNECT WATER LINES, INSTALL PLUGS INTO HEAD AND CONNECT WATER TEMP SENSOR, INSTALL FUEL LINES, INSTALL GLOW PLUGS, INSTALL GLOW PLUG HARNESS, INSTALL INTAKE PIPE, CLOCK TURBO AND TIGHTEN, INSTALL AIR FILTER HOUSING, INSTALL EXHAUST MUFFLER, INSTALL FILTER BASE BRACKET AND MOUNT OIL FILTER BASE, FILL WITH ENGINE OIL AND REPLACE FILTER, FILL COOLING SYSTEM WITH WATER, INSTALL CRANKCASE BREATHER, STARTED ENGINE AND CHECKED FOR LEAKS.

1	0T-0225	GASKET	N	2.27
1	1A-5183	CAPSCREW	N	1.65
1	1R-0739	FILTER AS	S	13.57
1	1S-4810	GASKET	S	.96
1	1S-6595	GASKET	S	.80
1	2P-6132	GASKET	N	2.77
26	2S-0736	WASHER	N	17.94
1	4F-6109	GASKET	N	1.11
2	4L-8337	SEAL	N	20.70
1	4M-6480	GASKET	S	1.00
7	5B-3850	WASHER	N	1.75
1	5S-9059	GASKET	N	2.96
1	6N-7263	GASKET	N	61.98
1	8H-9818	GASKET	N	1.34
2	8S-4000	DAMPER	N	10.30

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REMOVE & INSTALL ACCESS PANEL

COMPLAINT: NEEDS ROD MAIN BEARINGS INSPECTED.

CAUSE: HEAD GASKET FAILURE.

CORRECTION: PLACE TRANSMISSION JACK UNDER BELLY PAN, REMOVE MOUNTING BOLTS AND LOWER TO GROUND, BELLY PAN WAS PACKED FULL OF WET DIRT, CLEAN ALL DIRT OUT OF BELLY PAN.

TOTAL LABOR SEG. 15

SEGMENT 15 TOTAL 768.80 T

REPLACE PISTON & MAIN BEARING

COMPLAINT: BEARINGS ARE WORN.

CAUSE: OIL DILUTED WITH COOLANT DUE TO HEAD GASKET FAILURE.

CORRECTION: CLEAN UP CRANKSHAFT DUE TO SOME COOLANT RESIDUE FROM REMOVING CYLINDER LINER, START REPLACING MAIN BEARINGS, REPLACE THRUST BEARINGS, FINISH REPLACING MAIN BEARINGS, APPLY WHITE LITHIUM ASSEMBLY LUBE TO ALL THE MAIN BEARINGS AND THRUST BEARINGS, APPLY ANTISEIZE TO BOLT THREADS AND FACE OF WASHERS AND TORQUE TO

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REFERENCE # 0732506	06-04-19	10 10 10				8366027
MAKE AA	MODEL D7F	SERIAL NUMBER 061G00216			9999999.0	

NEW METER.

1 1A-6240  
1 9S-7992

WASHER  
METER A

N .20  
N 128.48

TOTAL PARTS SEG. 35

TOTAL LABOR SEG. 35

SEGMENT 35 TOTAL 178.28 T

MACHINE/GRIND/MILL CYLINDER HEAD ASSEMBLY

COMPLAINT: CUSTOMER WANTED HEAD MILLED.

CAUSE: HEAD GASKET FAILURE.

CORRECTION: REMOVED PRE-CHAMBERS AND VALVES.

CLEANED HEAD SURFACE SET ON THE MILL AND LEVELED.

REMOVED .016" FROM THE HEAD SURFACE. INSTALLED  
VALVES, PRE-CHAMBERS, NOZZLES, AND NEW EXHAUST  
STUDS AND TORQUE ALL TO SPEC. WRAPPED UP AND SENT  
BACK TO JAMESTOWN.

6 5B-3718	SEAL	S	11.22
1 5M-2667	GASKET	S	2.68
1 5S-6735	GASKET	S	1.92
6 6F-1069	SEAL A	S	19.86
6 6V-1585	SEAL O RING	S	20.70

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TOTAL PARTS SEG. 40

TOTAL LABOR SEG. 40

SEGMENT 40 TOTAL 799.78 T

REPLACE VALVE GUIDE

COMPLAINT: FOUND VALVE GUIDE ON NUMBER TWO EXHAUST  
WORN AND FULL OF CARBON.

CAUSE: GUIDE WORN.

RESULTANT DAMAGE: REPLACE VALVE, VALVE GUIDE, AND  
VALVE SEAT.

CORRECTION: REMOVED VALVE FROM THE HEAD. REMOVED  
VALVE SEAT, CLEANED HEAD AND INSTALLED A NEW SEAT.  
PRESSED IN A NEW VALVE GUIDE AND REAMED TO SPEC,  
HAD ISSUES WITH FIVE GUIDES AS THEY BROKE DRIVING  
INTO PLACE, USED LIQUID NITROGEN AND THE PRESS TO  
INSTALL TO SPEC. GROUND NEW VALVE AND TOUCHED UP  
NEW SEAT TO MAKE GOOD CONTACT WITH THE VALVE.

1	1W-5321	INSERT	N	19.74
2	2A-4429	LOCK	S	1.56
2	2M-2488	STUD	N	13.26
10	7S-6719	STUD	S	59.70

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REFERENCE # 0732506	06-04-19	10 10 10				8366027
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PACK, INSPECT BLOCK WHERE O-RINGS SEAL AND FIND IT TO BE PITTED PRETTY BADLY, SHOWED ADVISOR AND LEAD ISSUE, ADVISOR WORKED WITH CUSTOMER ON HOW TO REPAIR AND HE DECIDED THAT WE WOULD ADD SUPERIOR METAL TO THE BLOCK TO MAKE IT SMOOTH AGAIN, THE NEW CYLINDER LINER WAS A THREE O-RING GROOVE LINER AT THE BOTTOM WHERE AS THE ORIGINAL LINER WAS A TWO O-RING GROOVE LINER, DID SOME MEASUREMENTS AND FIND THAT THE TOP GROOVE ON THE THREE GROOVE LINER WILL BARELY START ONTO SEALING SURFACE OF BLOCK, WORK WITH LEAD AND PARTS TO FIGURE OUT IF THIS IS THE CORRECT UPDATED CYLINDER LINER TO BE USED FOR THIS ENGINE, THE LINER WAS DETERMINED TO BE USED, ROTATED ENGINE OVER SO ROD JOURNAL WAS AT BOTTOM STROKE, INSTALL O-RINGS ONTO LINER, LUBRICATE O-RINGS AND INSTALL WITH TOOLING, CHECK LINER PROJECTION ON #6 CYLINDER AND WAS GOOD, INSTALL ROD END CAP AND TORQUE TO SPEC.

1 OR-1694	CYL KIT-REM	N	535.62
1	CORE CHARGE	N	177.33
1-	CORE CREDIT	N	177.33-
	TOTAL PARTS	SEG. 22	535.62 *
		F/R LBR	496.00 *
	SEGMENT 22 TOTAL		1031.62 T

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MAKE AA	MODEL D7F	SERIAL NUMBER 061G00216			9999999.0	

PACK, INSPECT BLOCK WHERE O-RINGS SEAL AND FIND IT TO BE PITTED PRETTY BADLY, SHOWED ADVISOR AND LEAD ISSUE, ADVISOR WORKED WITH CUSTOMER ON HOW TO REPAIR AND HE DECIDED THAT WE WOULD ADD SUPERIOR METAL TO THE BLOCK TO MAKE IT SMOOTH AGAIN, THE NEW CYLINDER LINER WAS A THREE O-RING GROOVE LINER AT THE BOTTOM WHERE AS THE ORIGINAL LINER WAS A TWO O-RING GROOVE LINER, DID SOME MEASUREMENTS AND FIND THAT THE TOP GROOVE ON THE THREE GROOVE LINER WILL BARELY START ONTO SEALING SURFACE OF BLOCK, WORK WITH LEAD AND PARTS TO FIGURE OUT IF THIS IS THE CORRECT UPDATED CYLINDER LINER TO BE USED FOR THIS ENGINE, THE LINER WAS DETERMINED TO BE USED, ROTATED ENGINE OVER SO ROD JOURNAL WAS AT BOTTOM STROKE, INSTALL O-RINGS ONTO LINER, LUBRICATE O-RINGS AND INSTALL WITH TOOLING, CHECK LINER PROJECTION ON #6 CYLINDER AND WAS GOOD, INSTALL ROD END CAP AND TORQUE TO SPEC.

1 OR-1694	CYL KIT-REM	N	535.62
1	CORE CHARGE	N	177.33
1-	CORE CREDIT	N	177.33-

TOTAL PARTS	SEG. 22	535.62 *
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SEGMENT 22 TOTAL	F/R LBR	496.00 *
		1031.62 T

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WORK PERFORMED AT JAMESTOWN BUTLER

TROUBLESHOOT ENGINE COOLING SYSTEM

COMPLAINT: TROUBLESHOOT ENGINE COOLING SYSTEM.

CAUSE: HEAD GASKET FAILED.

CORRECTION: CHECKED ENGINE OIL AND COULD SEE WAS OVERFULL WITH COOLANT/WATER. GOT MACHINE STARTED AND GOT INTO SHOP. TALKED WITH LEAD AND WAS DECIDED TO REMOVE GLOW PLUG TO SEE IF WE COULD SEE ANYTHING. WIRING WAS DISCONNECTED FOR GLOW PLUGS. REMOVED GLOW PLUGS 1-5 AND INSPECTED WITH BORE SCOPE AND DID NOT SEE ANYTHING. WHEN GLOW PLUG #6 WAS REMOVED, COOLANT STARTED COMING OUT OF PRE-CHAMBER. TALKED WITH LEAD AND WAS DECIDED CYLINDER HEAD NEEDS TO BE REMOVED.

TOTAL LABOR SEG. 01

SEGMENT 01 TOTAL

372.00 T

REPLACE WITH REMAN WATER PUMP

TOTAL LABOR SEG. 02 248.00 \*

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INVOICE #	07W00087766	08-21-19	CUSTOMER #	C55617	07	G	1	3
REFERENCE #	0732506	06-04-19	10	10	10		8366027	
MAKE	AA	MODEL	D7F	SERIAL NUMBER	061G00216		9999999.0	

TOTAL PARTS SEG. 05

TOTAL LABOR SEG. 05

SEGMENT 05 TOTAL 881.89 T

REMOVE WORN OR BROKEN BOLTS

COMPLAINT: WHEN ATTEMPTING TO REMOVE OIL PAN ONE OF THE BOLTS BROKE OFF.

CAUSE: RUSTED.

CORRECTION: THE HEAD OF AN OIL PAN BOLT BROKE OFF WHEN ATTEMPTING TO REMOVE, HAD TO BREAK OIL PAN BOLT IN DIFFERENT SPOT TO GET IT REMOVED FROM OTHER PIECE OF OIL PAN, REMOVE THE PIECES OF BROKEN BOLT FROM EACH OF THE OIL PAN PIECES.

TOTAL LABOR SEG. 06

SEGMENT 06 TOTAL 359.60 T

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REMOVE & INSTALL CYLINDER HEAD ASSEMBLY

COMPLAINT: REMOVE CYLINDER HEAD.

CAUSE: HEAD GASKET FAILED.

RESULTANT DAMAGE: COOLANT IN ENGINE OIL.

CORRECTION: DRAINED COOLING SYSTEM. REMOVED HOOD.

REMOVED AIR FILTER ASSEMBLY AND EXHAUST MUFFLER.

REMOVE INTAKE HORN, COOLANT PIPING AND FUEL LINES.

REMOVE OIL FILTER BASE AND BRACKET. REMOVE COOLANT LINE. REMOVE REAR BRACKET FOR CONSOLE AND LINKAGE ASSEMBLY FOR HAND CONTROLS. REMOVE VALVE COVER.

REMOVE ROCKER ARMS AND PUSH RODS. HOOK UP CYLINDER HEAD AND REMOVE CYLINDER HEAD. INSPECT CYLINDER HEAD, BLOCK AND HEAD GASKET. HEAD GASKET HAD FAILED AT #6 CYLINDER. CLEAN UP CYLINDER HEAD AND

ENGINE BLOCK AND INSPECT. TALK WITH LEAD AND ADVISOR. STARTED WITH CLEANING PARTS, LOCATE TAP AND TAP HEAD BOLT HOLES, CLEAN BLOCK AND PREP FOR HEAD INSTALL, GATHER HEAD BOLTS AND LOOKUP

REUSABILITY, CLEAN HEAD BOLTS AND FIND WASHERS TO BE BAD, LOOKUP AND ORDER PARTS, INSTALL NEW WASHERS ONTO BOLTS, CLEAN ROCKER SHAFT ASSEMBLY

AND LOOKUP INFO ON INSTALLATION, CLEAN PUSHRODS, INSTALL CYLINDER HEAD, APPLY OIL TO BOLTS AND WASHER FACES, TORQUE BOLTS IN SEQUENCE TO SPEC.

ROLL ENGINE OVER TO TDC1 AND SET APPROPRIATE INLET VALVES TO .015 IN. AND EXHAUST VALVES TO .025 IN, ROTATE 360 DEGREES TO TDC6 AND ADJUST APPROPRIATE INLET VALVES TO .015IN. AND EXHAUST TO .025 IN.

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2	6N-8940	PLATE THR	N	64.82
1	7H-1796	GASKET	N	1.04
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1	9H-6067	SEAL	N	3.81
1	169-4199	GASKET-OIL	N	38.45
1	169-4200	GASKET	S	34.73
7	232-3233	BEARING-MAIN	N	233.59
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REPLACE CYLINDER LINER

COMPLAINT: LINER AND PISTON SCORED.  
CAUSE: HEAD GASKET FAILURE AT #6 CYLINDER.  
CORRECTION: WITH OIL PAN REMOVED DISCONNECT THE #6 PISTON ROD END CAP, USE TOOLING TO REMOVE CYLINDER

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1	7S-7144	SPRING	S	5.81
1	8N-0875	VALVE	N	37.42
1	8N-7782	ROTOCOIL A	N	10.54
6	148-7425	GUIDE-VALVE	N	67.98
		TOTAL PARTS	SEG. 41	216.01 *
		TOTAL LABOR	SEG. 41	630.00 *
		SEGMENT 41 TOTAL		846.01 T

## DISASSEMBLE CYLINDER HEAD ASSEMBLY

COMPLAINT: DISASSEMBLE HEAD TO BE TESTED.

CORRECTION: REMOVED NUTS AND NOZZLE, ALSO REMOVED FITTINGS TO TEST HEAD.

TOTAL LABOR	SEG. 50	151.20 *
SEGMENT 50 TOTAL		151.20 T

## CLEAN CYLINDER HEAD ASSEMBLY

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MAKE AA	MODEL D7F	SERIAL NUMBER 061G00216			9999999.0	

CAUSE: #1 ADAPTER LEAKING.

CORRECTION: REMOVED ADAPTERS, SAND BLASTED AND CLEANED UP. FOLLOWING SIS SPECS, INSTALLED WITH SPACERS SPRAYED HEAD WITH PENETRATING OIL, WRAPPED UP. WRAPPED UP NOZZLES, FITTINGS AND NEW O-RINGS AND PUT IN A BOX. BROUGHT EVERYTHING UP TO PARTS TO BE SHIPPED TO BE MACHINED.

3 2S-8959	GASKET	N	2.82	8.46
6 7S-3206	SEAL-O-RING	N	6.92	41.52
TOTAL PARTS			SEG. 53	49.98 *
SEGMENT 53 TOTAL			F/R LBR	378.00 *
				427.98 T

ASSEMBLE AIR DRYER

ASSEMBLE AIR DRYER FOR CUSTOMER

COMPLAINT: ASSEMBLE AIR 2 AIR DRYER.

CAUSE: CUSTOMER REQUEST.

CORRECTION: THE CARTRIDGE WAS SEATED IN HOUSING. THE NEW O-RING WAS THEN INSTALLED AND END CAP SEATED. THE SNAP RING WAS SET INTO PLACE. THE LOCKS WERE THEN ENGAGED.

TOTAL LABOR	SEG. 99	62.00 *
-------------	---------	---------

1.5% per month (18% per annum) service charge on overdue accounts.

TERMS- Net Cash: Parts/Service/Rental due tenth of month following purchase.

Machine sales 10 days from date of invoice. Lease/Contract per agreement.

Please Pay  
This Amount

CONT'D

PLEASE REMIT ALL PAYMENTS TO: BUTLER MACHINERY COMPANY, BOX 9659, FARGO, ND 58106  
FOR CREDIT INQUIRIES, PLEASE CALL (701) 232-0833 FAX (701) 298-1717

INVOICE COPY Make AA= CAT

Sold To:

Ship To:

INVOICE # 07W00087766	08-21-19	CUSTOMER # C55617	07	G	1	14
REFERENCE # 0732506	06-04-19	10 10 10				8366027
MAKE AA	MODEL D7F	SERIAL NUMBER 061G00216			9999999.0	

COMPLAINT: CLEAN CYLINDER HEAD BEFORE PRESSURE TESTING.

CORRECTION: REMOVED GASKETS, BUFFED SURFACES, WASHED HEAD IN CUDA.

TOTAL LABOR SEG. 51

SEGMENT 51 TOTAL 63.00 T

CRACK/LEAK TEST CYLINDER HEAD ASSEMBLY

COMPLAINT: CRACK / LEAK TEST CYLINDER HEAD.

CORRECTION: PUT HEAD INTO TANK AT 180 DEGREES / 60 PSI / 1 HOUR. HEAD PASSED, OTHER THAN #1 ADAPTER LEAKING. REMOVED HEAD, SPRAYED WITH PENETRATING OIL. WILL RESEAL ADAPTERS ON ANOTHER SEGMENT.

F/R LBR  
SEGMENT 52 TOTAL

360.00 T

REPLACE GASKET/RESEAL PRECHAMBER/NOZZLE ADAPTER SET (ALL)

COMPLAINT: RESEAL ADAPTERS.

1.5% per month (18% per annum) service charge on overdue accounts.

TERMS- Net Cash: Parts/Service/Rental due tenth of month following purchase.

Machine sales 10 days from date of invoice. Lease/Contract per agreement.

Please Pay  
This Amount

CONT'D

PLEASE REMIT ALL PAYMENTS TO: BUTLER MACHINERY COMPANY, BOX 9559, FARGO, ND 58106  
FOR CREDIT INQUIRIES, PLEASE CALL (701) 232-6933 FAX (701) 298-1717

INVOICE COPY Make AA= CAT

Sold To:

Ship To:

INVOICE # 07W00087766	08-21-19	CUSTOMER # C55617	07	G	1	16
REFERENCE # 0732506	06-04-19	10 10 10				8366027
MAKE AA	MODEL D7F	SERIAL NUMBER 061G00216			9999999.0	

SEGMENT 99 TOTAL

62.00 T

TOTAL PARTS DISCOUNT 18.98-

N D STATE TAX 117.67 T  
JAMESTOWN CITY TAX 47.07 T

\* \* \*

C A S H

\* \* \*

1.5% per month (18% per annum) service charge on overdue accounts.

TERMS- Net Cash: Parts/Service/Rental due tenth of month following purchase.

Machine sales 10 days from date of invoice. Lease/Contract per agreement.

Please Pay  
This Amount

12817.01

PLEASE REMIT ALL PAYMENTS TO: BUTLER MACHINERY COMPANY, BOX 8689, FARGO, ND 58106  
FOR CREDIT INQUIRIES, PLEASE CALL (701) 232-6833 FAX (701) 238-1717

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