



3151 Charleston Hwy
West Columbia, SC 29172

credit@blanchardmachinery.com
Phone : (866) 313-0432

PLEASE REMIT TO:
BLANCHARD MACHINERY CO.
P.O. BOX 402197
Atlanta, GA 30384-2197

CUSTOMER NUMBER	0181350
CUSTOMER ORDER NUMBER	FLLPO29133
INVOICE NUMBER	IE09751
INVOICE DATE	04/26/2023
DUE 05/26/2023	185,491.99

SOLD TO

AMERICAN QUEEN STEAMBOAT
OPERATING COMPANY LLC
222 PEARL STREET
3RD FLOOR
NEW ALBANY IN 47150

SHIP TO

1670 Dry Dock Av
1670 DRY DOCK AVE.
"NAVIGATOR"
North Charleston, SC, 29405

MAKE	MODEL	SERIAL NUMBER	EQUIPMENT NUMBER	METER READING	MACH. ID NO.
AA	3516	09AN00184	MULTIPLE	4669.0	
QUANTITY	ITEM	DESCRIPTION	UNIT PRICE	EXTENSION	
		RECON BEFORE FAILURE ENGINE STBD GENSET SN: 9AN00184 TECHNICIAN DROVE TO CUSTOMER JOB SITE AND ONCE ON SITE TECHNICIAN MADE WAY INTO THE ENGINE SPACE AND BEGAN BY VERIFYING THE LOCK OUT AND TAG OUT WAS COMPLETED AND FLUIDS DRAINED. ONCE VERFIED TECHNICIAN BEGAN BY REMOVING THE CRANKCASE FILTER HOUSINGS THE AIR INTA PIPING AND THE AIR FILTER HOUSINGS. TECHNICIANS THEN REMOVED THE EXHAUST HEAT SHIELDS AND THEN REMOVED THE FUEL RAILS AND WATER MANIFOLDS. TECHNICIANS THEN REMOVED THE VALVE TRAIN PUSH RODS AND ROCKER BOXES. TECHNICIANS THEN REMOVED THE FUEL INJECTORS AND THEN REMOVED THE FUEL LINE FITTINGS AND THEN REMOVED THE THERMOCOUPERS. TECHNICIANS THEN REMOVED BOTH EXHAUST MANIFOLDS. TECHNICIANS THEN REMOVED THE SINGLE CYLINDER AIR INTAKES, AND THEN REMOVED THE HEAD BOLTS. TECHNICIANS THEN CLEANED UP THE WORK AREA AND DROVE BACK TO THE SHOP AND WROTE SERVICE REPORT AND NOTES. TECHNICIAN DROVE TO CUSTOMER JOB SITE AND ONCE ON SITE TECHNICIAN MADE WAY ONBOARD AND INTO THE ENGINE SPACE. TECHNICIAN BEGAN HELPING THE CREW TO GET THE CYLINDER HEADS TO THE UPPER DECK AND THEN TECHNICIAN USED CRANE TO GET CYLINDER HEADS FROM THE SHIP ONTO SERVICE VEHICLE AND HAD THEM TRANSPORTED TO MACHINE SHOP. TECHNICIANS THEN VACUMMED ENGINE OF DEBRIS AND THEN TECHNICIANS CLEANED THE DECK SURFACE OF THE ENGINE BLOCK.			
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		TECHNICIANS THEN LAID DOWN NEW GASKETS SPACER PLATES AND SEALS. TECHNICIANS THEN COVERED THE ENGINE AND THEN DISASSEMBLED THE R/H WATER MANIFOLD AND CLEANED AND REASSEMBLED WITH NEW SEALS AND GASKETS. TECHNICIANS THEN CLEANED UP THE WORK AREA AND DROVE BACK TO THE SHOP AND WROTE SERVICE REPORT AND NOTES. TECHNICIANS DROVE TO CUSTOMER JOB SITE AND ONCE ON SITE TECHNICIANS MADE WAY ONTO THE SHIP AND INTO THE ENGINE SPACE. TECHNICIANS BEGAN BY DISASSEMBLING THE ROCKER SHAFTS AND REPLACING THE ROCKER ARMS WITH NEW SPRINGS BUTTONS ADJUSTMENT SCREWS AND NUTS. TECHNICIANS THEN DISASSEMBLED THE L/H WATER MANIFOLD AND REASSEMBLED WITH NEW SEALS AND GASKETS. TECHNICIANS THEN CLEANED THE L/H ROCKER BOXES AND THEN CLEANED UP THE WORK AREA AND DROVE BACK TO THE SHOP AND WROTE SERVICE REPORT AND NOTES. TECHNICIAN DROVE TO CUSTOMER JOB SITE AND ONCE ON SITE TECH TRANSPORTED TOOLING AND SUPPLIES ONTO THE VESSEL AND MET WITH THE CHIEF ENGINEER. TECHNICIANS THEN VERIFIED ALL SYSTEMS WERE LOCKED AND TAGGED OUT AND ONCE COMPLETE TECHNICIANS BEGAN BY REMOVING THE AIR PIPING, AIR FILTER HOUSINGS AND AFTERCOOLER COVER. TECHNICIANS THEN REMOVED THE EXHAUST HEAT SHIELDS, THE FUEL RAILS, AND THE WATER MANIFOLDS. TECHNICIANS THEN REMOVED THE VALVE COVERS, ROCKER BOXES, VALVE TRAIN, INJECTORS, AND PUSH RODS. TECHNICIANS THEN REMOVED			
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QUANTITY	ITEM	DESCRIPTION	UNIT PRICE	EXTENSION	
		THE EXHAUST MANIFOLDS AND AIR INTAKES. TECHNICIANS THEN REMOVED THE FUEL LINE FITTINGS AND CYLINDER HEAD BOLTS. TECHNICIANS THEN CLEANED UP THE WORK AREA AND COVERED ENGINE AND WROTE SERVICE REPORT AND NOTES, AND DROVE BACK TO THE SHOP. TECHNICIAN DROVE TO CUSTOMER JOB SITE AND ONCE ON SITE TECHNICIAN MADE WAY TO THE ENGINE SPACE AND ONCE IN THE ENGINE ROOM TECHNICIAN BEGAN BY DOING THE FINAL TORQUE ON THE CYLINDER HEADS. ONCE TORQUE WAS COMPLETE TECHNICIAN CLEANED AND INSTALLED THE VALVE COVER BASES WITH NEW SEALS AND THEN TECHNICIAN DISASSEMBLED THE AIR INTAKES AND CLEANED AND THEN RESEALED AND THEM INSTALLED ON THE ENGINE WITH NEW SEALS AND GASKETS. TECHNICIAN THEN INSTALLED THE FUEL INJECTORS AND THEN CLEANED UP THE WORK AREA AND THEN WENT TO SERVICE TRUCK AND ORDERED ADDITIONAL PARTS. DROVE BACK TO THE SHOP AND WROTE SERVICE REPORT AND NOTES. TECHNICIAN DROVE TO CUSTOMER JOB SITE AND ONCE ON SITE TECHNICIAN MADE WAY TO THE ENGINE SPACE AND BEGAN BY INSTALLING THE THE R/H VLAVE COVER BASES, WITH NEW SEALS AND THEN INSTALLED FUEL INJECTORS. TECHNICIAN THEN REBUILT ALL ROCKER ARM ASEMBLIES WITH NEW BUTTONS AND SPRINGS AND THEN INSTALLED THEM ONTO THE ENGINE AND TORQUED TO CAT SPEC. TECHNICIAN THEN INSTALLED THE AIR INTAKES ON THE R/H SIDE AND THEN TECHNICIAN RESEALED AND EXHAUST MANIFOLDS AND INSTALLED THEM ONTO THE ENGINE.			
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		TECHNICIAN THEN ROTATED THE ENGINE TO TDC AND SET AND ADJUSTED THE VALVE LASH TO CAT SPEC, AND SET AND ADJUSTED THE FUEL TIMING TO CAT SPEC ON TEH COMPRESSION AND EXHAUST STOKES. TECHNICIAN THEN CLEANED UP THE WORK AREA AND DROVE BACK TO THE SHOP AN WROTE SERVICE REPORT AND NOTES. TECHNICIAN DROVE TO CUSTOMER JOB SITE AND ONCE ON SITE TECHNICIAN MADE WAY INTO THE ENGINE SPACE AND BEGAN BY REMOVING AND INSTALLING THE TURBO CARTRIDGES. TECHNICIAN THEN CLEANED THE COMPRESSOR HOUSINGS AND INSTALLED THEM ON THE TURBOS. TECHNICIAN THEN INSTALLED THE VALVE COVERS, AND THEN REMOVED AND REPLACED THE WATER TEMP REGULATORS. TECHNICIANS THEN DISASSEMBLED THE WATER MANIFOLDS AND REASSEMBLED WITH NEW SEALS AND GASKETS. TECHNICIANS THEN INSTALLED BOTH LEFT AND RIGHT HAND WATER MANIFOLDS WITH NEW SEALS, AND THEN INSTALLED BOTH LEFT AND RIGHT HAND FUEL RAILS. TECHNICIANS THEN CLEANED UP THE WORK AREA AND DROVE BACK TO THE SHOP AND WROTE SERVICE REPORT AND NOTES. TECHNICIAN DROVE TO CUSTOMER JOB SITE AND ONCE ON SITE TECHNICIAN MADE WAY INTO THE ENGINE SPACE AND BEGAN BY INSTALLING THE AIR FILTER HOUSINGS WITH NEW AIR FILTERS AND THEN TECHNICIANS INSTALLED BOTH LEFT AND RIGHT HAND EXHAUST HEAT SHIELDING. TECHNICIANS THEN INSTALLED THE AFTER COOLER CORES WITH NEW SEALS AND ORINGS, AND THEN TECHNICIANS INSTALLED THE AFTERCOOLER COVER. TECHNICIANS THEN			
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QUANTITY	ITEM	DESCRIPTION	UNIT PRICE	EXTENSION	
		INSTALLED THE AIR INTAKE PIPES, AND THEN TURBO WATER LINES AND OIL LINES. TECHNICIANS THEN HAD THE CREW CHANGE THE OIL FILTERS, PUMP IN OIL AND JACKET WATER. TECHNICIANS THEN INSTALLED THE CRANK CASE FILTER HOUSINGS, AND HOOKED MAIN OIL SUCTION PIPE BACK UP AND INSTALLED THE ELECTRICAL PANEL BACK ONTO THE ENGINE. TECHNICIANS PRIME AND BLED FUEL SYSTEM AND HAD CREW START THE ENGINE. SMALL LEAKS WERE FOUND TRIED TO CORRECT BUT THE R/H FRONT SECTION OF THE WATER MANIFOLD WOULD NEED TO BE TAKEN BACK OFF AND LOOKED AT CONTINUES TO LEAKS. TECHNICIAN CLEANED UP THE WORK AREA AND DROVE BACK TO THE SHOP AND WROTE SERVICE REPORT AND NOTES. TECHNICIAN DROVE TO CUSTOMER JOB SITE AND MADE WAY ON THE SHIP AND INTO THE ENGINE SPACE. TECHNICIAN BEGAN BY HAVING THE CREW DRAIN THE COOLANT DOWN AND THEN REMOVED THE SECTION OF WATER MANIFOLD AND HAD TO TP OUT BOLT HOLE IN THE LOWER REGULATOR HOUSING AND THEN RE INSTALLED MANIFOLD SECTION WITH NEW GASKETS AND THEN HAD THE CREW REFILL WITH COOLANT AND THEN CHECKED LEAK WAS REPAIRED. TECHNICIAN ALSO FOUND THAT WHILE TRYING TO CONNECT LAPTOP TO ECM IT WOULD NOT COMMUNICATE SO TECHNICIAN DID SOME TROUBLESHOOTING AND FOUND THE PLUGS TO HAVE OIL ON THEM SO TECHNICIAN CLEANED UP PLUGS AND THEN HOOKED BACK UP AND GOT LAPTOP AND CAT ET TO COMMUNICATE. TECHNICIANS THEN CLEANED UPO THE WORK AREA AND MADE SURE AGAIN THE FUEL			
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	SYSTEM WAS PRIMED AND THEN HAD THE CREW START THE ENGINE ND LET IT GET UP TP TEMP AND RAN IT FOR 30 MINUTES WITH NO ISSUES. TECHNICIANS THEN DEPARTED THE SHIP AND DROVE BACK TO THE SHOP AND WROTE SERVICE REPORT AND NOTES. AFTER RUNNING ENGINE NEXT DAY TECHNICIANS OBSERVED A SMALL EXHAUST LEAK SO TECHNICIANS HAD CREW TRANSFER POWER TO PORT GENSET AND LET COOL DOWN AND INSPECTED THE EXHAUST FOUND NO ISSUES WITH THE SECTIONS OR BELLOWS SO TECHNICIAN RE CLEANED THE SURFACES ANSD REPLACED SEALS AND REASSEMBLED AND HAD CREW RUN THE GENSET ONCE MORE AND FOUND THAT THE LEAK HAD BEEN RESOLVED.				
			F/R A	LL	23000.00 *
		SEGMENT 01 TOTAL			23000.00 T

	RECON BEFORE FAILURE ENGINE STARBOARD MAIN ENGINE S/N:8KN00397 TECHNICIAN DROVE TO CUSTOMER JOB SITE AND ONCE ON SITE TECHNICIAN MADE WAY INTO THE ENGINE SPACE AND BEGAN BY VERIFYING THE LOCK OUT AND TAG OUT WAS COMPLETED AND FLUIDS DRAINED. ONCE VERFIED TECHNICIAN BEGAN BY REMOVING THE CRANKCASE FILTER HOUSINGS THE AIR INTA PIPING AND THE AIR FILTER HOUSINGS. TECHNICIANS THEN REMOVED THE EXHAUST HEAT SHILEDSD AND THEN REMOVED THE FUEL RAILS AND WATER MANIFOLDS. TECHNICIANS THEN REMOVED THE VALVE TRAIN PUSH RODS AND ROCKER BOXES. TECHNICIANS THEN REMOVED THE FUEL INJECTORS AND				
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		CLEANED AND THEN RESEALED AND THEM INSTALLED ON THE ENGINE WITH NEW SEALS AND GASKETS. TECHNICIAN THEN INSTALLED THE FUEL INJECTORS AND THEN CLEANED UP THE WORK AREA AND THEN WENT TO SERVICE TRUCK AND ORDERED ADDITIONAL PARTS. DROVE BACK TO THE SHOP AND WROTE SERVICE REPORT AND NOTES. TECHNICIAN DROVE TO CUSTOMER JOB SITE AND ONCE ON SITE TECHNICIAN MADE WAY TO THE ENGINE SPACE AND BEGAN BY INSTALLING THE THE R/H VLAVE COVER BASES, WITH NEW SEALS AND THEN INSTALLED FUEL INJECTORS. TECHNICIAN THEN REBUILT ALL ROCKER ARM ASEMBLIES WITH NEW BUTTONS AND SPRINGS AND THEN INSTALLED THEM ONTO THE ENGINE AND TORQUED TO CAT SPEC. TECHNICIAN THEN INSTALLED THE AIR INTAKES ON THE R/H SIDE AND THEN TECHNICIAN RESEALED AND EXHAUST MANIFOLDS AND INSTALLED THEM ONTO THE ENGINE. TECHNICIAN THEN ROTATED THE ENGINE TO TDC AND SET AND ADJUSTED THE VALVE LASH TO CAT SPEC, AND SET AND ADJUSTED THE FUEL TIMING TO CAT SPEC ON TEH COMPRESSION AND EXHAUST STOKES. TECHNICIAN THEN CLEANED UP THE WORK AREA AND DROVE BACK TO THE SHOP AN WROTE SERVICE REPORT AND NOTES. TECHNICIAN DROVE TO CUSTOMER JOB SITE AND ONCE ON SITE TECHNICIAN MADE WAY INTO THE ENGINE SPACE AND BEGAN BY REMOVING AND INSTALLING THE TURBO CARTRIDGES. TECHNICIAN THEN CLEANED THE COMPRESSOR HOUSINGS AND INSTALLED THEM ON THE TURBOS. TECHNICIAN THEN INSTALLED THE VALVE COVERS, AND THEN REMOVED AND REPLACED THE WATER TEMP			
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		PROTECTING SPRAY ON THE HEADS. WRAPPED THE HEAD UP AND PUT THEM ON A PALLET.			
		F/R A	LL	14300.00 *	
		SEGMENT 06 TOTAL		14300.00 T	
		RECONDITION CYLINDER HEAD ASSEMBLY SHIPPED CYLINDER HEADS TO SPEC SHOP. PRESSURE WASH ALL CYL HEADS TO GET CARBON BUILD UP FROM INSIDE CYL HEADS, PERFORMED VALVE JOB ON ALL VALVES. FOUND 1 BENT INTAKE VALVE, REPLACED BENT INTAKE VALVE. LAPPED IN ALL VALVES USING LAPPING COMPOUND, CLEANED LAPPING COMPOUND FROM ALL VALVES AND FROM ALL HEADS, REASSEMBLED ALL CYL HEADS USING NEW VALVE OIL SEALS, RECHECKED ALL VALVE RECEPTION AND FOUND ALL WITHIN SPECS, CHECKED VACUUM ON ALL HEADS, ALL ARE HOLDING VACUUM, PAINTED ALL HEADS, LUBRICATE AND WRAPPED IN PLASTIC. SHIPPED HEADS TO SUMMERVILLE SHOP. LOADED CYLINDER HEADS AND TRANSPORTED TO JOBSITE. CRANED HEADS ONTO VESSEL AND TRANSPORTED TO THE ENGINE ROOM FOR INSTALLATION.			
		F/R A	LL	10500.00 *	
		SEGMENT 07 TOTAL		10500.00 T	
		RECONDITION CYLINDER HEAD ASSEMBLY 3/1/23 (2095) SURFACE HEAD. 6017--WASHED AND CLEANED ALL 18 CYL HEADS, PRESSURE TEST ALL 18 CYL HEADS, FOUND ALL HOLDING			
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		PRESSURE,CHECKED ALL VALVE RECESSON,AND FOUND ALL WITHIN SPEC,CHECKED ALL HEAD HEIGHT AND FOUND ALL WITHIN SPEC,CHECKED FLATNESS ON ALL AND FOUND ALL TO BE FLAT,DISASSEMBLED ALL CYL HEADS.CLEANED ALL VALVE SEATING AREAS WITH SCOTCH BRIGHT FLAPPER WHEEL,CLEANED TOP OF CYL HEADS, INTAKE AND EXHAUST PORT SEALING AREAS.MOVED ALL CYL HEAD TO MACHINE SHOP FOR MACHINING..			
		6017---PRESSURE WASH ALL CYL HEADS TO GET CARBON BUILD UP FROM INSIDE CYL HEADS,PERFORMED VALVE JOB ON ALL VALVES.FOUND 1 BENT INTAKE VALVE,REPLACED BENT INTAKE VALVE.LAPPED IN ALL VALVES USING LAPPING			
		COMPOUND,CLEANED LAPPING COMPOUND FROM ALL VALVES AND FROM ALL HEADS,REASSEMBLED ALL CYL HEADS USING NEW VALVE OIL SEALS,RECHECKED ALL VALVE RECESSON AND FOUND ALL WITHIN SPECS,CHECKED VACUUM ON ALL HEADS,ALL ARE HOLDING VACUUM,PAINTED ALL HEADS,LUBRICATE AND WRAPPED IN PLASTIC			
		3/3/2095 SET UP HEADS AND SURFACE.			
		3/4/23(4092)TOOK 2 CUTS ON HEADS LEFT IN MACHINE.			
		SET 6 MORE HEADS, IN SETS OF 3, INDICATED AND SHIMMED TO LEVEL EACH HEAD TO EACH OTHER. SURFCED ALL 6 HEADS			
			F/R A	LL	14300.00 *
		SEGMENT 10 TOTAL			14300.00 T

		RECONDITION CYLINDER HEAD ASSEMBLY			
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CUSTOMER ORDER NUMBER	FLLPO29133
INVOICE NUMBER	IE09751
INVOICE DATE	04/26/2023
DUE 05/26/2023	185,491.99

SOLD TO

AMERICAN QUEEN STEAMBOAT
OPERATING COMPANY LLC
222 PEARL STREET
3RD FLOOR
NEW ALBANY IN 47150

SHIP TO

1670 Dry Dock Av
1670 DRY DOCK AVE.
"NAVIGATOR"
North Charleston, SC, 29405

MAKE	MODEL	SERIAL NUMBER	EQUIPMENT NUMBER	METER READING	MACH. ID NO.
AA	3516	09AN00184	MULTIPLE	4669.0	
QUANTITY	ITEM	DESCRIPTION	UNIT PRICE	EXTENSION	
		UPDATE CYLINDER HEAD 6017-3-7-23-DISASSEMBLED CYL HEAD, REMOVED EXHAUST VALVE GUIDES AND SEATS. WASHED AND CLEANED HEAD, INSTALLED NEW EXHAUST VALVE GUIDES AND SEATS, LAPPED IN INTAKE AND EXHAUST VALVES USING LAPPING COMPOUND, CLEANED VALVES AND HEAD, INSTALLED NEW VALVE OIL SEALS FOR INTAKE VALVES, NEW WXHAUST SPRING WASHERS, INSTALLED NEW INNER AND OUTER SPRINGS ON INTAKE AND EXHAUST, INSTALLED NEW ROTTER COILS AND KEEPERS, PAINTED, LUBRICATE AND WRAPPED HEAD IN PLASTIC..			
		F/R A	LL	880.26 *	
		SEGMENT 11 TOTAL		880.26 T	
		RECONDITION CYLINDER HEAD ASSEMBLY UPDATE CYLINDER HEAD 6017-3-7-23-DISASSEMBLED CYL HEAD, REMOVED EXHAUST VALVE GUIDES AND SEATS. WASHED AND CLEANED HEAD, INSTALLED NEW EXHAUST VALVE GUIDES AND SEATS, LAPPED IN INTAKE AND EXHAUST VALVES USING LAPPING COMPOUND, CLEANED VALVES AND HEAD, INSTALLED NEW VALVE OIL SEALS FOR INTAKE VALVES, NEW WXHAUST SPRING WASHERS, INSTALLED NEW INNER AND OUTER SPRINGS ON INTAKE AND EXHAUST, INSTALLED NEW ROTTER COILS AND KEEPERS, PAINTED, LUBRICATE AND WRAPPED HEAD IN PLASTIC..			
		F/R A	LL	880.26 *	
		SEGMENT 12 TOTAL		880.26 T	
Blanchard Machinery Co., the Seller, expressly disclaims all warranties, either expressed or implied, including any implied warranty of merchantability or fitness for any particular use. The Seller neither assumes nor authorizes any other person to assume for it any liability in connection with the sales of this item/items. The Seller is not responsible for any consequential damages. Only the manufacturer's Warranty, if any, applies to this sales transaction.				PAY THIS AMOUNT	Cont'd
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