

HUDSON



FLAT RATE MANUAL

480-490-500 AND "A" SERIES

HUDSON MOTOR CAR COMPANY
DETROIT 14, MICHIGAN

17

INTRODUCTION

This edition of the Hudson Flat Rate Manual covers service operations applying to the 480, 490 and 500 and "A" series 6 and 8 cylinder Hudson cars. It is to be used as a guide by the Distributor and Dealer in determining his time allocations and establishing fair and competitive service charges to Hudson Owners.

The time established has been based on performance of the complete operation, with the necessary special tools, equipment and mechanics of average ability.

Where difficulty is encountered in doing the operation in the time given, a check should be made to determine if the Factory recommended procedure is being followed and, also, if the proper tools and equipment are used.

Factory adjustment of replacement certificates is on the basis of the established times shown in this flat rate manual.

In the back of this book will be found printed forms which are provided for reporting Dealers' shop experiences as related to the service operations and flat rate times shown in this manual. Your cooperation in making use of these forms when suggesting changes in time or additional service operations will be valuable when compiling new additions to this manual.

INSTRUCTIONS

In the "time required" column following the description of operations, there is also listed in some cases additional time required to perform further work at that particular state of disassembly.

The words, "remove," "install," and "overhaul" have definite meanings as will be explained in the following paragraphs.

The word "remove", implies to take off or out the part or parts unless otherwise specified such as "remove and replace," or "remove and install."

The word "install" is opposite of removal and applies to putting back the used part or installing a new one, for example, the first installation of an accessory or optional equipment.

"Overhaul" signifies removal of an assembly from the car, disassembly, inspection of all parts, and rebuild the assembly, using the same or new parts. Install the assembly and make necessary adjustments.

To expediate pricing and quoting, a labor conversion table is shown at the rear of the book and is computed at rates of \$2.50 to \$4.00 per hour labor charge.

The established time allowed covers the complete operation and allows for necessary preparation such as spotting the car, applying protective covers, procuring tools and parts.

The time established for the operations applies to standard production model cars. Therefore, where special equipment interferes with the performance of the operation, additional time allowances will have to be added to the standard time.

MODEL DESIGNATION

The new Hudson models are produced in the Super and Commodore Series and are identified as follows:

Hudson Super Six	Model 481-491-501
Hudson Commodore Six	Model 482-482-502
Hudson Super Eight	Model 483-493-503
Hudson Commodore Eight	Model 484-494-504
Hudson Pacemaker six	Model 500

1951 — "A" SERIES

Pacemaker Custom — 6 cyl.	Model 4A
Super Six Custom — 6 cyl.	Model 5A
Commodore Six Custom — 6 cyl.	Model 6A
Hornet Six — 6 cyl.	Model 7A
Commodore Eight Custom — 8 cyl.	Model 8A

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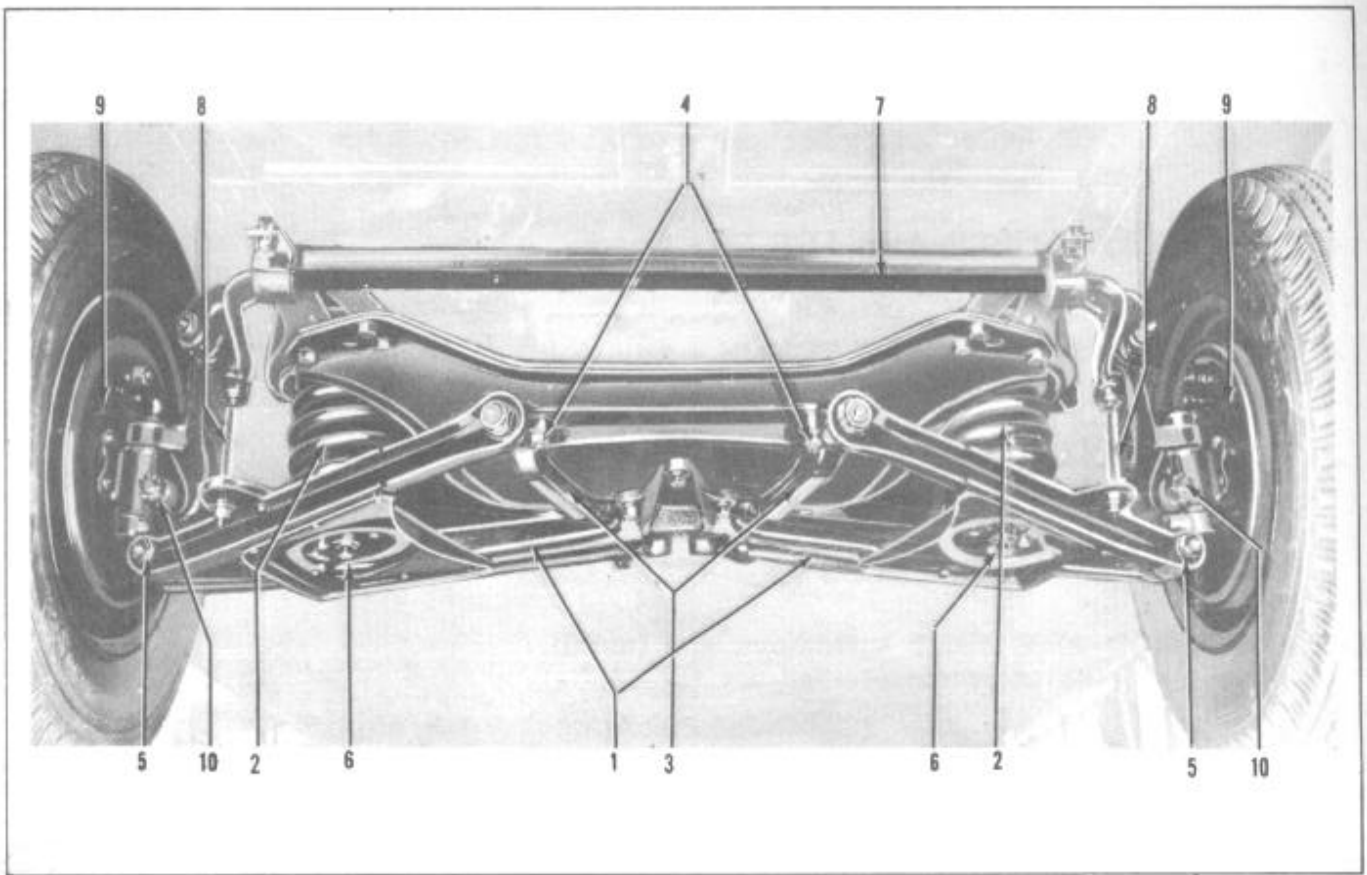
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OPERATION	DESCRIPTION	TIME	PRICE
FRONT SUSPENSION			
1-1	FRONT SUSPENSION OVERHAUL — Rebrush and replace any parts necessary — Includes adjusting caster, camber and toe-In All Models	5.9	_____
LOWER SUPPORT ARMS			
1-2	LOWER SUPPORT ARM (INNER) PIVOT — Remove and Install. All Models — one side both sides	.5 .9	_____ _____
1-3	LOWER SUPPORT ARM (INNER) PIVOT BUSHINGS — Remove and Install. All Models — one side both sides	.4 .7	_____ _____
1-4	LOWER SUPPORT ARM (OUTER) PIVOT AND/OR BUSHING — Remove and Install. All Models — one side both sides	.6 1.1	_____ _____
1-5	LOWER SUPPORT ARM — Remove and Install. All Models — one side both sides	1.3 2.5	_____ _____
UPPER SUPPORT ARMS			
1-6	UPPER SUPPORT ARM (INNER) PIVOT BUSHINGS — Remove and Install. All Models — right side left side	.6 .7	_____ _____
1-7	UPPER SUPPORT ARM ECCENTRIC BUSHING AND/OR PIVOT — Remove and Install. All Models — one side both sides	.7 1.3	_____ _____
1-8	UPPER SUPPORT ARM (INNER) PIVOT ASSEMBLY — Remove and Install. All Models — one side both sides	1.4 2.7	_____ _____
1-9	SUPPORT ARM RUBBER BUMPERS — Remove and Install. All Models — one side both sides	.3 .5	_____ _____
STEERING SPINDLE AND WHEEL BEARINGS			
1-10	STEERING SPINDLE — Remove and Install. All Models — one side both sides	1.3 2.1	_____ _____
1-11	STEERING SPINDLE PIVOT PIN AND SUPPORT BUSHINGS — Remove and Install. All Models — one side	1.7	_____
1-12	STEERING SPINDLE SUPPORT — Remove and Install. All Models — one side	1.9	_____
1-13	WHEEL BEARINGS — Remove, clean, repack, install and adjust. All Models — one side both sides	.6 .9	_____ _____



FRONT SUSPENSION

- | | |
|---|---|
| 1. Lower support arm assemblies | 6. Shock absorber anchor plate and attaching nuts |
| 2. Coil spring | 7. Front stabilizer bar |
| 3. Lower support arm pivot | 8. Stabilizer connectors |
| 4. Lower support arm pivot to frame bolt | 9. Brake backing plates |
| 5. Lower support arm to spindle support pivot and bushing | 10. Steering arm nut |

FRONT SUSPENSION — Continued

1-14 WHEEL HUB AND DRUM ASSEMBLY — Remove and Install

Includes cleaning, repacking and adjusting Wheel Bearings.

All Models — one side
both sides

.7 _____
1.0 _____

1-15 WHEEL BEARINGS — Adjust Only —

All Models — both sides

.4 _____

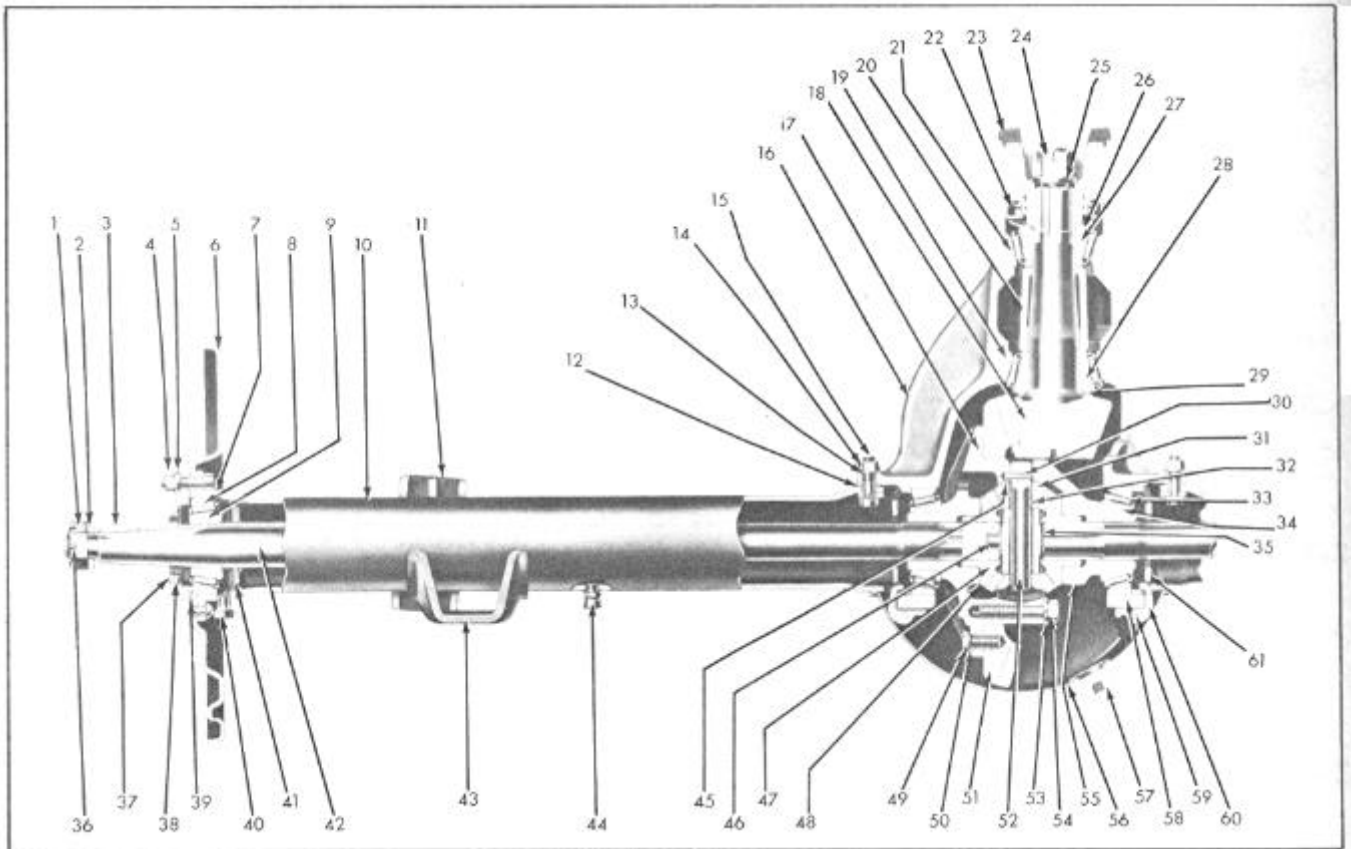
1-16 SPINDLE GREASE RETAINER AND WASHER — Remove and Install.

All Models — one side
both sides

.3 _____
.5 _____

OPERATION	DESCRIPTION	TIME	PRICE
FRONT SUSPENSION—Continued			
SPRINGS, SHOCK ABSORBERS AND STABILIZER			
1-17	COIL SPRINGS AND/OR SILENCER — Remove and Install.		
	All Models — one side	1.0	_____
	both sides	1.8	_____
1-18	SHOCK ABSORBER AND/OR RUBBER GROMMETS — Remove and Install.		
	All Models — one side	.5	_____
	both sides	.9	_____
1-19	SHOCK ABSORBER ANCHOR PLATE — Remove and Install.		
	All Models — one side	.2	_____
	both sides	.3	_____
1-20	LATERAL STABILIZER — Remove and Install. — All Models	.7	_____
1-21	LATERAL STABILIZER MOUNTING BRACKETS TO FRAME — Remove and Install.		
	All Models	.5	_____
1-22	LATERAL STABILIZER CONNECTORS AND/OR BUSHINGS — Remove and Install.		
	All Models — one side	.3	_____
	both sides	.5	_____
STEERING ARMS AND TIE RODS			
1-23	CENTER STEERING ARM AND PIVOT ASSEMBLY — Remove and Install.		
	All Models	1.0	_____
1-24	CENTER STEERING ARM PIVOT — Remove and Install.		
	All Models	1.8	_____
1-25	CENTER STEERING ARM BEARINGS, SPACERS OR SEALS — Remove and Install.		
	All Models	1.2	_____
1-26	CENTER STEERING ARM PIVOT BRACKET — Remove and Install.		
	All Models	.3	_____
1-27	TIE ROD ASSEMBLY — Remove and Install. Includes adjust toe-in.		
	All Models — one side	.4	_____
1-28	TIE ROD ASSEMBLIES — Remove and Install. Includes adjust toe-in.		
	All Models — both sides	.8	_____
1-29	TIE ROD CLAMP — Remove and Install.		
	All Models — one side	.3	_____
	both sides	.6	_____
1-31	TIE ROD END (INNER) — Remove and Install.		
	All Models — one side	.5	_____
	both sides	.7	_____
1-32	STEERING ARM — RIGHT OR LEFT — Remove and Install.		
	All Models	.7	_____

OPERATION	DESCRIPTION	TIME	PRICE
FRONT SUSPENSION—Continued			
1-33	DRAG LINK ASSEMBLY — Remove and Install. — All Models	.8	_____
1-34	DRAG LINK DUST COVER — Remove and Install. All Models	.3	_____
1-35	DRAG LINK BEARING AND/OR SPRING — Remove and Install. All Models — one end	.4	_____
	both ends	.7	_____
1-36	DRAG LINK — ADJUST. — All Models	.5	_____
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1-39	TOE-IN — ADJUST ONLY. — All Models	.6	_____
REAR AXLE			
2-1	AXLE ASSEMBLY — Remove and Install complete unit. Includes bleeding brake lines. — All Models	3.7	_____
2-2	AXLE ASSEMBLY HOUSING — Remove and Install. — Includes disassembly, inspection, reassembly and bleeding brake lines. All Models	6.5	_____
2-3	DIFFERENTIAL CARRIER AND GEAR SET ASSEMBLY OR HOUSING GASKET — Remove and Install. All Models	2.2	_____
2-4	DIFFERENTIAL CARRIER AND GEAR SET ASSEMBLY — Overhaul. — Includes disassembly and replacing necessary parts and adjusting drive gear and pinion. — All Models	4.7	_____
2-5	DIFFERENTIAL BEARINGS — Remove and Install. All Models — both bearings	3.0	_____
2-6	DRIVE PINION BEARINGS — Remove and Install. — Front and rear also includes adjustment of drive gear and pinion. All Models	3.8	_____
2-7	DRIVE GEAR AND PINION — Remove and Install. — Includes adjusting drive gear and pinion. — All Models	4.2	_____
2-8	DRIVE GEAR AND PINION — Adjust. — Includes remove and install carrier. — All Models	3.7	_____
2-9	DRIVE PINION OIL SEAL — Remove and Install. All Models	1.1	_____
2-10	DIFFERENTIAL CARRIER — Tighten to Axle Housing. All Models	.4	_____

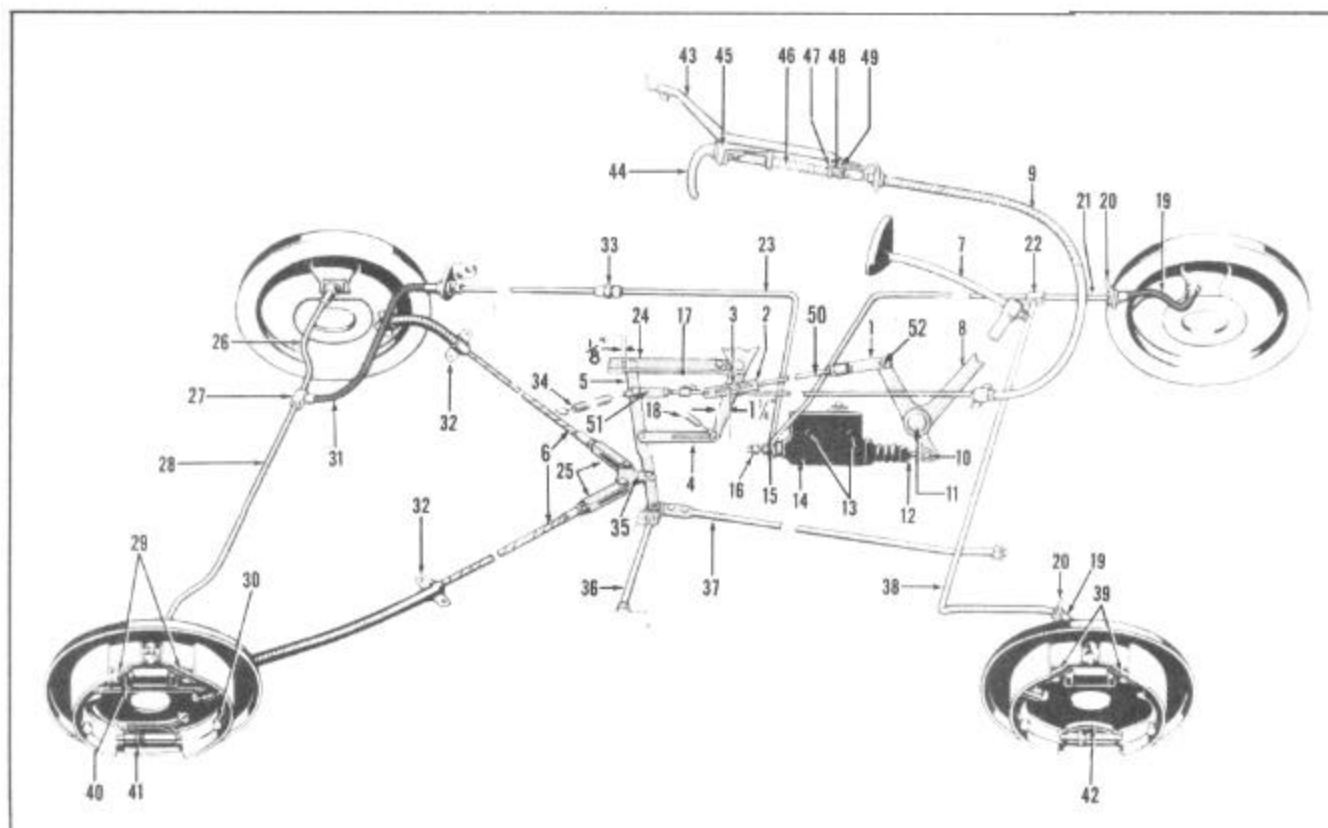


REAR AXLE ASSEMBLY

- | | |
|-----------------------------------|--|
| 1. Drive shaft nut | 32. Pinion bushing |
| 2. Drive shaft nut washer | 33. Bearing cup |
| 3. Drive shaft key | 34. Bearing cone |
| 4. Adjusting cap bolt nut | 35. Drive shaft thrust spacer |
| 5. Adjusting cap lockwashers | 36. Drive shaft nut cotter |
| 6. Brake backing plate | 37. Bearing adjusting cap |
| 7. Adjusting cap bolt | 38. Bearing adjusting cap oil seal |
| 8. Wheel bearing cup | 39. Bearing adjusting cap shims |
| 9. Wheel bearing cone | 40. Bearing grease hole plug |
| 10. Axle housing | 41. Drive shaft oil seal assembly |
| 11. Spring mounting pad | 42. Drive shaft |
| 12. Carrier gasket | 43. Axle housing stabilizer bracket |
| 13. Carrier stud lockwasher | 44. Axle housing vent assembly |
| 14. Carrier to housing stud nut | 45. Differential pinion thrust washer |
| 15. Carrier stud | 46. Drive shaft thrust button |
| 16. Carrier to cap assembly | 47. Differential gear |
| 17. Differential case bottom half | 48. Differential gear thrust washer |
| 18. Drive pinion | 49. Drive gear bolt |
| 19. Rear pinion bearing cup | 50. Drive gear bolt lockwasher |
| 20. Pinion bearing spacer | 51. Drive gear |
| 21. Front pinion bearing cup | 52. Pinion shaft |
| 22. Pinion oil seal | 53. Case screw lockwasher |
| 23. Axle companion flange | 54. Case screw |
| 24. Axle companion flange nut | 55. Case upper half |
| 25. Axle companion flange washer | 56. Housing cover |
| 26. Drive pinion oil washer | 57. Housing cover drain plug |
| 27. Front pinion bearing cone | 58. Differential bearing adjusting cap |
| 28. Rear pinion bearing cone | 59. Bearing adjusting nut cotter |
| 29. Rear pinion bearing shim | 60. Bearing adjusting nut lock |
| 30. Pinion shaft locating screw | 61. Bearing adjusting nut |
| 31. Pinion assembly | 62. Bearing adjusting cap screw |

OPERATION	DESCRIPTION	TIME	PRICE
REAR AXLE—Continued			
2-11	DIFFERENTIAL CARRIER HOUSING — Remove and Install. — When removed from car. — Includes removing all parts and installing in a new housing. — All Models	1.0	_____
2-12	DIFFERENTIAL ASSEMBLY OVERHAUL — When removed from car. — Includes replacing any case, gears, pinions, pinion shaft, thrust washers or spacer block. — All Models	.5	_____
2-13	DIFFERENTIAL CARRIER COMPANION FLANGE — Remove and Install. All Models	.6	_____
2-14	AXLE SHAFT — Remove and Install —(one). — Includes replacing shaft and repacking bearing. — All Models	1.1	_____
2-15	AXLE SHAFT — Adjust end play. All Models — one side both sides	.6 1.1	_____ _____
2-16	AXLE SHAFT THRUST BUTTON — Remove and Install (one). — With shaft removed. — All Models	.4	_____
2-17	AXLE SHAFT (INNER) OIL SEAL — Remove and Install. — Includes repacking bearing. All Models — one side both sides	1.2 2.0	_____ _____
2-18	AXLE SHAFT (OUTER) OIL SEAL — Remove and Install. Includes cleaning brakes and drums. All Models — one side both sides	.7 1.3	_____ _____
2-19	WHEEL BEARINGS — Remove and Install. — Includes cleaning and repacking bearings. All Models — one side both sides	1.0 1.7	_____ _____
WHEELS AND TIRES			
3-1	WHEELS AND TIRES — Remove and Install — (Five) . — Rotate to conserve tire life. — All Models	.6	_____
3-2	TIRE — Remove and Install. All Models — (One) (Two)	.4 .7	_____ _____
3-3	WHEELS AND TIRES — Remove and Install (Five) . — Rotate and balance two front Wheel Assemblies. — All Models	1.4	_____
3-4	ALIGN FRONT WHEELS. — Includes caster, camber, toe-in and setting steering gear on high point. — All Models	1.6	_____
3-5	FRONT WHEEL BEARINGS — Adjust Both. — All Models	.4	_____
3-6	FRONT WHEEL BEARINGS — Remove and Install. Includes cleaning, repacking and adjusting. All Models — one wheel both wheels	.6 1.0	_____ _____

OPERATION	DESCRIPTION	TIME	PRICE
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3-8	WHEELS — BALANCE. — Includes remove and Install and Balance statically and dynamically. — All Models — both front wheels	.9	
3-9	HUB AND BRAKE DRUM (FRONT) — Remove and Install. — Includes clean and repack and adjust bearings. All Models — one wheel both wheels	.6 1.0	
3-10	HUB AND BRAKE DRUM (REAR) — Remove and Install. All Models — one wheel both wheels	.4 .7	
3-11	HUB KEY (REAR) — Remove and Install. All Models — one two	.4 .7	
3-12	FRONT WHEEL GREASE RETAINER — Remove and Install. All Models — add	.2	
BRAKES			
4-1	BRAKES — INSPECTION. — Includes remove and Install Wheels and inspect condition of lining and any other parts. — Note if a reline or adjustment is ordered cancel this operation charge. All Models — one wheel four wheels	.3 .9	
4-2	BRAKES—MINOR ADJUSTMENT — Adjust shoes and brake cables, check anchor pin nuts for tightness, adjust brake pedal and check fluid level in master cylinder. — All Models	1.0	
4-3	BRAKES—MAJOR ADJUSTMENT —Includes remove drums, check lining, clean shoes and backing plate, grease and adjust cables, adjust anchor pins, brake pedal and refill master cylinder. — All Models	2.0	
4-4	BLEED BRAKE LINES. — All Models	.7	
4-5	FLUSH BRAKE SYSTEM. — Includes flush with alcohol and refill system with brake fluid and bleed lines. — All Models	.9	
4-6	BRAKES — RELINE AND ADJUST. — Includes removing drums, cleaning backing plates, lubriplate shoe contact points, install new shoes and lining, repack and adjust front wheel bearings and refill master cylinder. Time allowance includes .9 for relining shoes. All Models — (four wheels) If necessary to bleed lines add	3.7 .7	



HYDRAULIC BRAKE ARRANGEMENT

- | | |
|--|---|
| 1. Brake pedal pull rod clevis | 27. Rear axle brake tee |
| 2. Brake pull rod slide link | 28. Rear axle tee to right rear wheel tube |
| 3. Brake pull rod slide link retainer pin | 29. Brake shoe to anchor pin spring - rear |
| 4. Play link assembly | 30. Brake shoe hold down spring and retainer |
| 5. Hand brake cable lever | 31. Rear brake hose assembly |
| 6. Rear brake cable | 32. Rear brake cable support bracket |
| 7. Brake pedal rod assembly | 33. Brake tube connector |
| 8. Brake pedal lever assembly | 34. Hand brake cable lever return spring |
| 9. Hand brake cable assembly | 35. Hand brake cable lever toggle assembly |
| 10. Brake pedal to master cylinder clevis | 36. Cable lever pivot plate slide brace |
| 11. Brake pedal lever shaft | 37. Cable lever pivot plate and brace assembly |
| 12. Brake pedal to master cylinder push rod | 38. Frame tee to right front hose tube assembly |
| 13. Master cylinder attaching bolts | 39. Brake shoe to anchor pin spring - front |
| 14. Master cylinder assembly | 40. Brake cable lever strut |
| 15. Master cylinder outlet fitting | 41. Brake adjusting screw |
| 16. Master cylinder stop light switch | 42. Brake adjusting screw spring |
| 17. Pedal pull rod to guide hanger return spring | 43. Hand brake mounting bracket assembly |
| 18. Brake control lever to guide return spring | 44. Hand brake lever grip |
| 19. Front brake hose assembly | 45. Hand brake ratchet rod housing |
| 20. Front brake hose to frame assembly | 46. Hand brake ratchet rod |
| 21. Frame tee to left front hose tube assembly | 47. Hand brake inner ratchet rod stabilizer |
| 22. Front frame tee | 48. Hand brake ratchet rod stabilizer spring |
| 23. Master cylinder to frame connector tube | 49. Hand brake outer ratchet rod stabilizer |
| 24. Hand brake cable lever guide plate assembly | 50. Brake pedal lever pull rod |
| 25. Rear brake cable clevis | 51. Hand brake cable clevis |
| 26. Rear axle tee to left rear wheel tube | 52. Pedal link clevis. |

OPERATION	DESCRIPTION	TIME	PRICE
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BRAKES—Continued

4-34 BRAKE PEDAL LEVER, SHAFT AND HOUSING ASSEMBLY — Remove and Install.

All Models

1.0

To rebush add to operation 4-34

.3

HANDBRAKE

4-35 HAND BRAKE CABLE LEVER TOGGLE — Remove and Install.

All Models

.6

4-36 HAND BRAKE CABLE — Adjust. — All Models

.3

4-37 HAND BRAKE LEVER — Remove and Install. — All Models

.4

4-38 HAND BRAKE RATCHET STABILIZER SPRINGS — Remove and Install.

All Models

.3

4-39 HAND BRAKE RATCHET ASSEMBLY — Remove, free-up and Install.

All Models

.5

4-40 HAND BRAKE COMPLETE ASSEMBLY — Remove and Install.

All Models

1.0

CLUTCH

5-1 DRAIN AND REFILL. — All Standard Models

.3

With Drive-Master

.4

5-2 DRAIN, FLUSH AND REFILL. — All Standard Models

.5

With Drive-Master

.6

5-3 CLUTCH ASSEMBLY — Remove and Install. — Includes replacing cover gasket or driving plate.

All Models — Standard Transmission

5.0

With Drive-Master

5.2

With Supermatic

5.4

5-4 CLUTCH PILOT BEARING — Remove and Install. — Add to operation 5-3. — All Models

.3

5-5 CLUTCH ASSEMBLY — OVERHAUL. — Includes remove and Install transmission, clutch and replacing pressure plate, fingers engaging springs, clutch cover and necessary adjustments.

All Models — Standard Transmission

5.6

With Drive-Master

6.2

With Supermatic

6.4

5-6 CLUTCH ASSEMBLY — OVERHAUL, WHEN REMOVED FROM CAR.

All Models

.6

5-7 CLUTCH PEDAL — ADJUST. — All Models

.3

5-8 CLUTCH HOUSING — Remove and Install. — Includes remove and install transmission.

All Models — Standard Transmission

4.6

With Drive-Master

4.8

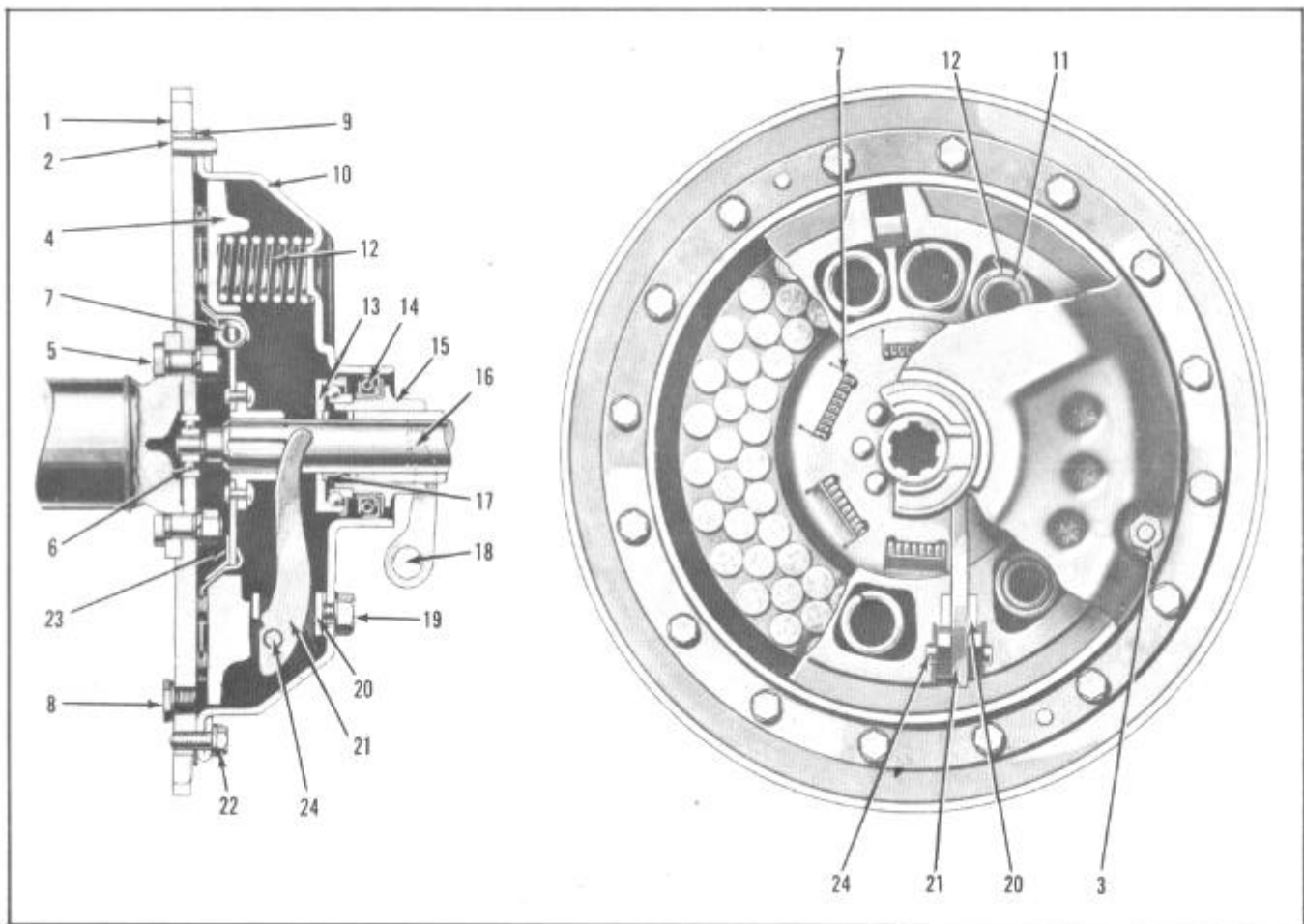
With Over-Drive

5.0

With Supermatic

5.2

OPERATION	DESCRIPTION	TIME	PRICE
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10" CLUTCH ASSEMBLY

- | | |
|-----------------------------------|--------------------------------------|
| 1. Flywheel | 13. Clutch throwout bearing |
| 2. Flywheel dowel pin | 14. Throwout bearing oil seal |
| 3. Clutch cover driving lug | 15. Clutch collar |
| 4. Clutch driven disc | 16. Main drive shaft |
| 5. Flywheel bolt | 17. Throwout bearing grease retainer |
| 6. Clutch pilot bearing | 18. Clutch shifter yoke |
| 7. Clutch driven disc spring | 19. Throwout finger retainer nut |
| 8. Clutch filler plug | 20. Throwout finger retainer |
| 9. Clutch cover gasket | 21. Throwout finger |
| 10. Clutch cover | 22. Clutch cover bolt |
| 11. Clutch engaging spring, inner | 23. Clutch driven disc |
| 12. Clutch engaging spring, outer | 24. Throwout finger pin |

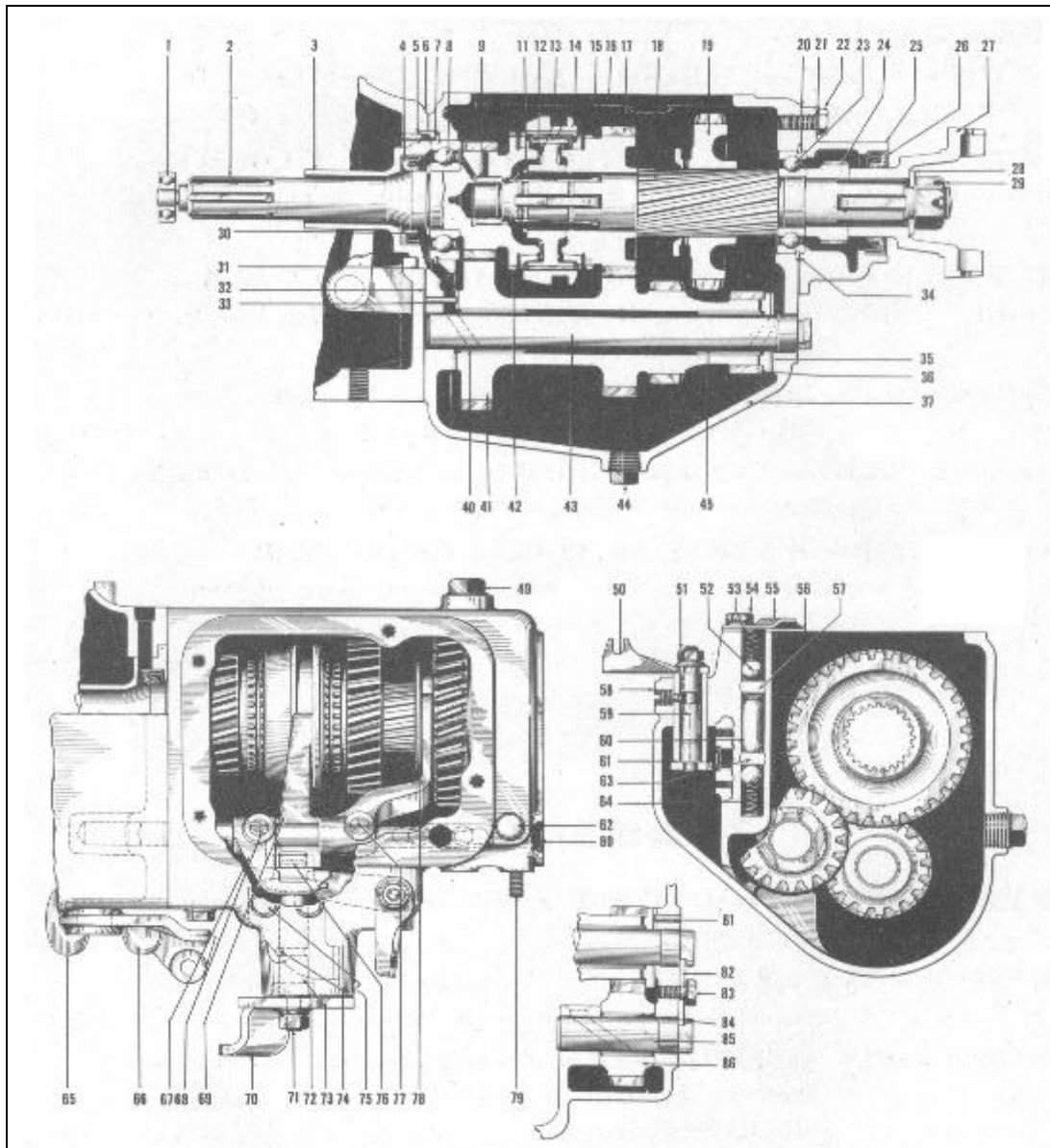
OPERATION	DESCRIPTION	TIME	PRICE
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CLUTCH—Continued

5-9	CLUTCH HOUSING — REBUSH — HOUSING REMOVED. — If necessary, add to operation 5-8. — All Models	.5	_____
5-10	CLUTCH SHIFTER YOKE, SHIFTER SHAFT AND/OR COUPLING — Remove and Install and Rebush — Housing Removed. All Models	.7	_____
5-11	CLUTCH CROSSHAFT AND COUPLING LEVER, FELT SEAL, RETAINER OR RUBBER BUSHING — Remove and Install. All Models	.5	_____
5-12	CLUTCH PEDAL LEVER SHAFT — Remove and Install. All Models	1.0	_____
5-13	CLUTCH PEDAL LEVER SHAFT HOUSING ASSEMBLY — Rebush — Includes Remove and Install. — All Models	1.3	_____
5-14	CLUTCH THROWOUT BEARING, COLLAR OR OIL SEAL — Remove and Install. — Includes remove and install transmission. All Models — Standard Transmission	4.4	_____
	With Drive-Master	4.6	_____
	With Overdrive	4.8	_____
	With Super-Matic	5.0	_____

TRANSMISSION

6-1	TRANSMISSION OPENING FLOOR COVER — Remove and Install. All Models	1.1	_____
6-2	TRANSMISSION CASE COVER AND/OR GASKET — Remove and Install. Standard Transmission — All Models	1.3	_____
6-3	TRANSMISSION ASSEMBLY — Remove and Install. — All Models. Standard Transmission	4.3	_____
	With Drive-Master	4.6	_____
	With Overdrive	4.8	_____
	With Super-Matic	5.0	_____
6.4	TRANSMISSION ASSEMBLY — Overhaul or Replace Case. — Includes Remove and Install, Disassembly — Replace Necessary Parts — Reassembling. — All Models. Standard Transmission	6.8	_____
	With Drive-Master	7.1	_____
	With Overdrive	7.8	_____
	With Super-Matic	8.0	_____
6.5	TRANSMISSION OVERHAUL — When Removed from Car. — Includes Disassembly — Replace Necessary Parts and Reassemble. — All Models. Standard Transmission	2.5	_____
	With Overdrive	3.3	_____



- | | | | |
|--------------------------|-------------------------|----------------------------|---------------------------|
| 1. Pilot Bearing | 22. Gear Housing Bolts | 44. Drain Plug | 67. L & R Shifter |
| 2. Main Drive Gear | 23. Shaft Rear Bearing | 45. C. S. Bushing Rear | 68. L & R Set Screw |
| 3. Bearing Retainer | 24. Speed. Gear | 49. Filler Plug | 69. H & I Shift Fork |
| 4. Oil Seal | 25. Gear Housing | 50. Sel. Lever Outer | 70. Shift Lever Outer |
| 5. Locating Pin | 26. Gear Housing Seal | 51. Sel. Shaft Nut | 71. Shift Shaft Nut |
| 6. Clutch Housing | 27. Comp. Flange | 52. Rail Lock Ball | 72. Shift Shaft Seal |
| 7. Washer Pin | 28. Flange Washer | 53. Lock Spring-L&R | 73. Shift Shaft |
| 8. Drive Gear Bearing | 29. Flange Nut | 54. Cover Screw | 74. Shift Shaft Pin |
| 9. Shaft Bearing Rollers | 30. Gear Lock Ring | 55. Trans. Cover | 75. Shifter Bracket Screw |
| 11. Hub Lock Ring | 31. Retainer Gasket | 56. Cover Gasket | 76. Shift Lever Inner |
| 12. Synch. Sleeve Hub | 32. Case Gasket | 57. L&R Rail | 77. L & R Set Screw |
| 13. Synch. Spring | 33. C. S. Washer Pin | 58. Bushing Set Screw | 78. L & R Fork |
| 14. Synch. Shift Plate | 34. M. S. Snap Ring | 59. Shift Sel. Lever | 79. Case Stud |
| 15. Synch. Shift Sleeve | 35. Thrust Washer | 60. Rail Interlock | 80. Expansion Plug |
| 16. Synch. Ring | 36. Steel Washer | 61. Sel. Shaft Bushing | 81. Washer Pin Rear |
| 17. Shaft Inter. Gear | 37. Trans. Case | 62. Breather | 82. C. S. Lock Plate |
| 18. Main Shaft | 40. C. S. Bushing Front | 63. H & I. Shift Rail | 83. Lock Plate Screw |
| 19. I. & R Gear | 41. C. S. Gear Cluster | 64. H & I. Ball Spring | 84. Idler Gear Bushing |
| 20. Gear Housing Gasket | 42. Main Drive Gear | 65. Throwout Lever | 85. Idler Gear Shaft |
| 21. Gear Housing Washer | 43. Countershaft | 66. H & I. Rail Stop Screw | 86. Reverse Idler Gear |

OPERATION	DESCRIPTION	TIME	PRICE
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TRANSMISSION—Continued

6-6	TRANSMISSION COMPANION FLANGE — Remove and Install. — Transmission in Car. — All Models	.8	_____
6-7	TRANSMISSION SPEEDOMETER HOUSING — Remove and Install. All Models	1.0	_____
6-8	MAINSHAFT — Remove and Install. — Includes any Gear On Shaft. — Includes Synchronizer Assembly or Rear Bearing. — All Models.		
	Standard Transmission	6.3	_____
	With Drive-Master	6.5	_____
	With Overdrive	6.7	_____
	With Super-Matic	6.9	_____
6-9	MAINSHAFT OIL SEAL — Remove and Install. All Models — Transmission in Car	1.1	_____
	Transmission Removed	.4	_____
6-10	MAINSHAFT REAR BEARING — Remove and Install. All Models Transmission in Car.		
	Standard Transmission	1.2	_____
	With Overdrive	1.5	_____
6-11	MAIN DRIVE GEAR — Remove and Install. — Includes Remove and Install Transmission and Replace any Parts Including Main Drive Gear Bearing. — All Models.		
	Standard Transmission	6.6	_____
	With Drive-Master	6.9	_____
	With Overdrive	7.1	_____
	With Super-Matic	7.3	_____
6-12	TRANSMISSION MAIN DRIVE GEAR STOP RING — Remove and Install. — Add to operation 6-11. — All Models	.5	_____
6-13	TRANSMISSION MAIN DRIVE GEAR BEARING, RETAINER AND OIL SEAL — Remove and Install. — Includes Remove and Install Transmission. — All Models.		
	Standard Transmission	4.8	_____
	With Drive-Master	5.1	_____
	With Overdrive	5.3	_____
	With Super-Matic	5.5	_____

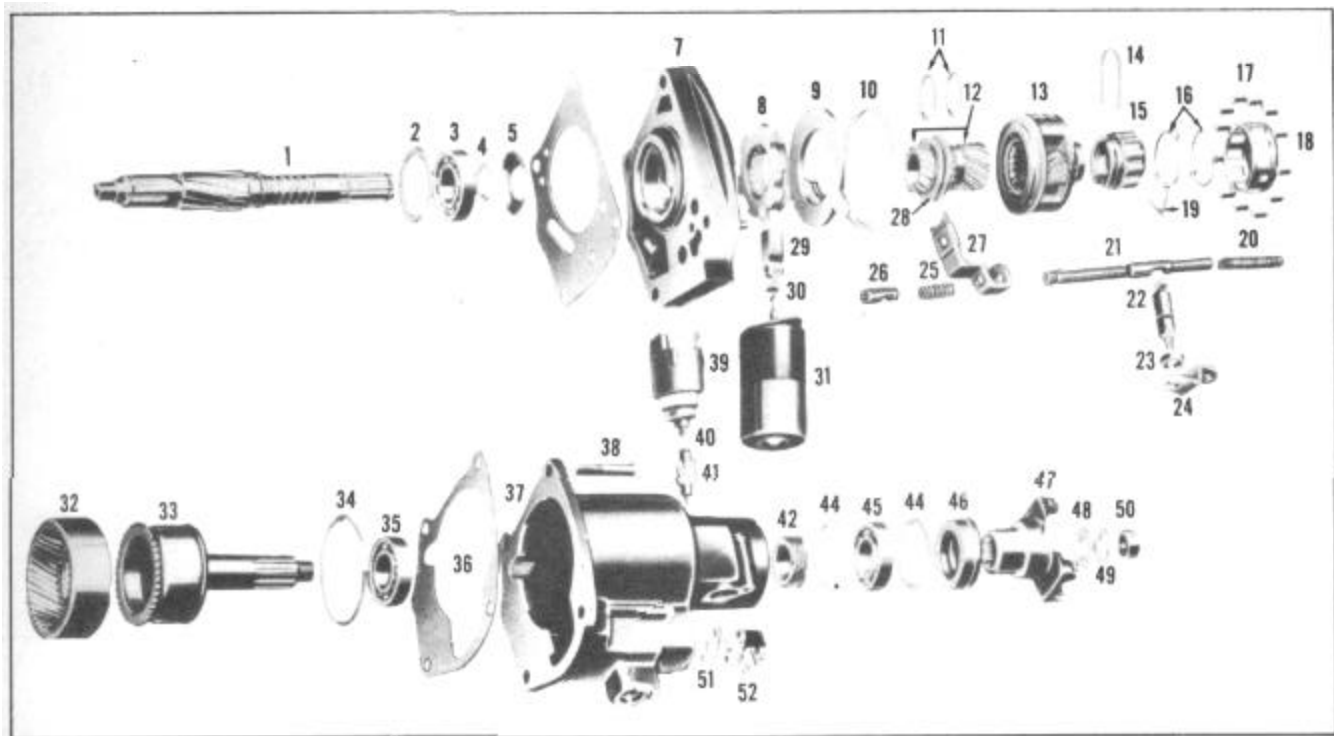
COUNTERSHAFT AND SHIFT RAILS

6-14	COUNTERSHAFT GEAR CLUSTER AND/OR COUNTERSHAFT — Remove and Install. — Includes Remove and Install Transmission — Replace Countershaft and/or Thrust Washers. — All Models.		
	Standard Transmission	6.8	_____
	With Drive-Master	7.1	_____
	With Overdrive	7.3	_____
	With Super-Matic	7.5	_____

OPERATION	DESCRIPTION	TIME	PRICE
TRANSMISSION—Continued			
6-15	COUNTERSHAFT BUSHINGS - Remove and Install. - Includes Line Ream and Remove and Install Transmission.		
	All Models - Standard Transmission	6.8	_____
	With Drive-Master	7.1	_____
	With Overdrive	7.3	_____
	With Super-Matic	7.5	_____
6-16	REVERSE IDLER GEAR, SHAFT OR BUSHINGS - Remove and Install. - Includes Remove and Install Transmission.		
	All Models - Standard Transmission	6.8	_____
	With Drive-Master	7.1	_____
	With Overdrive	7.3	_____
	With Super-Matic	7.5	_____
6-17	LOW AND REVERSE SHIFT RAIL AND/OR FORK - Remove and Install. - Unnecessary to Remove Transmission.		
	All Models - Stanadard Transmission	2.9	_____
	With Drive-Master	3.1	_____
	With Overdrive - Includes Remove and Install Transmission and Overdrive	6.3	_____
6-18	TRANSMISSION INTERLOCK PLUNGER - Remove and Install.		
	Includes Remove and Install floor boards.		
	All Models - Standard Transmission	3.0	_____
6-19	HIGH AND SECOND SHIFT RAIL AND FORK OR LOCK BALL AND SPRING - Remove and Install. - Includes Remove and Install Transmission.		
	All Models - Standard Transmission	4.7	_____
	With Drive-Master	5.0	_____
	With Overdrive	5.2	_____
	With Super-Matic	5.4	_____
6-20	TRANSMISSION SHIFT LEVER INNER OR OUTER OR SHIFT SHAFT - Remove and Install. - Unnecessary to remove Transmission.		
	All Models - Standard Transmission	3.3	_____
	With Drive-Master	3.5	_____
	With Overdrive	3.7	_____
	With Super-Matic	3.6	_____
6-21	TRANSMISSION SHIFT SELECTOR LEVER (OUTER AND INNER) AND BUSHING AND SET SCREW - Remove and Install.		
	All Models - Standard Transmission	4.8	_____
	With Drive-Master	5.1	_____
	With Overdrive	5.3	_____
	With Super-Matic	5.5	_____
REMOTE CONTROL			
6-22	REMOTE CONTROL HAND SHIFT LEVER AND TUBE AND STEERING JACKET TUBE - Remove and Install.		
	All Models - without direction indicator	2.2	_____
	with direction indicator add	.4	_____
6-23	REMOTE CONTROL, HAND SHIFT LEVER TUBE AND ROD ASSEMBLY - Remove and Install.		
	All Models - without direction indicator	1.7	_____
	with direction indicator add	.4	_____
6-24	REMOTE CONTROL, HAND SHIFT LEVER - Remove and Install.		
	All Models	.4	_____
6-25	REMOTE CONTROL, HAND SHIFT LEVER AND FULCUM BRACKET - Remove and Install.		
	All Models - without direction indicator	1.9	_____
	with direction indicator add	.4	_____

OPERATION	DESCRIPTION	TIME	PRICE
TRANSMISSION — Continued			
6-26	REMOTE CONTROL TUBE (UPPER) BRACKET — Remove and Install. All Models — without direction indicator with direction indicator add	.7 .4	
6-27	REMOTE CONTROL TUBE LOWER BRACKET. — Remove and Install. All Models	2.3	
6-28	REMOTE CONTROL PUSH ROD — Remove and Install. All Models	1.4	
6-29	REMOTE CONTROL CABLE, CASING AND BRACKET ASSEMBLY — Remove and Install. — All Models with drive master	.8 .9	
6-30	REMOTE CONTROL BELL CRANK AND BUSHING ASSEMBLY - Remove and Install. — All Models	.6	
6-31	REMOTE CONTROL BELL CRANK TO TRANSMISSION ROD AND GROMMET — Remove and Install. — All Models	.2	
OVERDRIVE			
7-1	TRANSMISSION AND OVERDRIVE ASSEMBLY — Remove and Install. All Models with drive-master add	5.1 .3	
7-2	TRANSMISSION AND OVERDRIVE—OVERHAUL (BOTH UNITS) . Includes removing and replacing any necessary parts in both units. All Models with drive-master add	7.8 .3	
7-3	OVERDRIVE HOUSING AND/OR REAR BEARING — Remove and Install. — Includes removing and installing solenoid, governor switch and shift rail switch on new housing. — All Models	1.4	
7-4	OVERDRIVE ASSEMBLY — OVERHAUL. — Includes disassembly and replacement of any parts — except the overdrive adaptor, bearing and transmission mainshaft. — All Models — Overdrive in Car	2.9	
7-5	OVERDRIVE ASSEMBLY — Remove and Install. — Includes remove and install transmission, removing overdrive from transmission and installing a new overdrive. -- All Models with drive-master add	7.2 .3	
7-6	OVERDRIVE WIRING HARNESS — Remove and Install. All Models with drive-master	1.0 1.6	
7-7	OVERDRIVE REAR OIL SEAL — Remove and Install. All Models — Overdrive in car	.9	
7-8	MAINSHAFT SPEEDOMETER DRIVE GEAR — Remove and Install. All Models — Overdrive in car	2.1	
7-9	SHIFT RAIL AND/OR FORK — Remove and Install. All Models — Overdrive in car Overdrive removed	2.7 .7	

OPERATION	DESCRIPTION	TIME	PRICE
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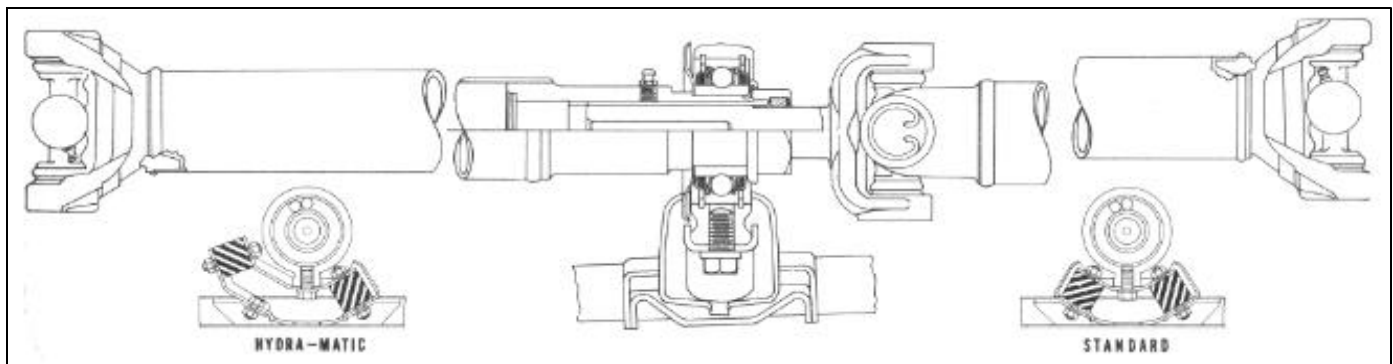


OVERDRIVE ASSEMBLY

- | | | | |
|-----|---------------------------------------|-----|-------------------------------------|
| 1. | Transmission mainshaft | 27. | Shift fork |
| 2. | Transmission mainshaft snap ring | 28. | Stationary gear collar |
| 3. | Transmission mainshaft bearing | 29. | Stationary gear pawl |
| 4. | Transmission snap ring | 30. | Stationary gear pawl oil seal |
| 5. | Bearing oil baffle | 31. | Solenoid assembly |
| 6. | Overdrive to transmission case gasket | 32. | Overdrive mainshaft ring gear |
| 7. | Overdrive housing adapter | 33. | Overdrive mainshaft |
| 8. | Stationary gear plate & balk ring | 34. | Snap ring |
| 9. | Stationary gear plate cover | 35. | Overdrive mainshaft bearing - front |
| 10. | Cover plate snap ring | 36. | Overdrive housing gasket |
| 11. | Stationary gear snap ring | 37. | Overdrive housing |
| 12. | Stationary cage assembly | 38. | Overdrive housing to adapter bolt |
| 13. | Pinion cage assembly | 39. | Governor switch |
| 14. | Pinion cage retainer clip | 40. | Lock ring |
| 15. | Cam assembly | 41. | Governor pinion |
| 16. | Cam roller retainer spring | 42. | Speedometer drive gear |
| 17. | Cam roller | 44. | Shaft bearing snap ring |
| 18. | Cam roller retainer | 45. | Overdrive mainshaft bearing - rear |
| 19. | Cam retainer clip | 46. | Overdrive mainshaft oil seal |
| 20. | Shift rail retractor spring | 47. | Companion flange |
| 21. | Shift rail | 48. | Mainshaft plain washer |
| 22. | Control shaft | 49. | Mainshaft lockwasher |
| 23. | Control shaft oil seal | 50. | Mainshaft nut |
| 24. | Control lever | 51. | Control switch gasket |
| 25. | Shift rail sleeve spring | 52. | Control switch |
| 26. | Shift rail sleeve | | |

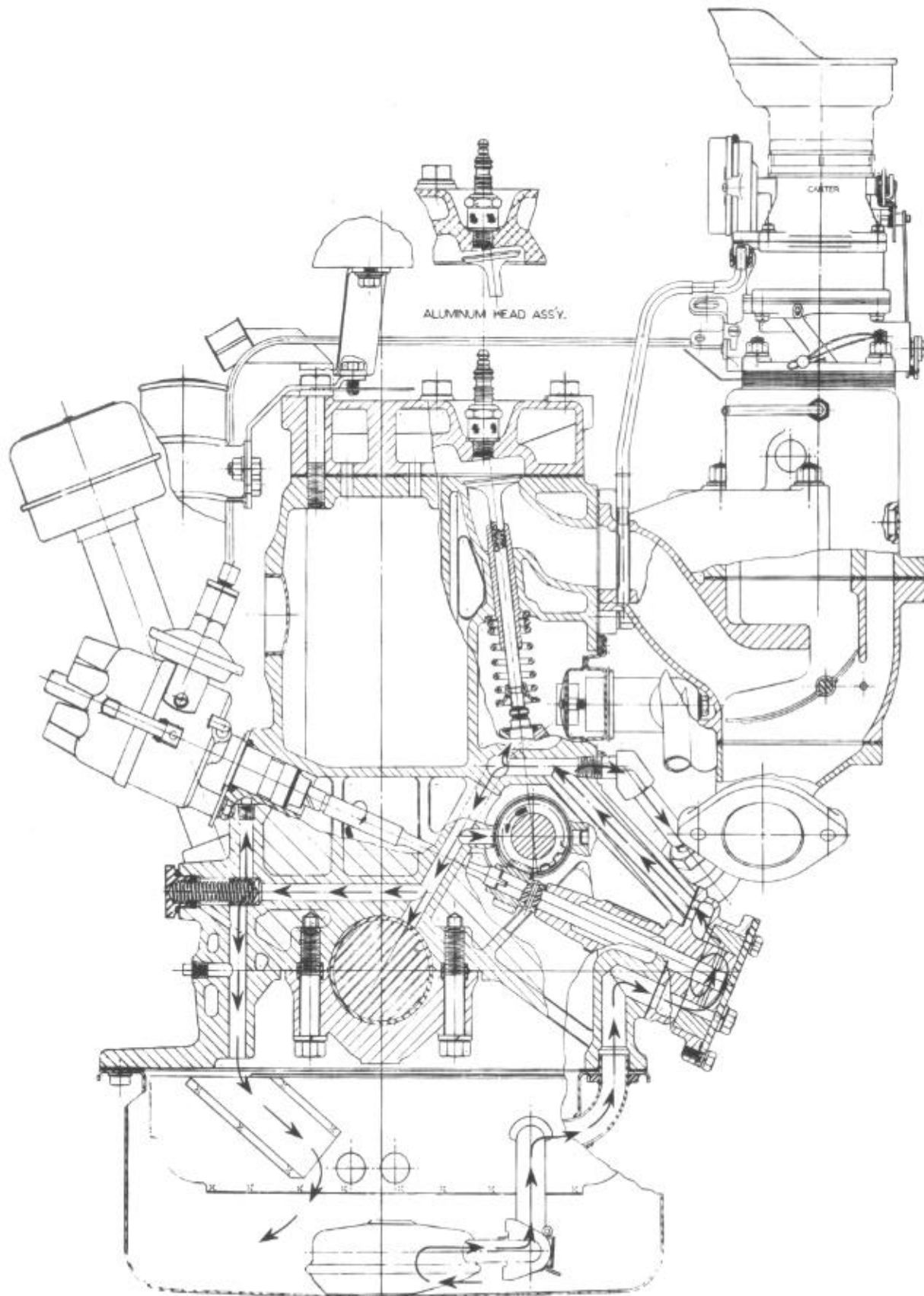
OPERATION	DESCRIPTION	TIME	PRICE
OVERDRIVE—Continued			
7-10	SOLENOID — Remove and Install. — All Models	.4	_____
7-11	SOLENOID STATIONARY GEAR PAWL — Remove and Install. All Models — Overdrive in car	2.9	_____
	Overdrive removed	.7	_____
7-12	GOVERNOR SWITCH — Remove and Install. — All Models	.4	_____
7-13	THROTTLE SWITCH — Remove and Install. All Models — Includes Adjustment	.3	_____
7-14	SOLENOID WIRING HARNESS ASSEMBLY — Remove and Install. All Models	.6	_____
7-15	CONTROL CABLE — Remove and Install and Adjust. — All Models	.6	_____
7-16	SPEEDOMETER PINION OR SLEEVE — Remove and Install. All Models	.5	_____
7-17	ADAPTOR TO TRANSMISSION GASKET — Remove and Install. Includes removing and installing transmission and Overdrive. All Models	6.2	_____
	With Drive-Master Add	.3	_____
7-18	ADAPTOR TO OVERDRIVE HOUSING GASKET — Remove and Install. All Models	2.5	_____
7-19	TRANSMISSION MAINSHAFT AND/OR MAINSHAFT REAR BEARING — Remove and Install. — All Models With Drive-Master Add	7.0	_____
		.3	_____
7-20	OVERDRIVE RELAY — Remove and Install. — All Models	.4	_____
7-21	SHIFT RAIL SWITCH --- Remove and Install. — All Models	.3	_____
7-22	OVERDRIVE HOUSING ADAPTOR — Remove and Install. — Includes remove and install transmission and overdrive assembly. All Models	6.3	_____
	With Drive-Master Add	.3	_____
7-23	STATIONARY GEAR AND/OR BALK RING — Remove and Install. All Models — Overdrive in car	2.9	_____
	Overdrive removed	.7	_____
7-24	OVERDRIVE CONTROL SHAFT — Remove and Install. All Models — Overdrive in car	2.3	_____
7-25	INTERLOCK PLUNGER — Remove and Install. — Includes remove and install the overdrive unit. All Models	5.6	_____
	With Drive-Master Add	.2	_____
7-26	OVERDRIVE WIRING HARNESS CHECK. — All Models	.5	_____

OPERATION	DESCRIPTION	TIME	PRICE
PROPELLER SHAFT			
8-1	PROPELLER SHAFT ASSEMBLY (FRONT) — Remove and Install. All Models	1.3	_____
8-2	PROPELLER SHAFT ASSEMBLY (REAR) — Remove and Install All Models	1.3	_____
8-3	PROPELLER SHAFTS AND THREE UNIVERSAL JOINTS ASSEMBLY — Remove and Install. All Models	1.7	_____
8-4	PROPELLER SHAFT FRONT, INTERMEDIATE OR REAR UNIVERSAL JOINT — Remove and Install. All Models	1.0	_____
8-5	UNIVERSAL JOINTS (THREE) OVERHAUL — Includes remove and Install and replace necessary parts. All Models	2.4	_____
8-6	PROPELLER SHAFT REAR SLEEVE YOKE — Remove and Install. 480-490-500 Models	.8	_____
8-7	PROPELLER SHAFT "U" BOLTS FRONT OR REAR — Remove and Install. All Models	1.0	_____
8-8	PROPELLER SHAFT "U" BOLTS — TIGHTEN. — All Models	.5	_____
8-9	PROPELLER SHAFT TRANSMISSION OR DIFFERENTIAL CARRIER COMPANION FLANGE — Remove and Install. All Models	.6	_____
8-10	PROPELLER SHAFT COMPANION FLANGE (Rear end of Front Shaft) — Remove and Install. — 480-490-500 Models	.8	_____
8-11	PROPELLER SHAFT CENTER BEARING AND HOUSING ASSEMBLY — Remove and Install — All Models	1.1	_____

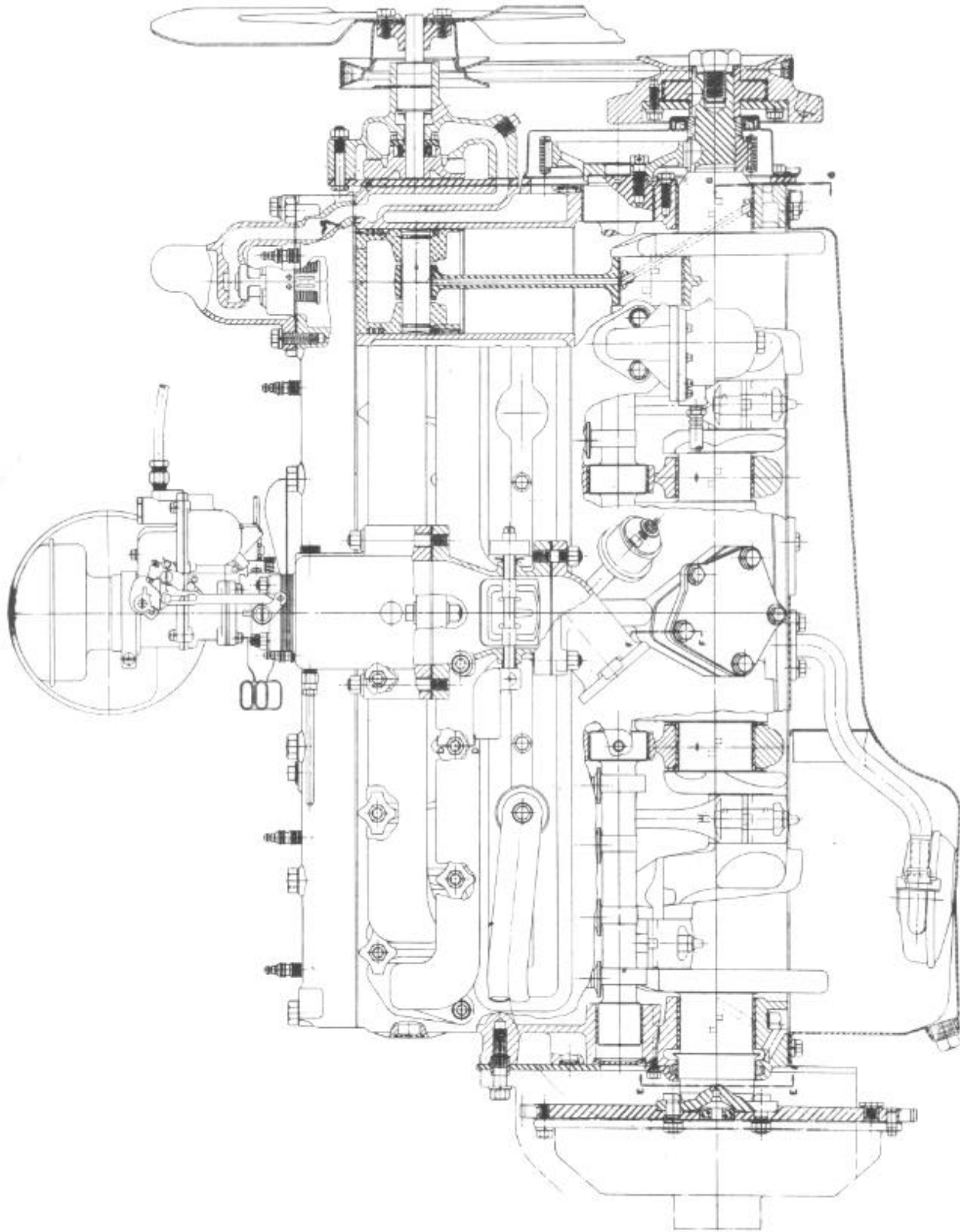


PROPELLER SHAFTS

OPERATION	DESCRIPTION	TIME	PRICE
PROPELLER SHAFT—Continued			
8-12	PROPELLER SHAFT CENTER BEARING — Remove and Install. All Models	1.2	_____
8-13	PROPELLER SHAFT CENTER BEARING SUPPORT CUSHIONS (TWO) — Remove and Install. — All Models	.4	_____
8-14	PROPELLER SHAFT CENTER BEARING SUPPORT — Remove and Install. 480-490 Models only	.5	_____
8-15	PROPELLER SHAFT CENTER BEARING SUPPORT REAR CUSHION — Remove and Install. — 480-490 Models only	.7	_____
8-16	PROPELLER SHAFT SLIDING SLEEVE — Remove and Install. "A" Models only	1.4	_____
ENGINE			
9-1	ENGINE AND TRANSMISSION ASSEMBLY — Remove and Install. All Models — 6 cyl. 8 cyl. With Drive-Master — Add With Overdrive — Add With Supermatic — Add	6.2 6.7 .8 .5 1.2	_____ _____ _____ _____ _____
9-2	ENGINE ASSEMBLY — Remove and Install. — Includes removing engine with transmission attached and remove and install — transmission, clutch, fuel and electrical equipment to new assembly and minor engine tune-up. All Models — 6 cyl. 8 cyl. With Drive-Master — Add With Overdrive — Add With Supermatic — Add	8.3 8.8 1.8 .5 2.2	_____ _____ _____ _____ _____
9.3	SKELETON ENGINE — Install includes removing old engine from car and remove and install all subassemblies from old block to new and minor engine tune-up. Does not include reconditioning fuel or electrical systems. All Models — 6 cyl. 8 cyl. With Drive-Master — Add With Overdrive — Add With Supermatic — Add	15.8 16.4 1.8 .5 2.2	_____ _____ _____ _____ _____
9-4	CYLINDER BLOCK AND PISTON ASSEMBLY — Install. — Includes remove and install subassemblies from old to new block and refacing old/or new valves and seats, aligning rods and install piston and rod assemblies, reinstall new engine assembly and minor tune-up. All Models — 6 cyl. 8 cyl. With Drive-Master — Add With Overdrive — Add With Supermatic — Add	21.2 23.2 1.8 .5 2.2	_____ _____ _____ _____ _____
9-5	ENGINE — PAINT. — Includes remove and install spark plugs and ignition wires. All Models Standard With Drive-Master	1.0 1.5	_____ _____

**6-CYLINDER OIL PRESSURE LUBRICATION DIAGRAM**

OPERATION	DESCRIPTION	TIME	PRICE
ENGINE—Continued			
9-6	ENGINE SUPPORT PLATE (FRONT) — Remove and Install. All Models — 6 cyl. 8 cyl.	3.6 3.4	
9-7	ENGINE SUPPORT PLATE (REAR) — Remove and Install.. All Models With Drive-Master With Overdrive With Supermatic	5.5 .8 .5 1.2	
9-8	ENGINE MOUNTINGS (FRONT) — Remove and Install both. All Models	1.0	
9-9	ENGINE MOUNTING (REAR) — Remove and Install. All Standard Models With Hydramatic (Two)	1.0 .6	
CAMSHAFT, CONNECTING ROD AND MAIN BEARINGS			
9-10	CAMSHAFT — Remove and Install. — Includes remove and install cylinder head, adjusting tappets and setting valve timing. All Models — 6 cyl. 8 cyl. With Drive-Master — Add	9.2 9.8 .8	
9-11	CAMSHAFT — EXPANSION PLUG AND /OR OIL GALLERY PLUG — Remove and Install. All Models With Drive-Master	5.6 .5	
9-12	CAMSHAFT BEARINGS — Remove and Install (using factory reamed bearings). Includes removal and installation of engine. All Models — 6 cyl. 8 cyl. With Drive-Master With Overdrive With Supermatic	11.9 12.3 .8 .5 1.2	
9-13	CAMSHAFT BEARINGS — Remove and Install and line ream. — Includes remove and install engine. All Models — 6 cyl. 8 cyl. With Drive-Master — Add With Overdrive — Add With Supermatic — Add To install when engine is disassembled. All Models — 6 cyl. 8 cyl	15.4 16.3 .8 .5 1.2 3.5 4.0	
9-14	CONNECTING RODS — REPLACEABLE BEARING SHELLS — Remove and Install all. — Includes removing and installing oil pan. All Models — 6 cyl. With Drive-Master — Add	3.7 .2	
9-15	CONNECTING RODS — REPLACEABLE BEARING SHELLS — Remove and Install all. — Engine removed from car. All Models — 6 cyl.	1.9	

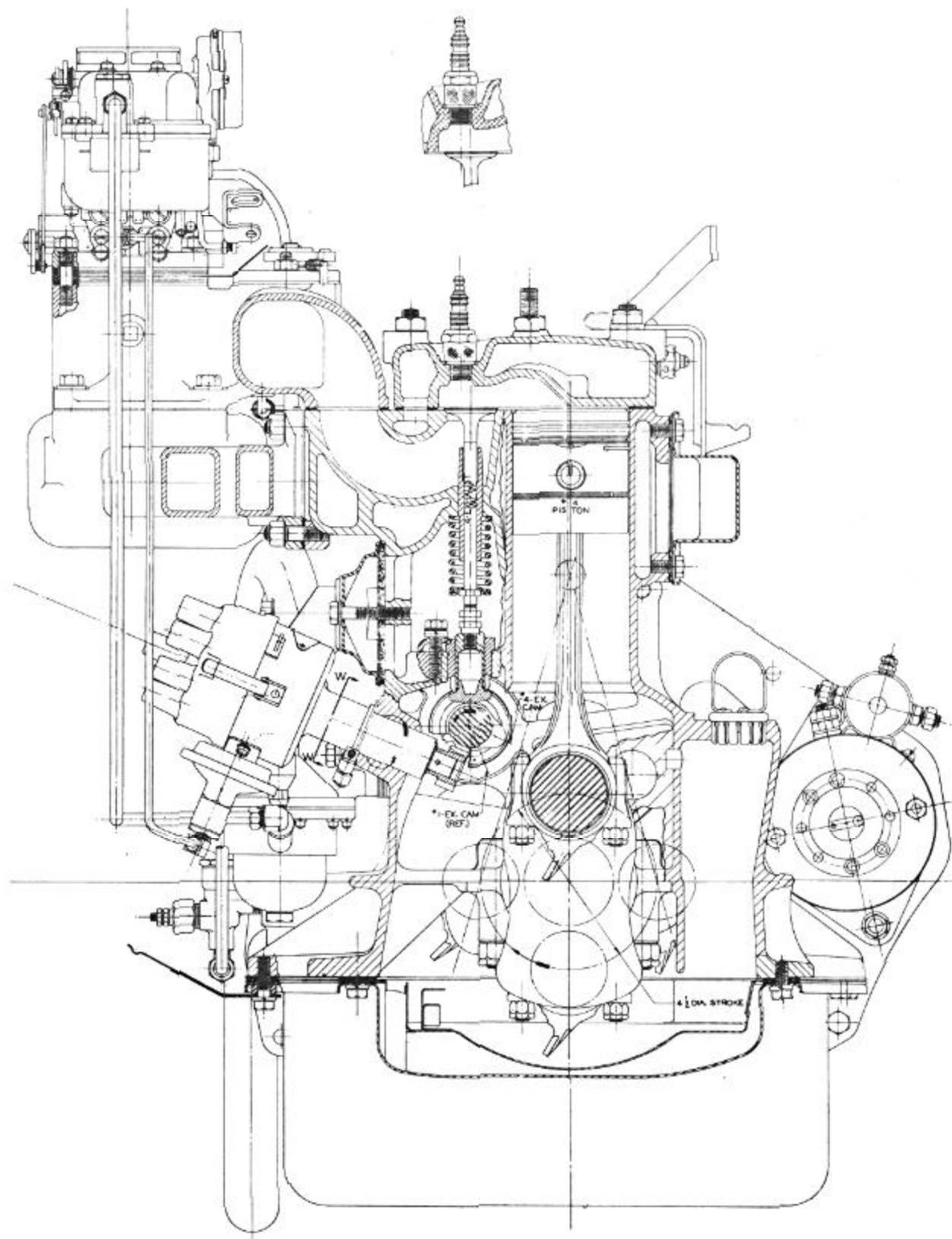


6-CYLINDER ENGINE LONGITUDINAL CROSS SECTION.

OPERATION	DESCRIPTION	TIME	PRICE
ENGINE—Continued			
9-16	MAIN BEARINGS — Remove and Install. — With engine in car. — Includes removing and installing oil pan. All Models — 6 cyl. With Drive-Master — Add	3.3 .2	 _____
9-17	MAIN BEARINGS — Remove and Install all. — Engine removed from car — Using factory reamed bearings. All Models — 6 cyl. 8 cyl.	2.6 2.8	 _____
9-18	MAIN BEARINGS — Remove and Install all. — Includes line ream — engine removed from car and crankshaft removed. All Models — 8 cyl.	3.9	_____
9-19	MAIN BEARING (CENTER) #3 THRUST, UPPER AND LOWER SHELLS — Replace with engine in car. — Includes remove and install oil pan. All Models — 6 cyl. 8 cyl. With Drive-Master — Add	2.2 3.5 .2	 _____ _____ _____
9-20	MAIN BEARING — OIL LEAK CORRECTION. — Includes remove and install oil pan and repacking cap. All Models — 6 cyl. — front Includes Crankshaft seal — rear Front and rear All Models — 8 cyl. front rear Front and rear With Drive-Master — Add	2.8 2.3 3.1 3.3 2.8 3.6 .2	 _____ _____ _____ _____ _____ _____ _____
FLYWHEEL, CRANKSHAFT AND TIMING GEARS			
9-21	CRANKSHAFT — Remove and Install. — Includes remove and install engine. All Models — 6 cyl. 8 cyl. With Drive-Master — Add With Overdrive — Add With Supermatic — Add	10.9 11.8 .8 .5 1.2	 _____ _____ _____ _____ _____
9-22	VIBRATION DAMPENER — Remove and Install. — Includes remove and install radiator. — All Models	1.2	_____
9-23	FLYWHEEL ASSEMBLY — Remove and Install — or tighten. All Models With Drive-Master With Overdrive With Supermatic	5.2 5.8 5.5 6.3	 _____ _____ _____ _____
9-24	FLYWHEEL RING GEAR — Remove and Install. — With flywheel on bench — if necessary add to operation 9-23 — All Models	.6	_____
9-25	TIMING COVER GASKET OR OIL SEAL AND SPACER — Remove and Install. All Models	2.3	_____

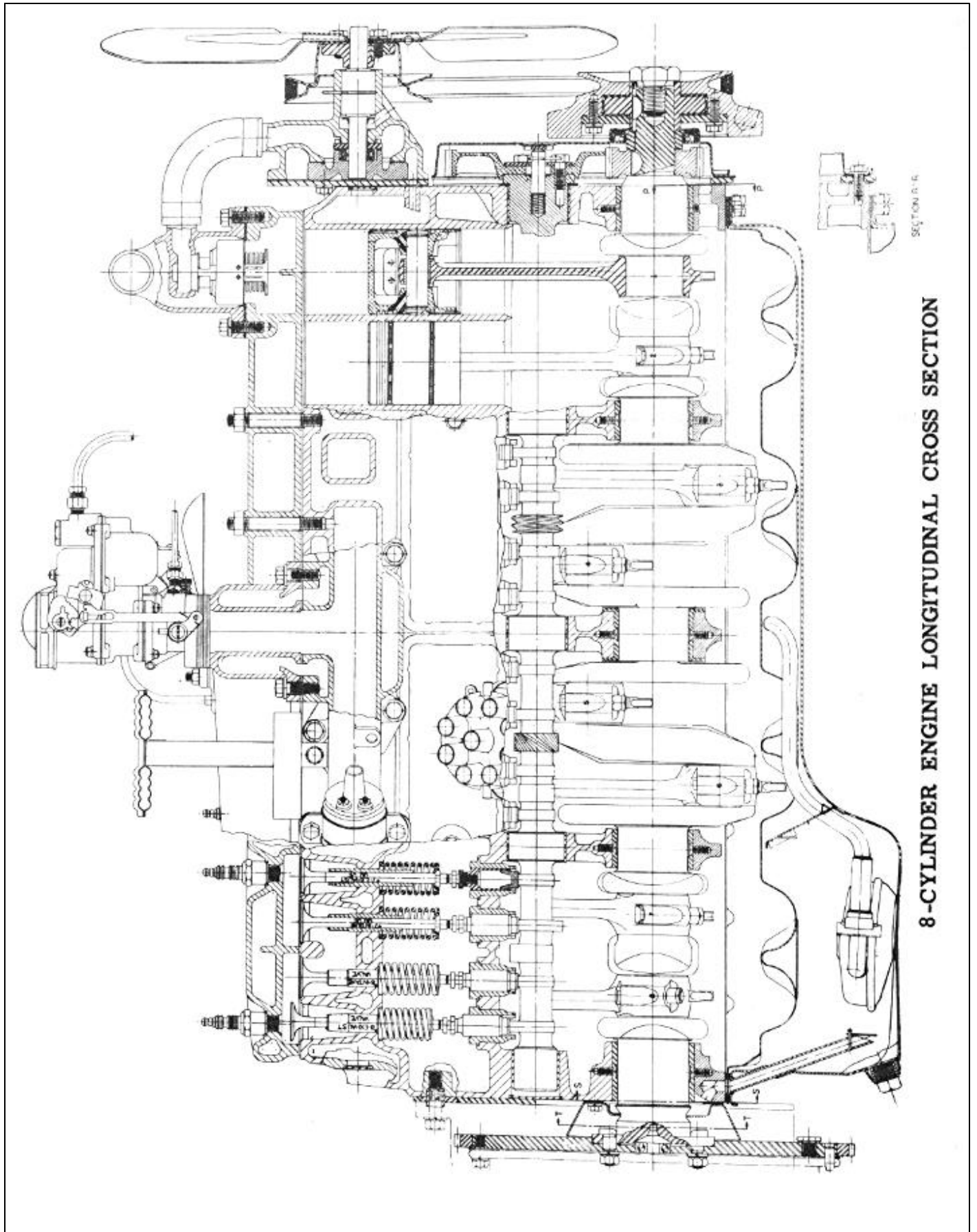
OPERATION	DESCRIPTION	TIME	PRICE
ENGINE—Continued			
9-26	TIMING CHAIN — Remove and Install. — Includes checking timing. All Models — 6 cyl.	3.1	_____
9-27	TIMING GEAR AND SPROCKET — Remove and Install. —Includes remove and install vibration dampener. — All Models — 6 cyl	3.1	_____
9-28	TIMING GEARS — Remove and Install. — Includes remove and install vibration dampener. — All Models — 8 cyl.	2.6	_____
CYLINDER BLOCK			
9-29	CYLINDER BLOCK — Hone all cylinders. — Does not include time for removing and installing, cylinder head and pistons. All Models — 6 cyl.	4.7	_____
	8 cyl.	5.9	_____
9-30	CYLINDER BLOCK — Hone one cylinder. — When cylinder head and piston is removed. All Models — 6 cyl.	1.0	_____
	Each additional cyl — Add	.7	_____
	All Models — 8 cyl.	1.1	_____
	Each additional cyl. — Add	.8	_____
9-31	CYLINDER BLOCK — REBORE — All cylinders. — When cylinder head and pistons are removed. — Includes remove and install studs on 8 cyl. models. All Models — 6 cyl.	5.5	_____
	8 cyl.	7.2	_____
9-32	CYLINDER BLOCK HEAD STUD — Remove and Install — All. All Models — 8 cyl.	1.0	_____
9-33	CYLINDER BLOCK HEAD STUD — Remove and Install (one) — broken stud. — All Models — 8 cyl.	.4	_____
MANIFOLDS			
9-34	EXHAUST MANIFOLD AND/OR GASKETS — Remove and Install. All Models — 6 cyl.	2.2	_____
	8 cyl.	1.9	_____
9-35	EXHAUST MANIFOLD HEAT TUBE — Remove and Install. All Models	.3	_____
9-36	INTAKE MANIFOLD TO CARBURETOR GASKET—Remove and Install. All Models	.4	_____
9-37	INTAKE MANIFOLD AND/OR GASKETS — Remove and Install. All Models — 6 cyl.	2.2	_____
	8 cyl.	2.5	_____
ENGINE LUBRICATION			
9-38	9-38 OIL CHECK VALVE — Remove and Install. All Models — 6 cyl.	.2	_____
	8 cyl.	.4	_____
	With Drive-Master — 6 cyl.	1.1	_____

OPERATION	DESCRIPTION	TIME	PRICE
ENGINE—Continued			
9-39	OIL CHECK VALVE (BAKELITE) PRESSURE INDICATOR PIN ASSEMBLY — Remove and Install. — All Models — 8 cyl	.2	_____
9-40	OIL PRESSURE INDICATOR — BLOCK UNIT—Remove and Install. All Models — 8 cyl.	.2	_____
9-41	OIL PAN ASSEMBLY — Remove, Clean and Install. — Includes replacing gaskets. All Models — 6 cyl. 8 cyl. With Drive-Master — Add	1.6 2.1 .2	_____ _____ _____
9-42	OIL PUMP ASSEMBLY — Remove and Install. — Includes checking timing on six cylinder engines. All Models — 6 cyl. 8 cyl. With Drive-Master — 6 cyl.	.6 .8 .7	_____ _____ _____
9-43	OIL PUMP SUCTION PIPE — Remove and Install. All Models — 8 cyl.	.2	_____
9-44	OIL PUMP TO CHECK VALVE PIPE — Remove and Install. All Models — 8 cyl.	.3	_____
9-45	OIL PRESSURE INDICATOR LIGHT — Remove and Install lens or bulb. All Models	.2	_____
9-46	OIL PRESSURE CHECK — Includes remove and Install — block indicator unit. — All Models — 6 cyl.	.4	_____
CONNECTING RODS, PISTONS AND RINGS			
9-47	CONNECTING RODS — Align all. — Includes remove and install cyl. head and oil pan, remove ridge from walls and remove and install connecting rods, pistons and rings. All Models — 6 cyl. 8 cyl. With Drive-Master — Add	7.1 8.4 .8	_____ _____ _____
9-48	CONNECTING RODS — Align all. — When removed from engine includes installing new rings on pistons. All Models 6 cyl. 8 cyl.	1.6 2.0	_____ _____
9-49	CONNECTING RODS. — Remove and Install a complete set of new rods using old pistons — if necessary add to operation 9-48. All Models — 6 cyl. 8 cyl.	1.0 1.3	_____ _____
9-50	CONNECTING ROD — Remove and Install (one only). — Includes remove and install oil pan, cylinder head, remove ridge from wall and remove and install connecting rod piston and rings. All Models — 6 cyl. 8 cyl. With Drive-Master For each additional rod — Add	4.6 5.6 .8 .5	_____ _____ _____ _____



8-CYLINDER ENGINE TRANSVERSE CROSS SECTION

OPERATION	DESCRIPTION	TIME	PRICE
ENGINE—Continued			
9-51	PISTON — Remove and Install one with rings. — When oil pan and cylinder head are Removed. — All Models	.8	_____
9-52	PISTONS AND RINGS — Remove and Install (All). — Includes remove and install oil pan and cylinder head. Remove ridge from walls and remove carbon. Fit new pistons and rings and align rods.		
	All Models — 6 cyl.	4.8	_____
	8 cyl.	5.8	_____
	With Drive-Master — Add	.8	_____
	If necessary to hone cylinders — 6 cyl. Add	4.5	_____
	8 cyl. Add	5.9	_____
9-53	PISTON AND RINGS — Remove and Install (one). — Includes remove and install — oil pan and cylinder head and remove and install piston, rings and aligning rod.		
	All Models — 6 cyl.	4.8	_____
	8 cyl.	5.8	_____
	With Drive-Master	.8	_____
	For each additional piston — Add	.7	_____
	If necessary to hone one cylinder — Add	1.0	_____
	To hone each additional cylinder — Add	.7	_____
9-54	PISTON PINS — Remove and Install (All). — Includes and remove and install cylinder head, oil pan, connecting rod bushings and aligning rods using old pistons, remove carbon and remove ridge from walls.		
	All Models — 6 cyl.	9.2	_____
	8 cyl.	11.1	_____
	With Drive-Master	.8	_____
9-55	PISTON PIN — Remove and Install (one) pin and bushings. — Includes remove and install cylinder head and oil pan, remove ridge from walls and align rods.		
	All Models — 6 cyl.	5.0	_____
	8 cyl.	6.0	_____
	With Drive-Master — Add	.8	_____
	For each additional pin — Add	.8	_____
9-56	PISTON PIN — Remove and Install (one) . — When piston and rod is removed. Includes ream bushings, fit pin and align rod.		
	All Models — Each Pin	.4	_____
9-57	PISTON RINGS — Remove and Install (All) . — Includes remove and install cylinder head and oil pan, removing carbon and ridge from walls, align rods.		
	All Models — 6 cyl.	7.3	_____
	8 cyl.	9.2	_____
	With Drive-Master — Add	.8	_____
9-58	PISTON RINGS — Remove and Install on one piston (only). — Includes remove and install — cylinder head and oil pan, removing carbon and ridge from wall and aligning rods.		
	All Models — 6 cyl.	4.5	_____
	8 cyl.	5.5	_____
	With Drive-Master — Add	.8	_____
	For each additional piston — Add	.6	_____
9-59	PISTON RINGS — Remove and Install piston out of car.		
	All Models — One Piston	.2	_____



OPERATION	DESCRIPTION	TIME	PRICE
ENGINE—Continued			
CYLINDER HEADS			
9-60	CYLINDER HEAD — Tighten all studs or cap screws. All 480-490 Models — 6 cyl. 8 cyl. All 500 and "A" Models — 6 cyl. 8 cyl.	.3 .4 .7 .5	
9-61	CYLINDER HEAD — COMPRESSION TEST — All cylinders. All Models — 6 cyl. 8 cyl.	.8 .9	
9-62	CYLINDER HEAD AND/OR GASKET — Remove and Install. — Includes removing carbon. All Models — 6 cyl. 8 cyl. With Drive-Master — Add To drill out and replace a broken stud or cap screw — Add	1.8 2.3 .8 .4	
VALVES, SPRINGS, TAPPETS AND GUIDES			
9-63	TAPPETS — ADJUST ALL. — Includes remove and install left front wheel and both valve tappet covers. All Models — 6 cyl. 8 cyl.	1.5 1.9	
9-64	TAPPET ASSEMBLIES—Remove and Install all, including guides. Includes remove and install cylinder head and adjusting tappets. All Models — 8 cyl.	4.8	
9-65	TAPPET ASSEMBLIES—Remove and Install all, including guides. Includes remove and install cylinder head and oil pan, valve tappet covers, camshaft and adjusting tappets. All Models — 6 cyl. With Drive-Master — Add	9.8 .8	
9-66	TAPPET ASSEMBLY — Remove and Install one—unnecessary to remove cylinder head. — Includes remove and install valve covers. All Models — 8 cyl.	1.1	
9-67	TAPPET ASSEMBLY — Remove and Install one—including guide. Includes remove and install cylinder head and oil pan, valve tappet covers, camshaft and adjusting tappets. All Models — 6 cyl. With Drive-Master — Add	9.4 .8	
9-68	VALVE TAPPET COVERS — Remove and Install. — Includes replacing gasket. All Models — 6 cyl. — front 8 cyl. Rear all Models — 6 cyl. 8 cyl.	.3 .3 .4 .5	
9-69	VALVES — GRIND. — Includes remove carbon, adjust tappets and minor engine tune up. All Models — 6 cyl. 8 cyl. With Drive-Master — Add	6.4 7.1 .6	

OPERATION	DESCRIPTION	TIME	PRICE
ENGINE—Continued			
9-70	VALVES -- Remove and Install one. — Includes remove and install cylinder head, tappet covers and checking tappet adjustment also refacing valve and seat. All Models — 6 cyl. 8 cyl. For each additional valve — Add With Drive-Master — Add	3.3 3.4 .2 .8	
9-71	VALVE GUIDES — Remove and Install. — All when valves are removed. All Models — 6 cyl. 8 cyl. To remove and install one guide	1.6 1.8 .3	
9-72	VALVE SPRINGS — Remove and Install all. — Includes remove and install cylinder head, valve tappet covers and adjusting tappets. All Models — 6 cyl. 8 cyl. With Drive-Master — Add	4.2 3.8 .8v	
9-73	VALVE SPRING — Remove and Install one with valve cover removed. — Includes checking adjustment. All Models — 8 cyl. Each additional spring — Add	.8 .2	
9-74	VALVE SPRING — Remove and Install one. — Includes remove and install cylinder head, valve covers and checking adjustment.. All Models — 6 cyl. With Drive-Master For each additional spring — Add	3.3 4.1 .2	

ENGINE COMBINATION OPERATION #1

9-75	MINOR ENGINE TUNE-UP. — Includes clean and regap or replace spark plugs, adjust or replace distributor points, check flywheel timing, adjust carburetor and climatic control, clean fuel pump sediment bowl, clean and/or recoil air cleaner. All Models — 6 cyl. 8 cyl. With Drive-Master — 6 cyl.	1.5 1.7 1.6	
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ENGINE COMBINATION OPERATION #2

9-76	MAJOR ENGINE TUNE-UP. — Includes check battery gravity, battery cables and load test battery, clean and regap or replace spark plugs, check engine compression and engine vacuum, test and adjust distributor mechanical and vacuum advance and dwell angle. Test condenser capacity, make coil first and secondary test, check engine timing at flywheel, check generator output, check generator regulator, clean and adjust carburetor and climatic control, check fuel pump pressure and clean sediment bowl, clean air cleaner. Note: If necessary to overhaul carburetor add operation 18-2. All Models — 6 cyl. With Drive-Master All Models — 8 cyl.	3.3 3.5 3.7	
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OPERATION	DESCRIPTION	TIME	PRICE
ENGINE—Continued			
ENGINE COMBINATION OPERATION #3			
9-77	VALVES AND/OR SPRINGS AND TAPPET ASSEMBLIES. — Includes remove and install cylinder head, valve covers, refacing valves and seats, adjusting tappets and minor engine tune-up — on 6 cylinder Models camshaft removal and replacement is included. All Models — 6 cyl. 8 cyl. With Drive-Master — Add	12.3 8.8 .8	
ENGINE COMBINATION OPERATION #4			
9-78	VALVES AND/OR VALVE SPRINGS, PISTONS, PINS, RINGS AND MAIN AND CONNECTING ROD BEARINGS — Remove and Install. — Includes remove and install cylinder head, oil pan, main and connecting rod bearings, aligning rods, refacing valves and seats, replacing piston rings and minor engine tune-up operation 9-75. All Models — 6 cyl. 8 cyl. With Drive-Master — Add If necessary to hone cylinders — 6 cyl. — Add — 8 cyl. — Add	14.2 15.3 .8 4.7 5.9	
BODY AND HARDWARE			
DOORS			
10-1	DOOR ASSEMBLY — Complete, Remove and Install. All Models — front rear Door outer panel lower moulding — Remove and Install. All Models — front or rear	1.5 1.7 .1	
10-2	DOOR ASSEMBLY — SKELETON — Remove and Install. — Does not Include Painting. All Models — front rear	3.0 2.5	
10-3	DOOR (FRONT) WINDOW REGULATOR ASSEMBLY—Remove and Install. All Models	1.6	
10-4	DOOR (REAR) WINDOW REGULATOR ASSEMBLY — Remove and Install. All Models	1.3	
10-5	DOOR VENTILATING WING REGULATOR ASSEMBLY (CRANK TYPE) — Remove and Install. All Models	1.5	
10-6	DOOR VENTILATING WING REGULATOR ASSEMBLY (FRICTION TYPE) — Remove and Install. — All Models	1.2	
10-7	DOOR WINDOW REGULATOR HANDLES — Remove and Install (one). All Models	.2	
10-8	DOOR ARM RESTS — Remove and Install (one) — All Models	.2	
10-9	DOOR HANDLE (Inside) — Remove and Install (one). All Models	.2	
10-10	DOOR HANDLE (Outside) — Remove and Install (one) All Models	.1	

OPERATION	DESCRIPTION	TIME	PRICE
BODY AND HARDWARE—Continued			
10-11	DOOR LOCK CYLINDER AND HOUSING — Remove and Install. All Models-	.2	_____
10-12	DOOR LOCK COMPLETE ASSEMBLY — Remove and Install. — Includes remove and install trim panels and regulator handles. All Models — front	1.7	_____
	rear	1.2	_____
10-13	DOOR LOCK STRIKER PLATE — Remove, Install and Adjust. All Models	.3	_____
10-14	DOOR CHECK STRAP — Remove and Install. — All Models	1.3	_____
10-15	DOOR HINGE AND/OR HINGE PIN — Remove and Install. — Front upper and lower and rear lower all Models	.6	_____
	Upper rear all Models	.2	_____
WEATHERSTRIPPING			
10-16	FRONT DOOR OPENING WEATHERSTRIP (UPPER) — Right or left — Remove and Install. — All Models	.4	_____
10-17	FRONT DOOR OPENING WEATHERSTRIP (LOWER END) — Right or left — Remove and Install. — All Models	.2	_____
10-18	FRONT DOOR OPENING WEATHERSTRIP—Front Pillar (dog- leg) — Remove and Install. — All Models	.4	_____
10-19	FRONT DOOR (FRONT) WEATHERSTRIP AT BELT LINE (S- Rubber) — Remove and Install. — All Models	.3	_____
10-20	FRONT DOOR (FRONT) WEATHERSTRIP — Remove and Install (LOWER) — Right or left. — All Models	.3	_____
10-21	FRONT DOOR VENTILATING WING (CRANK TYPE) WEATHER- STRIP — Remove and Install. — All Models	2.2	_____
10-22	FRONT DOOR VENTILATING WING (FRICTION TYPE) WEATHERSTRIP — Remove and Install. — All Models	2.0	_____
10-23	DOOR BOTTOM WEATHERSTRIP — Remove and Install. All Models — Sedans	.5	_____
	Broughams and Coupes	.6	_____
10-24	REAR DOOR OPENING WEATHERSTRIP (FRONT) — Remove and Install (one). — All Models	.2	_____
10-25	REAR DOOR WEATHERSTRIP (REAR) — Remove and Install. All Models	.2	_____
10-26	REAR COMPARTMENT DOOR WEATHERSTRIP — Remove and Install. All Models	.9	_____
	If necessary to touch up paint — Add	.8	_____

OPERATION	DESCRIPTION	TIME	PRICE
BODY AND HARDWARE—Continued			
10-27	QUARTER WINDOW — WEATHERSTRIP—Remove and Install. All Models — Sedans Broughams and Coupes	.9 1.2	
DOOR LINERS			
10-28	FRONT DOOR INNER PANEL LINER (INNER) —Remove and Install one. All Models — Sedans Broughams and Coupes	.9 .7	
10-29	FRONT DOOR INNER PANEL LINER (OUTER) — Remove and Install one. All Models — Sedans Broughams and Coupes	2.6 2.7	
10-30	REAR DOOR INNER PANEL LINER (INNER) — Remove and Install. All Models — Sedans	.6	
10-31	REAR DOOR INNER PANEL LINER (OUTER) — Remove and Install. All Models — Sedans	1.9	
10-32	QUARTER WINDOW INNER PANEL LINER (OUTER) — Remove and Install. All Models — Broughams and Coupes	3.7	
10-33	QUARTER WINDOW WATER BAFFLE — Remove and Install. All Models — Sedans	3.1	
SEATS, SEAT TRACK AND UPHOLSTERY			
10-34	FRONT SEAT AND SEAT TRACK ASSEMBLY — Remove and Install. All Models	.8	
10-35	REAR SEAT AND SEAT BACK ASSEMBLY — Remove and Install. All Commodore Models (3 sections) Super Models (1 section)	.5 .4	
10-36	FRONT SEAT BACK ROBE HANGERS — Remove and Install. All Models — Sedans (one) Broughams and Coupes (two)	.5 .6	
10-37	SEAT CUSHION — UPHOLSTERY. — Includes remove and install seat covering — factory cut to size. — All Model Sedans	1.0	
10-38	SEAT BACKS — UPHOLSTERY. — Includes remove and install covering — factory cut to size. All Super Models — front or rear Commodore Models — rear	1.0 1.4	
10-39	FRONT SEAT BACK — UPHOLSTERY. — Includes remove and install covering — factory cut to size. — All Models	.6	
10-40	REAR SEAT CENTER ARM REST — UPHOLSTERY—Remove and Install. Commodore Models (only) — cloth trim	.9	

OPERATION	DESCRIPTION	TIME	PRICE
BODY AND HARDWARE—Continued			
WINDSHIELD			
10-41	WINDSHIELD DRAIN TUBES — Install. — All Models	.6	_____
10-42	WINDSHIELD GLASS AND/OR WEATHERSTRIP—Remove and Install.		
	All Models — one side	1.5	_____
	both sides	2.9	_____
	Radio equipped — one side	1.9	_____
	both sides	3.3	_____
10-43	WINDSHIELD — Reseal to eliminate leaks. — All Models	.5	_____
10-44	WINDSHIELD GARNISH MOULDING RIGHT OR LEFT—Remove and Install.		
	All Models	.3	_____
10-45	WINDSHIELD WIPER ARMS — Adjust travel. — All Models	.3	_____
10-46	WINDSHIELD WIPER CONTROL KNOB ASSEMBLY — Remove and Install.		
	All Models	.3	_____
10-47	WINDSHIELD WIPER CABLE — Remove and Install.		
	All Models — one cable	.6	_____
1048	WINDSHIELD WIPER MOTOR — Remove and Install.		
	All Models	.3	_____
10-49	WINDSHIELD WIPER PULLEY HOUSING AND CABLE — Remove and Install. —		
	All Models	.4	_____
10-50	WINDSHIELD WIPER CABLE TENSION PULLEY—Remove and Install.		
	All Models	.4	_____
10-51	WINDSHIELD WIPER AND WASHER CONTROL KNOB ASSEMBLY — Remove and Install. — All Models	.4	_____
WINDOWS, REGULATORS AND MOULDINGS			
10-52	WINDOWS, REGULATORS AND MOULDINGS DOOR GLASS — Remove and Install.		
	All Models — Sedans — front	1.8	_____
	rear	1.3	_____
	Broughams and Coupes	2.0	_____
10-53	DOOR VENTILATING WING GLASS — Remove and Install.		
	All Models	1.8	_____
10-54	QUARTER WINDOW GLASS — Remove and Install.		
	All Models — Sedans	.6	_____
	Broughams and Coupes	.7	_____
10-55	REAR WINDOW (SINGLE) GLASS AND/OR WEATHERSTRIP — Remove and Install. — All Models	1.8	_____
10-56	REAR WINDOW (DOUBLE) GLASS AND/OR WEATHERSTRIP — Remove and Install.		
	All Models — one side	2.8	_____
	both sides	3.0	_____

OPERATION	DESCRIPTION	TIME	PRICE
BODY AND HARDWARE—Continued			
10-57	DOOR GLASS RUN CHANNEL — Remove and Install.		
	All Models — Sedan — front	1.8	_____
	Sedan — rear	1.3	_____
	Broughams and Coupes	1.9	_____
10-58	DOOR WINDOW REGULATOR ASSEMBLY — Remove and Install.		
	All Models — Sedan — front	1.7	_____
	Sedan — rear	1.4	_____
	Broughams and Coupes	1.9	_____
10-59	WINDOW REGULATOR ASSEMBLIES (FREE UP).— Includes remove Moulding to oil mechanism. — All Models	.5	_____
10-60	WINDOW REGULATOR HANDLES OR ESCUTCHEONS — Remove and Install. — All Models.	.2	_____
10-61	DOOR VENTILATING WING REGULATOR ASSEMBLY—Remove and Install. All Models — crank type	1.5	_____
	friction type	1.2	_____
10-62	QUARTER WINDOW REGULATOR ASSEMBLY — Remove and Install. All Models — Broughams and Coupes	2.0	_____
10-63	QUARTER WINDOW GARNISH MOULDING—Remove and, Install. — All Models — Broughams and Coupes	.3	_____
10-64	DOOR WINDOW GARNISH MOULDING — Remove and Install. All Models — front or rear	.3	_____
10-65	FRONT DOOR REVEAL MOULDING — Remove and Install. All Models — Sedans	1.3	_____
10-66	REAR DOOR REVEAL MOULDING — Remove and Install. All Models — Sedans	.3	_____
10-67	DOOR REVEAL MOULDING — Remove and Install. — Right or left. All Models — Broughams	1.4	_____
BODY INTERIOR TRIM			
10-68	DOOR WINDLACE — Remove and Install. — Complete. All Models — Sedans	1.5	_____
	Broughams and Coupes	1.0	_____
10-69	QUARTER TRIM PANEL — Remove and Install. All Models — Sedans Super Series	.6	_____
	Sedans Commodore Series	.4	_____
	Broughams and Coupes	.9	_____
10-70	FLOOR MAT (FRONT) — Remove and Install. — All Models	.2	_____
10-71	FLOOR MAT (REAR) — Remove and Install. — All Models	.4	_____
10-72	REAR COMPARTMENT FLOOR MAT — All Models	.3	_____

OPERATION	DESCRIPTION	TIME	PRICE
BODY AND HARDWARE—CONVERTIBLE BODY—Continued			
10-73	COWL KICK PANEL — Remove and Install. — All Models	.6	_____
10-74	DOOR POCKET TRIM PANEL — Remove and Install. All Models	.7	_____
10-75	DOOR TRIM PANEL (OUTER) — Remove and Install. All Models	.2	_____
10-76	DOOR POCKET MOULDING — Remove and Install. All Models — each	.3	_____
10-77	DOOR PILLAR POST TRIM PANEL — Remove and Install. All Models — Sedans	.4	_____
10-78	HEADLINING — Remove and Install. All Models — Sedans and Broughams Coupes	7.5 6.9	_____ _____
10-79	SUN VISOR — Remove and Install (one) . — All Models	.2	_____
10-80	ROOF PANEL INSULATION — Replace or Install new. All Models — Sedans Broughams and Coupes	7.9 7.3	_____ _____
REAR COMPARTMENT DOOR			
10-81	REAR COMPARTMENT DOOR — Remove and Install and align All Models	1.0	_____
10-82	REAR COMPARTMENT DOOR WEATHERSTRIP — Remove and Install. All Models If necessary to touch up paint — Add	.9 .8	_____ _____
10-83	REAR COMPARTMENT DOOR NAME PLATE—Remove and Install. All Models	.3	_____
10-84	REAR COMPARTMENT DOOR LOCK ASSEMBLY — Remove and Install. All Models — 480-490-500	.5	_____
10-85	REAR COMPARTMENT DOOR LOCK HANDLE AND/OR CYLINDER — Remove and Install. All Models — 480-490-500 Lock and Cylinder "A" Series	.3 .5	_____ _____
10-86	REAR COMPARTMENT DOOR LATCH OPERATING LEVER — Remove and Install — one. All Models — 480-490-500	.3	_____
10-87	REAR COMPARTMENT DOOR HINGE AND/OR SPRING — Remove and Install. — All Models	.5	_____
10-88	REAR COMPARTMENT DOOR STRIKER — Remove and Install. All Models	.2	_____
INSTRUMENT PANEL AND INSTRUMENTS			
10-89	INSTRUMENT PANEL ASSEMBLY COMPLETE — Remove and Install. All Models — Commodores — 480-490-500 and "A" Series Supers — 480-490-500 Series	4.6 4.0	_____ _____
	Instrument panel top covering (leather) — Remove and Install. "A" Series Models	1.3	_____
10-90	INSTRUMENT FINISH PANEL (CENTER SECTION) — Remove and Install. All Models — 480-490-500 Left Section — All Models — 480-490-500	.7 .3	_____ _____

OPERATION	DESCRIPTION	TIME	PRICE
BODY AND HARDWARE—Continued			
10-91	LOCKER BOX DOOR — Remove and Install. Any Model — Right or Left door	.3	_____
10-92	LOCKER BOX — Remove and Install. — All Models	.5	_____
10-93	LOCKER BOX — LOCK AND CYLINDER — Remove and Install. All Models	.3	_____
10-94	HEADLIGHT SWITCH AND/OR CIRCUIT BREAKER—Remove and Install. All Models	.3	_____
10-95	RHEOSTAT LIGHT SWITCH — Remove and Install. Commodore Models only	.2	_____
10-96	STARTER MOTOR SWITCH — Remove and Install. — All Models.	.2	_____
10-97	SPEEDOMETER HEAD — Remove and Install. All Models — 480-490-500 "A" Series	.5 .7	_____ _____
10-98	SPEEDOMETER LENS — Remove and Install. All Models — 480-490-500 "A" Series	.6 .8	_____ _____
10-99	SPEEDOMETER CABLE OR HOUSING — Remove and Install. All Models	.6 .6	_____ _____
10-100	SPEEDOMETER PINION — Remove and Install. — All Models		
10-101	CLOCK — ANY STYLE — Remove and Install. All Models — 480-490-500 "A" Series	.6 .8	_____ _____
10-102	REMOVE AND REPLACE ANY INSTRUMENT PANEL LIGHT BULB. All Models	.2	_____
10-103	REMOVE AND REPLACE THE FUEL OR TEMPERATURE GAUGE. All Models — 480-490-500 "A" Series	.7 .9	_____ _____
CONVERTIBLE BODY			
TOP COVERING, MOTOR AND PUMP ASSEMBLY AND OPERATING CYLINDERS			
10-104	TOP, COMPLETE ASSEMBLY,— Remove and Install— and adjust. Bows, top covering and curtain attached. — All Models	5.5	_____
10-105	TOP COVERING — Remove and Install. — Includes rear curtain. All Models	7.4	_____
10-106	TOP COVERING — Remove and Install. — Less rear curtain. All Models	5.5	_____
10-107	TOP REAR CURTAIN AND EXTENSION — Remove and Install. All Models	4.3	_____
10-108	REAR CURTAIN (ONLY) — Remove and Install. — All Models	1.0	_____
10-109	REAR CURTAIN WINDOW FRAME — Remove and Install. All Super Models	.7	_____

OPERATION	DESCRIPTION	TIME	PRICE
BODY AND HARDWARE—CONVERTIBLE BODY—Continued			
10-110	REAR CURTAIN WINDOW FRAME WEATHERSTRIP — Remove and Install. — All Super Models	.7	_____
10-111	REAR CURTAIN LOWER MOULDING — Remove and Install. All Models	.4	_____
10-112	HYDRAULIC MOTOR AND PUMP ASSEMBLY — Drain and refill system. All Models	1.5	_____
10-113	REAR QUARTER WINDOW REGULATOR — CYLINDER — Remove and Install. — Includes draining and refilling system. All Models	3.5	_____
10-114	HYDRAULIC MOTOR AND PUMP ASSEMBLY — Remove and Install. All Models	2.2	_____
10-115	HYDRAULIC MOTOR AND PUMP ASSEMBLY — Refill. All Models	.6	_____
10-116	TOP CONTROL VALVE ASSEMBLY — Remove and Install. All Models	1.0	_____
10-117	TOP OPERATING CYLINDER AND YOKE ASSEMBLY — Remove and Install. — All Models — one side	1.5	_____
10-118	OPERATING CYLINDER ANCHOR, CLEVIS PIN — Remove and Install. All Models — one side	1.5	_____
10-119	QUARTER PILLAR ASSEMBLY — Remove and Install. All Models — one side	.8	_____
10-120	TOP QUARTER PILLAR UPPER BRACKET—Remove and Install. Right or Left Hand — All Models — one — two	1.5 2.9	_____ _____
10-121	QUARTER PILLAR RAIL — Remove and Install. Right or Left Hand — All Models	1.0	_____
TOP HEADER, BOWS, SIDERAILS, AND MOULDINGS			
10-122	TOP FRONT HEADER ASSEMBLY — Remove and Install. All Models	2.5	_____
10-123	HEADER TO SIDE RAIL BRACKET — Remove and Install. Right or Left Hand — All Models	2.0	_____
10-124	HEADER FRONT LOWER MOULDING — Remove and Install. All Models	.4	_____
10-125	HEADER FRONT UPPER MOLDING — Remove and Install. All Models	.4	_____
10-126	HEADER MOULDING — REAR — Remove and Install.—All Models	.4	_____
10-127	TOP REAR BOW MOULDING — Remove and Install. — All Models	.4	_____

OPERATION	DESCRIPTION	TIME	PRICE
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BODY AND HARDWARE—CONVERTIBLE BODY—Continued

10-128	TOP PADS (two) — Remove and Install. — All Models	4.5	_____
10-129	QUARTER FLAP RETAINER — Remove and Install. All Models — Right or Left Hand	.2	_____
10-130	TOP HOLD-DOWN CLAMP ASSEMBLY — Remove and Install. All Models — Right or Left Hand	.2	_____
10-131	TOP FRONT SIDE RAIL HINGE — Remove and Install. All Models — Right or Left Hand	1.0	_____
10-132	FRONT SIDE RAIL #2 BOW CONTROL LINK BRACKET — Remove and Install. — All Models — Right or Left Hand	.3	_____
10-133	#2 BOW CONTROL LINK ASSEMBLY — Remove and Install. All Models — Right or Left Hand	.4	_____
10-134	#2 BOW CONTROL LINK ASSEMBLY REAR — Remove and Install. All Models — Right or Left Hand	.7	_____
10-135	#3 BOW — Remove and Install. — All Models	2.2	_____
10-136	TOP PIVOT BRACKET BRACE — Remove and Install. All Models — Right or Left Hand	.8	_____
10-137	TOP BALANCE LINK — Remove and Install. All Models — Right or Left Hand	.2	_____

DOOR WINDOWS, AND REGULATORS, SWITCHES

10-138	DOOR WINDOW REGULATOR ASSEMBLY (HYDRAULIC) — Remove and Install. — All Models — Right or Left Hand	1.8	_____
19-139	DOOR WINDOW REGULATOR ASSEMBLY MANUAL CONTROL — Remove and Install. All. Models — Right or Left Hand	2.0	_____
10-140	DOOR WINDOW REGULATOR ROLLER GUIDE TIE BAR ASSEMBLY — Remove and Install. — All Models Right or Left Hand	2.0	_____
10-141	DOOR WINDOW REGULATOR CROSS ARM ASSEMBLY (MANUAL) — Remove and Install. — All Models — Right or Left Hand	2.0	_____
10-142	DOOR WINDOW STOP BUMPER — Remove and Install. All Models — Right or Left Hand	.4	_____
10-143	DOOR WINDOW STOP BUMPERS — Adjust. All Models — Right or Left Hand	.3	_____
10-144	DOOR WING FRAME AND GLASS ASSEMBLY — Remove and Install. — All Models — Right or Left Hand	1.0	_____

OPERATION	DESCRIPTION	TIME	PRICE
BODY AND HARDWARE—CONVERTIBLE BODY—Continued			
10-145	DOOR WING GLASS — Remove and Install. All Models — Right or Left Hand	.4	_____
10-146	DOOR WINDOW CENTER BAR GLASS RUN — Remove and Install. — All Models — Right or Left Hand	2.0	_____
10-147	WINDOW REGULATOR SWITCH ASSEMBLY (MULTIPLE) — Remove and Install. — All Models	.5	_____
10-148	WINDOW REGULATOR SWITCH ASSEMBLY (SINGLE) — Remove and Install. — All Models	.2	_____
10-149	QUARTER WINDOW GLASS — Remove and Install. All Models — Right or Left Hand	1.1	_____
10-150	QUARTER WINDOW HINGE — Remove and Install. All Models — Right or Left Hand	.8	_____
10-151	QUARTER WINDOW HINGE BRACKET — Remove and Install. All Models — Right or Left Hand	.8	_____
10-152	QUARTER WINDOW REGULATOR ASSEMBLY MANUAL CONTROL — Remove and Install. All Models — Right or Left Hand	1.5	_____
10-153	QUARTER WINDOW REGULATOR ASSEMBLY (HYDRAULIC) — Remove and Install. — All Models	1.8	_____
10-154	QUARTER WINDOW REGULATOR GUIDE—Remove and Install. All Models — Right or Left Hand	1.4	_____
10-155	QUARTER WINDOW REGULATOR PANEL ASSEMBLY — Remove and Install. — All Models — Right or Left Hand	.9	_____
10-156	QUARTER WINDOW ASSEMBLY — Remove and Install. All Models — Right or Left Hand	.7	_____
DOOR HINGES, LOCKS AND MOULDINGS			
10-157	DOOR WINDOW VALANCE — Remove and Install. All Models — Right or Left Hand	.3	_____
10-158	FRONT SEAT BACK VALANCE — Remove and Install. All Models — Right or Left Hand	.3	_____
10-159	10-159 QUARTER BELT MOULDING — Remove and Install. All Models — Right or Left Hand	.7	_____
10-160	10-160 REAR BELT MOULDING — Remove and Install. — All Models	4.3	_____

OPERATION	DESCRIPTION	TIME	PRICE
BODY AND HARDWARE—CONVERTIBLE BODY—Continued			
10-161	DOOR BELT MOULDING — Remove and Install. All Models — Right or Left Hand	1.3	_____
10-162	DOOR HINGE ASSEMBLY UPPER — Remove and Install. All Models — Right or Left Hand	.6	_____
10-163	DOOR HINGE ASSEMBLY LOWER — Remove and Install. All Models — Right or Left Hand	.6	_____
10-164	DOOR LOCK ASSEMBLY — Remove and Install. All Models — Right or Left Hand	1.7	_____
10-165	DOOR REMOTE CONTROL ASSEMBLY — Remove and Install. All Models — Right or Left Hand	1.6	_____
BODY INTERIOR TRIM AND SEATS			
10-166	PILLAR WINDLACE ASSEMBLY — FRONT — Remove and Install. — All Models — Right or Left Hand	.2	_____
10-167	PILLAR WINDLACE ASSEMBLY — REAR — Remove and Install. All Models — Right or Left Hand	.3	_____
10-168	REAR FLOOR SIDE CARPET ASSEMBLY — Remove and Install. All Models — Right or Left Hand	.4	_____
10-169	REAR FLOOR MAT AND PAD ASSEMBLY — Remove and Install. All Models	.6	_____
10-170	FRONT SEAT FRAME AND BACK — COMPLETE — Remove and Install. — All Models	.4	_____
10-171	REAR SEAT BACK SUPPORT — Remove and Install. All Models — Right or Left Hand	.8	_____
10-172	REAR SEAT CENTER ARM REST — UPHOLSTER — Includes Remove and Install. — All Models — Leather trim	1.5	_____
10-173	QUARTER TRIM SUPPORT PANEL ASSEMBLY — FRONT — Remove and Install. — All Models — Right or Left Hand	.3	_____
10-174	QUARTER TRIM SUPPORT PANEL ASSEMBLY — REAR — Remove and Install. — All Models — Right or Left Hand	.7	_____
WEATHERSTRIPPING			
10-175	DOOR OPENING WEATHERSTRIP — Remove and Install. All Models — Right or Left Hand	.3	_____
10-176	DOOR OPENING BELT WEATHERSTRIP — Remove and Install. All Models — Right or Left Hand	.2	_____

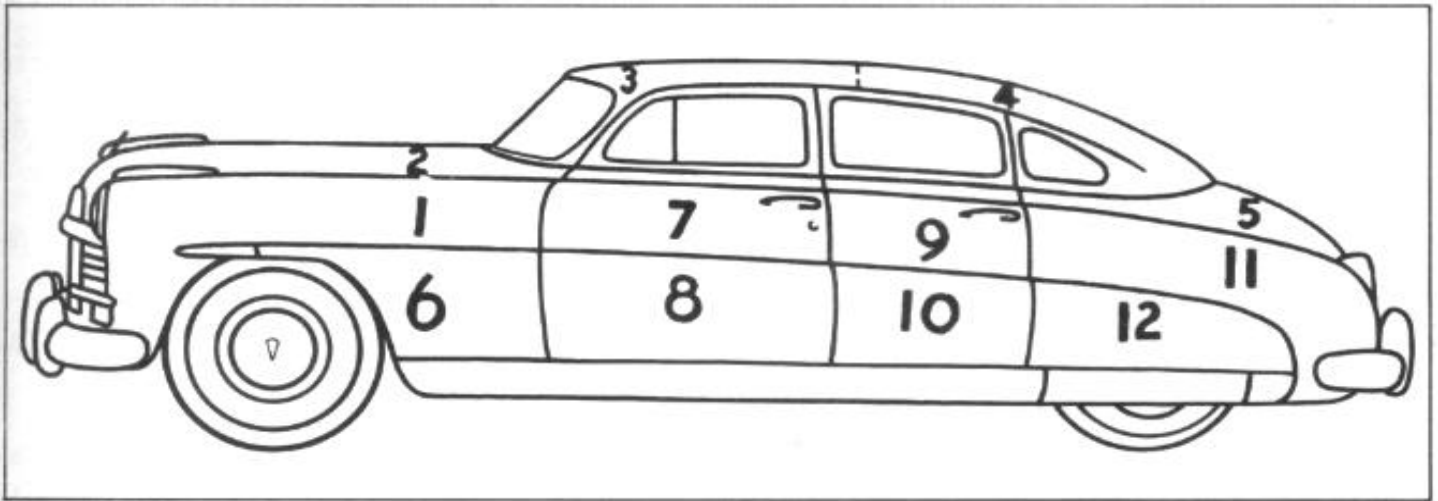
OPERATION	DESCRIPTION	TIME	PRICE
BODY AND HARDWARE—CONVERTIBLE BODY—Continued			
10-177	DOOR BOTTOM WEATHERSTRIP — Remove and Install. All Models — Right or Left Hand	.6	_____
10-178	DOOR REAR WEATHERSTRIP — Remove and Install. All Models — Right or Left Hand	.3	_____
10-179	DOOR WING RETAINER AND WEATHERSTRIP — Remove and Install. — All Models — Right or Left Hand	1.5	_____
10-180	DOOR WING WEATHERSTRIP — Remove and Install. All Models — Right or Left Hand	.6	_____
10-181	CENTER BAR AND WEATHERSTRIP ASSEMBLY — Remove and Install. All Models	1.7	_____
10-182	CENTER BAR VENT WING WEATHERSTRIP — Remove and Install. — All Models — Right or Left Hand	2.0	_____
10-183	DOOR WINDOW MOULDING AND WEATHERSTRIP ASSEMBLY — Remove and Install. — All Models — Right or Left Hand	.2	_____
10-184	QUARTER WINDOW MOULDING AND WEATHERSTRIP ASSEMBLY — Remove and Install. — All Models — Right or Left Hand	.1	_____
10-185	QUARTER WINDOW WEATHERSTRIP FRONT — Remove and Install. — All Models — Right or Left Hand	.2	_____
10-186	QUARTER WINDOW BELT WEATHERSTRIP — Remove and Install. — All Models — Right or Left Hand	.7	_____
10-187	FOLDING TOP HEADER JOINT WEATHERSTRIP (UPPER) — Remove and Install. — All Models	.4	_____
10-188	FOLDING TOP HEADER JOINT WEATHERSTRIP (LOWER) — Remove and Install. — All Models	.5	_____
10-189	WINDSHIELD FRONT PILLER WEATHERSTRIP — Remove and Install. All Models	.2	_____
10-190	TOP SIDE RAIL WEATHERSTRIP — FRONT — Remove and Install. — All Models — Right or Left Hand	.3	_____
10-191	TOP SIDE RAIL WEATHERSTRIP — INTERMEDIATE — Remove and Install. — All Models — Right or Left Hand	.3	_____
10-192	TOP SIDE RAIL WEATHERSTRIP — REAR — Remove and Install. — All Models — Right or Left Hand	.4	_____

OPERATION	DESCRIPTION	TIME	PRICE
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BODY REFINISHING INSTRUCTIONS

The necessary time for each operation is shown after the area locations as indicated by numbers on the car paint sketch below.

The flat rate times shown are for completely sanding, priming and refinishing the area as indicated on the sketch.



OPERATION NO.	AREA	
1	FRONT FENDER — (upper one side) — Refinish All Models	1.5 _____
2	HOOD — (complete area) — Refinish All Models	3.0 _____
3	ROOF PANEL — (front) — Refinish All Models	2.0 _____
4	ROOF PANEL — (rear) — Refinish All Models	2.0 _____
5	REAR COMPARTMENT DOOR — (complete area) — Refinish All Models	2.0 _____
6	FRONT FENDER LOWER — (one side) — Refinish All Models	1.0 _____
7	FRONT DOOR UPPER PANEL — (one side) — Refinish All Models.	1.0 _____
8	FRONT DOOR LOWER PANEL — (one side) — Refinish All Models.	1.0 _____
9	REAR DOOR UPPER PANEL — (one side) — Refinish All Models	1.0 _____
10	REAR DOOR LOWER PANEL — (one side) — Refinish All Models	1.0 _____
11	REAR FENDER UPPER PANEL — (one side) — Refinish All Models	1.5 _____

OPERATION	DESCRIPTION	TIME	PRICE
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BODY REFINISHING — Continued

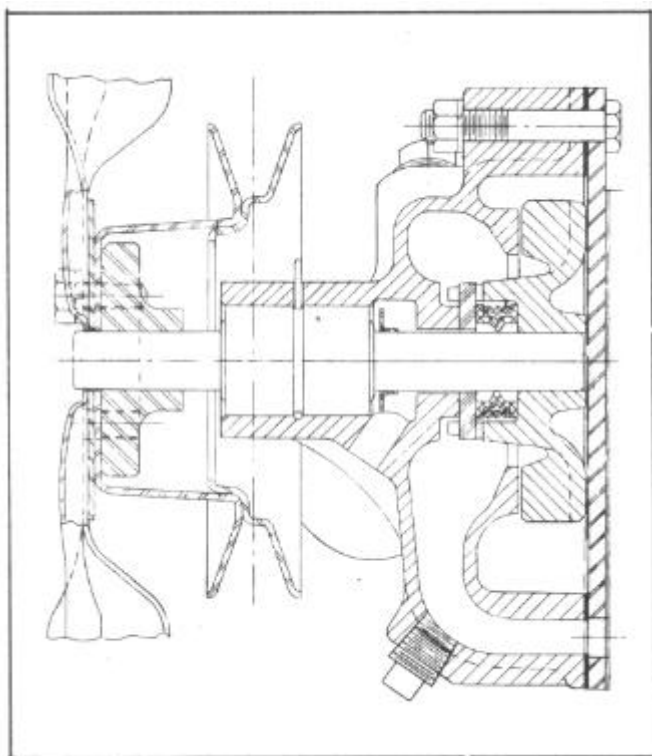
OPERATION NO.	AREA	PRICE
12	REAR FENDER LOWER PANEL — (one side) — Refinish All Models	1.0 _____
COMPLETE CAR	ONE COLOR	TWO-TONE
Sedans	30.	30.5
Broughams	29.	29.5
Coupes	28.	28.5
Convertibles	24.	24.5

NOTE: Spot refinishing must be estimated according to local s.

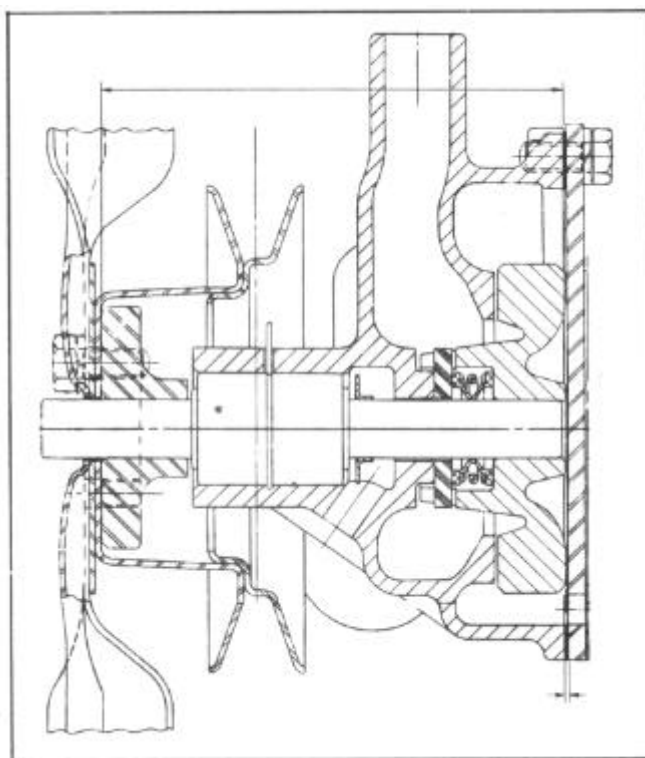
COOLING SYSTEM

11-1	COOLING SYSTEM — Flush and Refill. — All Models	.5 _____
11-2	WATER JACKET COVER OR GASKET — Remove and Install. All Models — 8 cylinder With Drive-Master	1.4 _____ 2.4 _____
11-3	CYLINDER WATER JACKET PLUGS — Remove and Install. All Models — 6 cyl. (3 plugs) front plug center plug rear plug	1.5 _____ .7 _____ .6 _____ .4 _____
11-4	RADIATOR CORE — Remove and Install. — All Models	.8 _____
11-5	RADIATOR DRAIN COCK — Remove and Install. — All Models	.3 _____
11-6	RADIATOR INLET HOSE — Remove and Install. — All Models	.4 _____
11-7	RADIATOR OUTLET HOSE — Remove and Install. — All Models.	.5 _____
11-8	RADIATOR HOSE — WATER PUMP TO WATER JACKET — Remove and Install. — All Models — 8 cylinder	.3 _____
11-9	RADIATOR BY-PASS HOSE — Remove and Install. All Models — 8 cylinder	.3 _____
11-10	RADIATOR HOSES (all) — Remove and Install. — All Models	1.1 _____
11-11	THERMOSTAT HOUSING AND/OR GASKET —Remove and Install. All Models	.5 _____

OPERATION	DESCRIPTION	TIME	PRICE
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6-CYLINDER WATER PUMP



8-CYLINDER WATER PUMP

COOLING SYSTEM — Continued

WATER PUMP AND FAN

11-12	WATER PUMP ASSEMBLY — Remove and Install. — All Models	1.0	_____
11-13	WATER PUMP — OVERHAUL. — Includes removal and installation, disassembly and inspection and replacement of any necessary parts. All Models	1.7	_____
11-14	FAN BLADES — Remove and Install. — All Models	.3	_____
11-15	FAN BELT — Remove and Install and Adjust. — All Models .	.3	_____
11-16	FAN BELT — ADJUST only. — All Models	.2	_____
11-17	WATER DISTRIBUTING TUBE — Remove and Install. All Models	3.0	_____
11-18	TEMPERATURE INDICATOR ELEMENT—Remove and Install.— (Cylinder head unit). — All Models With Drive-Master — Add	.3 .7	_____ _____

OPERATION	DESCRIPTION	TIME	PRICE
EXHAUST SYSTEM			
12-1	EXHAUST MANIFOLD AND/OR GASKETS — Remove and Install. All Models — 8 cylinder 6 cylinder When necessary to drill out and replace broken stud — Add	1.9 2.2 .4	_____
12-2	INTAKE MANIFOLD AND/OR GASKETS — Remove and Install. All Models — 8 cylinder 6 cylinder	2.5 2.2	_____
12-3	EXHAUST MANIFOLD DAMPER VALVE — Remove and Install. All Models — 8 cylinder 6 cylinder	.3 2.0	_____
12-4	EXHAUST MANIFOLD OUTLET ELBOW AND/OR GASKET — Remove and Install. — All Models	.8	_____
12-5	EXHAUST PIPE FLANGE AND/OR GASKET — Remove and Install. All Models — 8 cylinder	.9	_____
12-6	EXHAUST PIPE FLANGE GASKET — Remove and Install. All Models — 6 cylinder	.8	_____
12-7	EXHAUST PIPE (FRONT) — Remove and Install. All Models — 8 cylinder 6 cylinder	2.0 1.2	_____
12-8	EXHAUST PIPE (REAR) — Remove and Install. — All Models	.8	_____
12-9	EXHAUST PIPE FRONT CLAMP — Remove and Install. All Models	.5	_____
12-10	EXHAUST MUFFLER — Remove and Install. — All Models	.7	_____
12-11	MUFFLER CLAMP SUPPORT TO ENGINE REAR SUPPORT PLATE — Remove and Install. — All Models	.5	_____
12-12	MUFFLER CLAMP REAR — Remove and Install. — All Models	.3	_____
ELECTRICAL			
13-1	BATTERY — Remove and Install — New or Charging. — Does not include recharge time. — All Models	.3	_____
13-2	BATTERY COVER — Remove and Install. — All Models	.2	_____
13-3	BATTERY DRIP TRAY — Remove and Install. — All Models	.4	_____
13-4	BATTERY TO FRAME SUPPORT AND/OR BOLTS — Remove and Install. — Includes Breaking Welds on late 500 Series Cars. All Models	.6	_____

OPERATION	DESCRIPTION	TIME	PRICE
ELECTRICAL— Continued			
13.5	BATTERY CABLE TO STARTER MOTOR — Remove and Install. All Models	.2	_____
13.6	BATTERY GROUND STRAP — Remove and Install. — All Models .	.2	_____
13.7	BATTERY TO STARTER CABLE AND GROUND STRAP — Remove and Install both. — All Models	.5	_____
13-8	BATTERY TERMINALS — Clean and apply a coating of grease. All Models	.3	_____
GENERATOR			
13-9	GENERATOR ASSEMBLY — Remove and Install. — All Models	.4	_____
13-10	GENERATOR BRACKET — Remove and Install. — All Models	.5	_____
13-11	GENERATOR — Check charging rate. — All Models.	.3	_____
13-12	GENERATOR COMMUTATOR — Clean commutator and brushes and adjust charging rate. — All Models	.5	_____
13-13	GENERATOR OVERHAUL — Remove and Install. — Clean, repair and replace any necessary parts and test — does not include turning armature or undercutting mica. — All Models	1.6	_____
13-14	GENERATOR ARMATURE — Remove and Install. — Includes turning armature on lathe and undercutting mica. — All Models	1.2	_____
13-15	GENERATOR VOLTAGE REGULATOR — Remove and Install. All Models	.4	_____
HORN			
13-16	HORN ASSEMBLY — Remove and Install. All Models — one two	.3 .5	_____ _____
13-17	HORN ASSEMBLY — Clean and adjust contacts without removing horn. All Models	.4	_____
13-18	HORN RING — Remove and Install. 480-490 Models 500 Custom Wheel	.2 .6	_____ _____

OPERATION	DESCRIPTION	TIME	PRICE
EXHAUST SYSTEM			
13-19	HORN BUTTON WIRE — Remove and Install. — All Models	.3	_____
13-20	HORN RELAY — Remove and Install. — All Models	.2	_____
ELECTRICAL			
13-21	COIL — Remove and Install. — All Models	.3	_____
13-22	COIL — Test, make first and secondary check. — Includes remove and install. — All Models	.7	_____
13-23	DISTRIBUTOR ASSEMBLY — Remove and Install. — Includes checking flywheel timing. All Models — 6 cyl.	.6	_____
	6 cyl. — With Drive-Master	.7	_____
	8 cyl.	.7	_____
13-24	DISTRIBUTOR ASSEMBLY — OVERHAUL — Includes remove and Install. — Disassembly and reassembly, replace any necessary parts, checking mechanical and vacuum advance, condenser, rotor, cap and setting flywheel timing. All Models — 6 cyl.	1.5	_____
	8 cyl.	1.6	_____
13-25	DISTRIBUTOR POINTS — Clean or replace and adjust. — Includes checking flywheel timing. All Models	.6	_____
	With Drive-Master	.7	_____
13-26	DISTRIBUTOR CAP — Remove and Install. — All Models	.2	_____
13-27	DISTRIBUTOR CONDENSER — Remove and Install. All Models — 8 cyl.	.3	_____
	6 cyl.	.3	_____
	With Drive-Master — 6 cyl.	.4	_____
13-28	DISTRIBUTOR VACUUM ADVANCE UNIT—Remove and Install. Includes setting flywheel timing. — All Models	.7	_____
13-29	DISTRIBUTOR DRIVE SHAFT — Remove and Install. — Includes setting flywheel timing. — All Models	.8	_____
13-30	IGNITION CABLES — Complete set — Remove and Install. All Models — 6 cyl.	.5	_____
	8 cyl.	.6	_____
13-31	IGNITION SWITCH AND/OR LOCK — Remove and Install. All Models	.4	_____
	To replace ignition switch cable — Add	.6	_____
13-32	SPARK PLUGS — Remove and Install. All Models — 6 cyl.	.3	_____
	8 cyl.	.4	_____
13-33	SPARK PLUGS — Remove, Clean, Adjust and Reinstall. All Models — 6 cyl.	.5	_____
	8 cyl.	.6	_____

OPERATION	DESCRIPTION	TIME	PRICE
ELECTRICAL— Continued			
LIGHTS			
13-34	HEADLIGHT ASSEMBLY — Remove and Install one — Adjust two All Models	.8	_____
13-35	HEADLIGHT SEALED BEAM UNIT — Remove and Install one. — Includes adjusting beam	.3	_____
13-36	HEADLIGHTS — Adjust. — All Models	.2	_____
13-37	PARKING LIGHTS — Remove and Install. All Models — one	.2	_____
	two	.3	_____
	Light Bulb (only) one	.1	_____
13-38	FENDER LIGHTS OR BULB OR LENS — Remove and Install. All Models	.3	_____
13-39	HOOD LIGHT CREST OR LENS — Remove and Install. All Models — 480-490-500	.3	_____
	"A" Series	.5	_____
	Bulb 480-490-500	.1	_____
	"A" Series	.2	_____
13-40	STOPLIGHT — SWITCH — Remove and Install. — All Models	.3	_____
13-41	TAILSLIGHT GLASS OR BULB — Remove and Install. All Models	.2	_____
13-42	COURTESY LIGHT — Remove and Install lens or bulb. —All Models	.2	_____
13-43	DOME LIGHT — Remove and Install Lens or Bulb. All Models	.2	_____
STARTER MOTOR			
13-44	STARTER MOTOR ASSEMBLY — Remove and Install. All Models	.5	_____
	With Drive-Master	1.9	_____
13-45	STARTER MOTOR ASSEMBLY — OVERHAUL. — Includes remove and install, clean, replace any necessary parts. All Models	1.9	_____
	With Drive-Master	3.3	_____
13-46	STARTER MOTOR SOLENOID ASSEMBLY—Remove and Install. All Models — 480-490-500	.4	_____
	With Drive-Master	.5	_____
	All Model "A" Series	.2	_____
13-47	STARTER BUTTON AND SWITCH ASSEMBLY — Remove and Install. All Models	.2	_____
13-48	STARTER BENDIX DRIVE — Remove and Install with starter removed. All Models	.3	_____
13-49	STARTER BENDIX COVER. — Install all Standard Models With Drive-Master	.5	_____
		1.3	_____

OPERATION	DESCRIPTION	TIME	PRICE
ACCESSORIES			
14-1	BACK-UP LIGHT — Install. All Models — one two	1.6 _____ 1.8 _____	
14-2	BATTERY FILLER — Install. — All Models	.5 _____	
14-3	CIGARETTE LIGHTER — Install. — On models not so equipped	.7 _____	
14-4	CIGARETTE LIGHTER ELEMENT — Remove and Install. All Models	.2 _____	
14-5	CURB SIGNALS — Install. — All Models	.3 _____	
14-6	CLOCK — ELECTRIC — Install. — Includes removing old clock and installing electric type. — All Models	.6 _____	
14-7	DIRECTION INDICATOR — Install. — All Models	.5 _____	
14-8	DIRECTION INDICATOR SWITCH AND WIRES ASSEMBLY — Remove and Install. — All Models	.6 _____	
14-9	EXHAUST DEFLECTOR — Install. — All Models	.1 _____	
14-10	FOG LIGHTS (two) — Install. — All Models	1.0 _____	
14-11	FRONT FENDER TOP ORNAMENT KIT — Install. — All Models	.6 _____	
14-12	FRONT DOOR VENT WING SHIELDS — Install. — All Models.	1.2 _____	
14-13	GAS TANK LOCKING CAP — ELECTRIC — Install. — All Models	.1 _____	
14-14	GLARE PROOF MIRROR — Install. — All Models	2.5 _____	
14-15	HILL HOLD KIT — Install. — All Models	.2 _____	
14-16	HUB CAP KIT (large) — Install. — All Models	.5 _____	
14-17	KARVISOR — Install. — All Models Paint Traffic Light Viewer	1.0 _____ .2 _____	
14-18	KLEENEX TISSUE DISPENSER — Install. — All Models	.2 _____	
14-19	LICENSE PLATE FRAME — Install. All Models — adjustable custom	.2 _____ .3 _____	
14-20	MOULDING KITS — FENDER AND SIDE BODY PANELS — Install. All Models — Sedans Broughams and Coupes	2.0 _____ 1.8 _____	
14-21	OIL FILTERS — Install. All Models — 6 cyl. 8 cyl. With Drive-Master — 6 cyl.	.5 _____ 1.5 _____ 1.9 _____	
14-22	OUTSIDE REAR VIEW MIRROR — Install. — All Models	.3 _____	

OPERATION	DESCRIPTION	TIME	PRICE
ACCESSORIES — Continued			
14-23	RADIO ANTENNA — Install. — All Models	.9	_____
14-24	RADIO ANTENNA — Remove and Install. — All Models	.4	_____
14-25	RADIO ASSEMBLY — Install (installation initial). — Includes antenna and speaker installation. — All Models	2.3	_____
14-26	RADIO ASSEMBLY — Install. — All Models	1.4	_____
14-27	RADIO DIAL LIGHT BULB — Install. — All Models	1.0	_____
14-28	RADIO REAR SEAT SPEAKER — Install. — All Models	2.5	_____
14-29	RADIO RECEIVER — Remove and Install. — All Models	1.0	_____
14-30	RADIO SPEAKER ASSEMBLY — Install. — All Models	.3	_____
14-31	RADIATOR GRILLE GUARD — Install. — All Models	.5	_____
14-32	REAR BUMPER GUARD — Install. — All Models	.7	_____
14-33	REAR WINDOW WIPER — Install. — All Models	1.7	_____
14-34	SEAT COVERS — Install. Commodore Series — Broughams and Coupes Sedans Super Series — Broughams and Coupes Sedans	2.2 2.0 1.8 1.6	_____ _____ _____ _____
14-35	SPARE TIRE VALVE EXTENSION — Install. — All Models	.3	_____
14-36	SPOT LIGHT — Install. — All Models	1.0	_____
14-37	STEERING WHEEL KIT (DELUXE) — Remove and Install. All Models	.6	_____
14-38	UNDER SEAT HEATER — Install. — All Models	3.0	_____
14-39	UTILITY LIGHT KIT (3 UNITS) — Install. — All Models	1.5	_____
14-40	WEATHER CONTROL — COMPLETE UNIT — Install. All Models	2.3	_____
14-41	WEATHER CONTROL MOTOR — Remove and Install. All Models	1.3	_____
14-42	WEATHER CONTROL CORE — Remove and Install. All Models	1.5	_____
14-43	WHEEL TRIM RINGS KIT — Install. — All Models	.5	_____
14-44	WHITE SIDE WALL TIRES (Five) — Install. — All Models	1.7	_____
14-45	WINDOW VENT SHADES — Doors and Quarter Windows. All Models — Broughams and Coupes Sedans	.6 .9	_____ _____
14-46	WINDSHIELD WASHER — Install. — All Models	1.0	_____

OPERATION	DESCRIPTION	TIME	PRICE
FRAME AND SHEET METAL			
FENDERS AND DOOR MOULDING			
15-1	FRONT FRAME ASSEMBLY — Remove and Install. — Includes (only) removing engine frame from underbody. Breaking welds at #3 and #4 crossmembers and removing bolts at #4 crossmember and installing a new engine frame, welding and replacing bolts. — Does not include any engine or sheet metal work. — All Models	6.8	_____
15-2	FRONT FRAME #2 CROSSMEMBER — Remove and Install. —Includes disconnect lower support arms, removing shock absorbers, coil springs, five bolts each side of crossmember to engine frame and center steering arm bracket. — All Models	.2	_____
15-3	FRONT FRAME #3 CROSSMEMBER — Remove and Install. —Includes disconnect hand brake, removing bolts at rear engine supports and frame. All Models with Hydra-matic Transmissions	1.4	_____
15-4	FRONT FENDER — Remove and Install. — All Models — one side	3.3	_____
15-5	FRONT FENDER ORNAMENT — Remove and Install. Commodore Models	.3	_____
15-6	FRONT FENDER NAME PLATE — Remove and Install (one) . All 480-490 Models	.2	_____
15-7	FRONT FENDER SIDE DUST SHIELD — Remove and Install. All Models	.7	_____
15-8	FRONT FENDER SIDE DUST SHIELD EXTENSION — Remove and Install. All Models	.4	_____
15-9	FRONT FENDER MOULDING AND NAME PLATE—Remove and Install (one). 500 Series or "A" Series — All Models — Pacemakers	.5 .2	_____ _____
15-10	DOOR (UPPER) MOULDINGS — Remove and Install on any door. All Models	.2	_____
15-11	FRONT FENDER EXTENSION—Remove and. Install. — All Models	.6	_____
15-12	FRONT FENDER STONE GUARD — Remove and Install. All Models	.4	_____
15-13	REAR FENDER — Remove and Install. All Models — Sedans — Right Hand Sedans — Left Hand Broughams and Coupes — Right Hand Broughams and Coupes — Left Hand	2.3 2.5 3.2 3.4	_____ _____ _____ _____
15-14	REAR FENDER MOULDING AND ORNAMENT — Remove and Install (one) on 500 Series or "A" Series. — All Models	.3	_____
15-15	REAR FENDER GAS TANK FILLER DOOR—Remove and Install. All Models	.2	_____
15-16	GAS TANK FILLER DOOR SPRINGS (two) —Remove and Install All Models	.2	_____
15-17	GAS TANK FILLER NECK GROMMET — Remove and Install. All Models	.2	_____

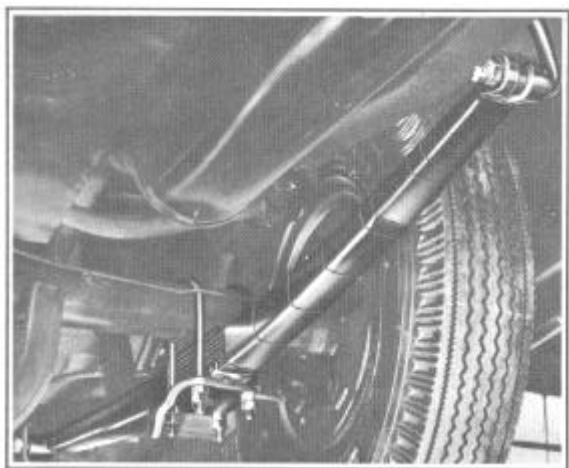
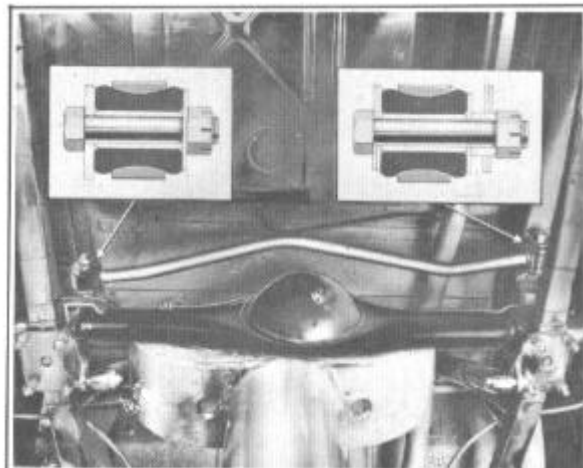
OPERATION	DESCRIPTION	TIME	PRICE
FRAME AND SHEET METAL — Continued			
15-18	REAR FENDER WATER BAFFLE AND DRAIN TROUGH — Remove and Install. — All Models — one side	1.8	_____
ROCKER PANELS AND MOULDINGS			
15-19	ROCKER PANEL — Remove and Install one. — All Models	.7	_____
	Moulding — "A" Series ("V" Type) — Remove and Install — All Models	.6	_____
	Moulding — All Other Models — Remove and Install .	.6	_____
15-20	ROCKER PANEL EXTENSION — Remove and Install one.		
	All Models	.3	_____
	Moulding — Remove and Install one — All Models	.1	_____
15-21	ROCKER PANEL LOWER MOULDING — Remove and Install one		
	All Models	.2	_____
15-22	FENDER (FRONT) LOWER MOULDING — Remove and Install one.		
	All Models	.2	_____
15-23	ROCKER PANEL UPPER AND LOWER MOULDING — Remove and Install one. — All Models	.3	_____
15-24	FENDER (REAR) LOWER MOULDING — Remove and Install one.		
	All Models	.2	_____
15-25	ROCKER PANEL (REAR) LOWER MOULDING—Remove and Install one.		
	All Models	.2	_____
15-26	REAR WHEEL COVER AND ROD ASSEMBLY — Remove and Install one.		
	All Models	.2	_____
15-27	REAR WHEEL COVER — UPPER MOULDING — Remove and Install one.		
	All Models	.4	_____
15-28	REAR WHEEL COVER — LOWER MOULDING — Remove and Install one.		
	All Models	.3	_____
15-29	DOOR SCUFF PLATE — Remove and Install. — Front or Rear.		
	All Models	.3	_____
HOOD			
15-30	HOOD — Remove and Install and Adjust. — All Models	.6	_____
15-31	HOOD — Adjust. — Includes adjusting lock lower support plate.		
	All Models	.4	_____
15-32	HOOD LOCK LOWER SUPPORT PLATE — Remove, Install and Adjust. All Models	.3	_____
15-33	HOOD LOCK — UPPER — Remove and Install. — All Models	.3	_____
15-34	HOOD PROP — Remove and Install — Right or Left.		
	All Models	.2	_____

OPERATION	DESCRIPTION	TIME	PRICE
FRAME AND SHEET METAL — Continued			
15-35	HOOD PROP SPRING — Remove and Install — Right or Left. All Models	.3	_____
15-36	HOOD HINGE — Remove and Install. — All Models	.9	_____
15-37	HOOD HINGE RETURN SPRING — Remove and Install. All Models	.9	_____
15-38	HOOD CONTROL KNOB AND WIRE ASSEMBLY — Remove and Install. All Models	.3	_____
15-39	HOOD CREST, LIGHT BULB OR LENS — Remove and Install All 480, 490 and 500 Models	.4	_____
15-40	HOOD CREST LIGHT BULB, SOCKET OR WIRE — Remove and Install. All "A" Series Models	.5	_____
15-41	HOOD LOUVRE (UPPER) Remove and Install — Right or Left All 480, 490 and 500 Series	.2	_____
15-42	HOOD LOUVRE (LOWER) Remove and Install — Right or Left. All 480, 490 and 500 Series	.3	_____
GRILLE			
15-43	GRILLE LOUVRE (UPPER) AND FENDER TIE PANEL COMPLETE ASSEMBLY — Remove and Install. All "A" Series Models	.6	_____
15-44	GRILLE LOUVRE (UPPER) Right or Left — Remove and Install. All "A" Series Models — Includes operation 15-40	.7	_____
15-45	GRILLE LOUVRE (CENTER) Right or Left—Remove and Install. With grille assembly removed. All "A" Series Models	.7	_____
15-46	GRILLE LOUVRE (LOWER) Right or Left — Remove and Install. With grille assembly removed. All "A" Series Models	.7	_____
15-47	GRILLE — LOWER SPLASH APRON — Remove and Install. — All "A" Series Models. With grille assembly removed With bumper removed	.3 .3	_____ _____
15-48	FENDER TIE PANEL AND HOOD LOCK LOWER SUPPORT— Remove and Install. — 480, 490 and 500 Models	.6	_____
15-49	RADIATOR GRILLE CENTER BAR (UPPER OR LOWER) — Remove and Install. — All 480-490 Models	.3	_____
15-50	GRILLE BAFFLE OR MOULDING — Remove and Install. — Center or Lower — Right or Left. All 480, 490 Models — one six	.2 .5	_____ _____

OPERATION	DESCRIPTION	TIME	PRICE
FRAME AND SHEET METAL — Continued			
15-51	GRILLE TO RADIATOR DEFLECTOR AND BAFFLE SUPPORT — Remove and Install. All 500 and "A" Series Models	1.1	_____
15-52	GRILLE COMPLETE ASSEMBLY — Remove and Install. —Includes removing and installing fender tie panel, hood crest, parking lights, and disassembling and replacing any louvre, baffle, lower splash apron or struts. All "A" Series Models	3.5	_____
15-53	PARKING LIGHTS — Remove and Install. All Series Models — one — two	.3 .5	_____ _____
15-54	GRILLE STRUT CAP — Remove and Install. All "A" Series — one — two With grille removed — two	.3 .5 .2	_____ _____ _____
15-55	GRILLE STRUT ASSEMBLY — Remove and Install. — With grille removed. All "A" Series Models	.2	_____
15-56	GRILLE STRUT CAP — Remove and Install. All 500 Series Models	.2	_____
15-57	GRILLE STRUT ASSEMBLY — Remove and Install. All 500 Series Models — one side — both sides Grille strut moulding (one only)	.7 1.1 .2	_____ _____ _____
15-58	GRILLE FRONT SPLASH GUARD AND MOULDING — Remove and Install. All 480 and 490 Models	.4	_____
15-59	GRILLE FRONT SPLASH GUARD, CENTER STRUTS AND MOULDING — Remove and Install. All 500 Series	.9	_____
15-60	GRILLE LOUVRES (LOWER) Right or Left — Remove and Install. 501, 502, 503, 504 Models	.6	_____
15-61	GRILLE MOULDING (LOWER) — Remove and Install. 500 Model only	.3	_____
15-62	GRILLE MOULDING — UPPER OR INTERMEDIATE — Right or Left — Remove and Install. 500 Series	.4	_____
15-63	GRILLE BAFFLE — UPPER, INTERMEDIATE OR LOWER — Remove and Install. All 500 Series	.6	_____
15-64	COWL VENTILATOR ASSEMBLY — Remove and Install. All Models	.8	_____

OPERATION	DESCRIPTION	TIME	PRICE
BUMPERS			
16-1	FRONT BUMPER ASSEMBLY — Remove and Install. All Models	.6	_____
16-2	FRONT BUMPER IMPACT BAR — Remove and Install. All Models	.8	_____
16-3	FRONT BUMPER TO FRAME BRACKET — Remove and Install. All Models	.6	_____
16-4	FRONT BUMPER GUARD ASSEMBLY (INNER) — Remove and Install. All Models — right or left	.3	_____
16-5	FRONT OR REAR BUMPER GUARD — Remove and Install. All Models — right or left hand	.3	_____
16-6	FRONT BUMPER LICENSE GUARD (LOWER) — Remove and Install. All Models	.2	_____
16-7	FRONT BUMPER LICENSE GUARD (UPPER) — Remove and Install. All Models	.3	_____
16-8	REAR BUMPER ASSEMBLY — Remove and Install. — All Models	.7	_____
16-9	REAR BUMPER IMPACT BAR — Remove and Install. All Models	.5	_____
16-10	REAR BUMPER GUARD AND LICENSE LIGHT — Remove and Install. 500 Model Commodores — one	.6	_____
16-11	REAR BUMPER STONE GUARD — Remove and Install. All Models	.3	_____
16.12	REAR LICENSE PLATE BRACKET ASSEMBLY — Remove and Install. All Models	.2	_____
REAR SUSPENSION			
17-1	REAR SPRING — Remove and Install. All Models — one two	1.4 2.3	_____ _____
17-2	REAR SPRING COVER (METAL) — Remove and Install. All Models — one spring two springs	2.0 3.6	_____ _____
17-3	REAR SPRING LEAF — Remove and Install. All Models — one spring two springs	2.2 3.8	_____ _____
17-4	REAR SPRING SHACKLE AND/OR BUSHING — Remove and Install. All Models — one spring two springs	.4 .8	_____ _____

OPERATION	DESCRIPTION	TIME	PRICE
REAR SUSPENSION — Continued			
17-5	REAR SPRING (FRONT) BUSHING OR PIN — Remove and Install. All Models — one spring two springs	.5 _____ .9 _____	
17-6	REAR SPRING MOUNTING CLIPS — Remove and Install. All Models — one spring two springs	.6 _____ 1.1 _____	
17-7	REAR SPRING MOUNTING CLIPS (TIGHTEN). — All Models	.4 _____	

**REAR SPRING MOUNTING****REAR STABILIZER MOUNTING**

17-8	SPRING SHACKLE BUSHINGS AND SPRING CLIPS — Tighten both. All Models	.6 _____	
17-9	REAR SPRINGS — Remove and Install — both. — Replace shackle bushings and shackle "U" bolts and lubricate. — All Models	3.5 _____	
17-10	REAR SPRING REMOVAL AND LUBRICATION — Remove and Install. — Includes springs, spring covers, cleaning springs and lubrication. — All Models — two	4.1 _____	
17-11	REAR SHOCK ABSORBERS AND/OR RUBBER BUSHINGS — Remove and Install. All Models — one two	.5 _____ .9 _____ .8 _____	
17-12	REAR STABILIZER AND/OR RUBBER BUSHINGS — Remove and Install. All Models		

FUEL SYSTEM

18-1	CARBURETOR ASSEMBLY — Remove and Install. — All Models	.4 _____	
18-2	CARBURETOR ASSEMBLY — OVERHAUL. — When removed from engine.	2.0 _____	

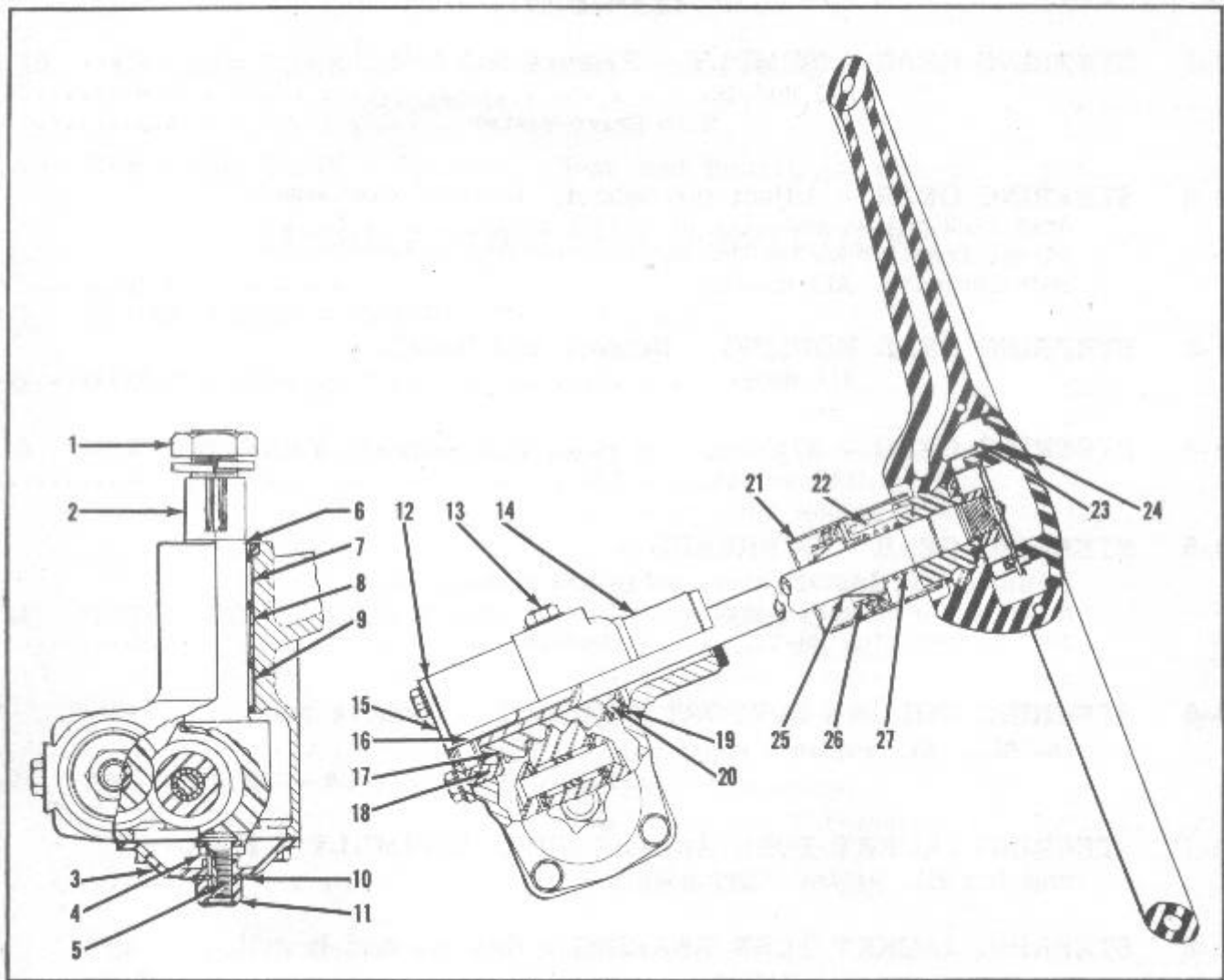
OPERATION	DESCRIPTION	TIME	PRICE
FUEL SYSTEM — Continued			
18-3	CARBURETOR ASSEMBLY — Remove and Install. — Includes disassembly and assembly, clean and overhaul, replace necessary parts and adjust. — All Models	2.4	_____
18-4	CARBURETOR ASSEMBLY — CHECK WITH VACUUM GAUGE All Models	.3	_____
18-5	CARBURETOR FLOAT OR NEEDLE VALVE—Remove and Install. Includes adjusting float level, remove and install carburetor. All Models	.6	_____
18-6	CARBURETOR AUTOMATIC CHOKE — Remove and Install. Includes cleaning and overhaul. — All Models	.7	_____
18-7	CARBURETOR AIR CLEANER — Remove and Install. All Models — oil bath refill dry clean	.4 .2	_____ _____
18-8	CARBURETOR TO EXHAUST MANIFOLD HEAT TUBE — Remove and Install. All Models — 8 cyl.	.3	_____
18-9	CARBURETOR IDLE PORT PLUGS AND METERING RODS — Install. — All Models	.5	_____
18-10	STANDARD FUEL PUMP AND/OR GASKET — Remove and Install. All Models — 6 cyl. 8 cyl.	.6 1.4	_____ _____
18-11	STANDARD FUEL PUMP — OVERHAUL—When removed from car. All Models	.8	_____
18-12	COMBINATION FUEL PUMP AND/OR GASKET — Remove and Install. All Models — 6 cyl. 8 cyl.	.7 1.5	_____ _____
18-13	COMBINATION FUEL PUMP — OVERHAUL — When removed from car. All Models	1.0	_____
18-14	FUEL PUMP SEDIMENT BOWL AND SCREEN — Remove, Clean and Install. All Models	.4	_____
18-15	FUEL PUMP FLEXIBLE HOSE — Remove and Install. All Models	.4	_____
18-16	GAS LINE, FUEL PUMP TO TANK — Remove and Install.	.7	_____
18-17	GAS LINE, FUEL PUMP TO CARBURETOR—Remove and Install. All Models	.2	_____
18-18	GASOLINE GAUGE DASH UNIT — Remove and Install. 480-490 Models — 500 Series	.7	_____
18-19	GASOLINE TANK GAUGE — Remove and Install. — All Models .	.6	_____
18-20	GASOLINE TANK — Remove, Clean and Install. — All Models	1.8	_____

LUBRICATION AND INSPECTION

19-1	LUBRICATION — COMPLETE. — All Models	.7	_____
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OPERATION	DESCRIPTION	TIME	PRICE
FUEL SYSTEM — Continued			
19-2	VACUUM CLEAN CAR. — All Models	.2	_____
19-3	PRE-DELIVERY INSPECTION AND ADJUSTMENTS. All 6 cylinder Models All 8 cylinder Models	4.8 5.1	_____ _____
19-4	1,000 MILE INSPECTION AND ADJUSTMENT. All 6 cylinder Models All 8 cylinder Models	2.0 2.1	_____ _____
19-5	2,000 MILE INSPECTION AND ADJUSTMENT. All 6 cylinder Models All 8 cylinder Models	4.0 4.9	_____ _____
19-6	CLUTCH — Drain, Flush and Refill. — All Models	.4	_____
19-7	DIFFERENTIAL — Drain, Flush and Refill. — All Models	.4	_____
19-8	FRONT WHEEL BEARINGS — Remove, Clean, Repack, Install and Adjust. All Models	.6	_____
19-9	REAR WHEEL BEARINGS — Remove, Clean, Repack, Install and Adjust. All Models	1.7	_____
19-10	REAR SPRINGS — LUBRICATE. All Models — one spring two springs	.3 .5	_____ _____
19-11	STEERING GEAR — LUBRICATE. — All Models	.3	_____
19-12	TRANSMISSION — Drain, Flush and Refill (Standard Transmission)	.4	_____
19-13	TRANSMISSION — Drain and Refill (Hydramatic)	.7	_____
19-14	VACUOTIVE DRIVE POWER CYLINDER—Fill with one ounce of shock absorber fluid. — 480-490 Models	.3	_____
STEERING			
20-1	STEERING GEAR ASSEMBLY — Remove and Install. All Models With Drive-Master	3.9 4.2	_____ _____
20-2	STEERING GEAR — Adjust throughout. — Includes disconnect drag link, adjust end play of sector shaft, adjust front wheel toe-in, set gear on high spot and lubricate. — All Models	1.6	_____
20-3	STEERING GEAR HOUSING — Remove and Install. — All Models	.7	_____
20-4	STEERING GEAR — Tighten (To frame side member) . All Models	.3	_____
20-5	STEERING GEAR — OVERHAUL ON BENCH. — Includes disassemble and reassemble, renew any necessary parts and adjust.—Add to operation 20-1. — All Models	1.2	_____
20-6	STEERING COLUMN SUPPORT BRACKET—Remove and Install. All Models — upper half lower half	.2 .6	_____ _____
20-7	STEERING JACKET TUBE AND BEARING ASSEMBLY — Remove and Install. — All Models	1.2	_____

OPERATION	DESCRIPTION	TIME	PRICE
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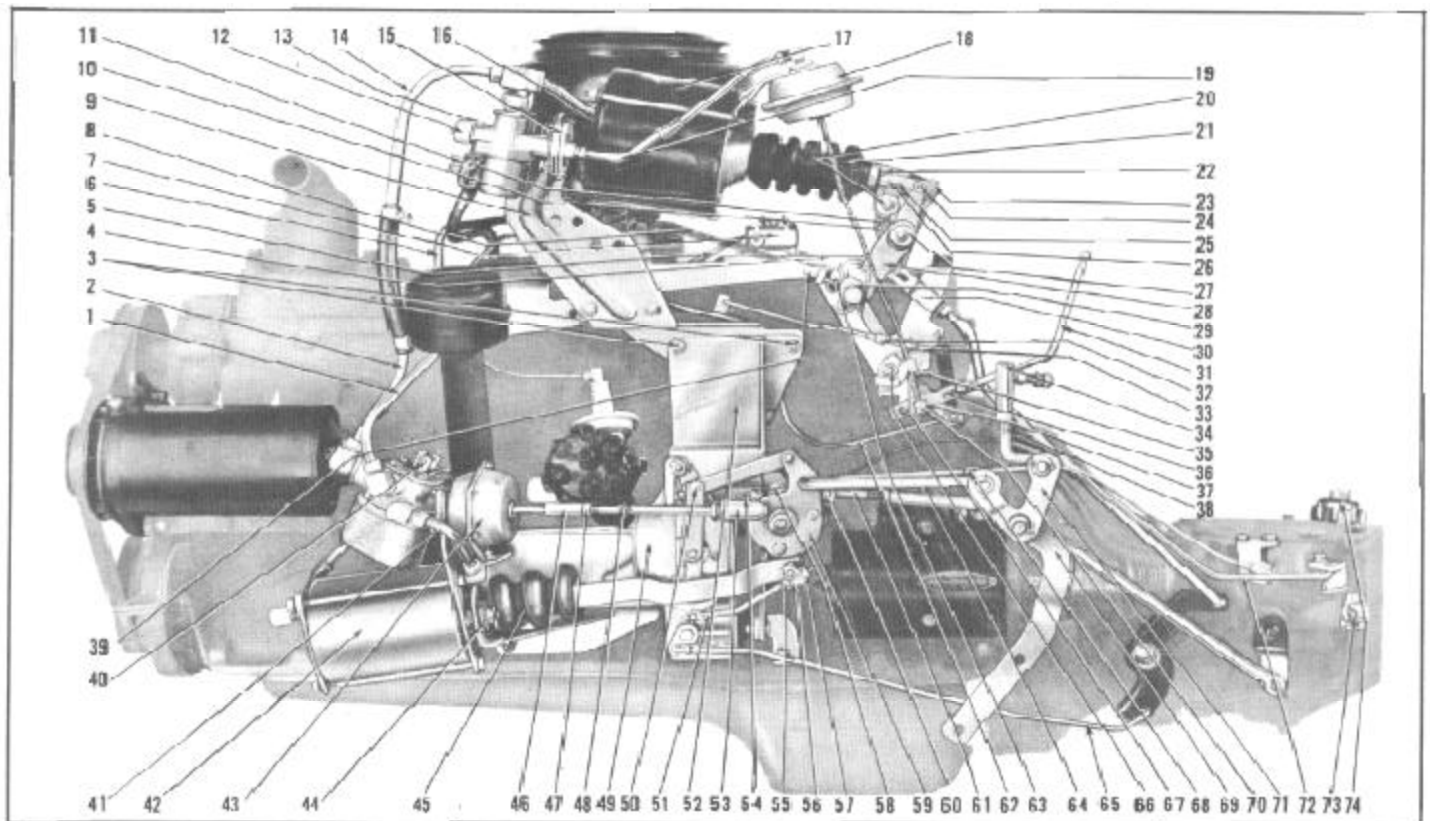


Steering Gear

- | | | | |
|-----|------------------------------|-----|------------------------------------|
| 1. | Gear shaft nut | 15. | Worm shaft cover |
| 2. | Gear shaft | 16. | Grease retainer tube |
| 3. | Gear shaft cover | 17. | Worm shaft lower bearing |
| 4. | Adjusting screw thrust plate | 18. | Worm shaft lower bearing cup |
| 5. | Adjusting screw | 19. | Worm shaft upper bearing cup |
| 6. | Oil retainer | 20. | Worm shaft upper bearing |
| 7. | Needle bearing | 21. | Jacket tube |
| 8. | Spacer | 22. | Direction indicator cancelling pin |
| 9. | Needle bearing | 23. | Horn button contact cup |
| 10. | Adjusting screw lock plate | 24. | Horn button |
| 11. | Adjusting screw lock nut | 25. | Jacket tube bearing spacer |
| 12. | Worm cover shims | 26. | Jacket tube bearing |
| 13. | Oil filler plug | 27. | Jacket tube spring |
| 14. | Main column tube | | |

OPERATION	DESCRIPTION	TIME	PRICE
STEERING — Continued			
20-8	STEERING JACKET TUBE BEARING — Remove and Install. All Models	.8	_____
20-9	STEERING GEAR SECTOR SHAFT — Remove and Install. All Models With Drive-Master (includes adjustment) To replace oil seal — Add	1.3 2.7 .2	_____ _____ _____
20-10	STEERING GEAR SECTOR SHAFT— Adjust end play. All Models	.6	_____
20-11	STEERING GEAR WORM AND TUBE ASSEMBLY — Remove and Install. — Includes adjustment. All Models With Drive-Master With steering gear removed	5.1 5.4 1.2	_____ _____ _____
20-12	STEERING WHEEL — Remove and Install. — All Models	.6	_____
20-13	STEERING WHEEL — TIGHTEN ONLY. — All Models	.3	_____
20-14	STEERING WHEEL HORN RING OR HORN BUTTON — Remove and Install. All Models	.2	_____
20-15	STEERING PITMAN ARM — Remove and Install. All Models With Drive-Master	.7 2.0	_____ _____
VACUMOTIVE DRIVE			
21-1	VACUMOTIVE DRIVE — Install on cars not so equipped. All 480 and 490 Models	3.8	_____
21-2	VACUMOTIVE DRIVE — Adjust and Lubricate. All 480 and 490 Models	.6	_____
21-3	VACUMOTIVE POWER CYLINDER — Remove and Install. — Includes adjusting. — All 480 and 490 Models	1.8	_____
21-4	VACUMOTIVE POWER CYLINDER — Overhaul. — Includes removing and installing and adjusting. — All 480-490 Models	2.6	_____
21-5	MOUNTING BRACKET — Remove and Install. All 480 and 490 Models	.8	_____
21-6	SOLENOID VALVE AND/OR GASKET — Remove and Install. All 480 and 490 Models	.3	_____
21-7	BELLCRANK— Remove and Install. — All 480 and 490 Models	1.0	_____
21-8	VALVE LEVER OR COMPENSATOR LEVER—Remove and Install. All 480 and 490 Models	.8	_____
21-9	VALVE LEVER CAM — Remove and Install. All 480 and 490 Models	.2	_____
21-10	VALVE LEVER CAM PIVOT — Remove and Install. All 480 and 490 Models	.4	_____
21-11	BELLCRANK TO COUPLING LEVER ROD AND/OR PLAY LINK — Remove, Install and Adjust. — All 480 and 490 Models	1.2	_____

OPERATION	DESCRIPTION	TIME	PRICE
VACUMOTIVE DRIVE — Continued			
21-12	COMPENSATOR TRIP LEVER SPRING — Remove and Install. All 480 and 490 Models	.7	_____
21-13	PISTON ROD BOOT — Remove and Install. All 480 and 490 Models	.9	_____
21-14	PISTON ROD END, PIN AND/OR LINK — Remove and Install All 480 and 490 Models	.3	_____
21-15	ACCELERATOR CROSS SHAFT AND LEVER ASSEMBLY — Remove, Install and Adjust. — All 480 and 490 Models	.8	_____
21-16	VALVE LEVER CAM THREADED SLEEVE ROD ASSEMBLY — Remove, Install and Adjust. — All 480 and 490 Models	.3	_____
21-17	INSTRUMENT PANEL SWITCH — Remove and Install. All 480 and 490 Models	.3	_____
21-18	SHIFT RAIL SWITCH — Remove and Install. All 480 and 490 Models	.3	_____
21-19	GOVERNOR SWITCH AND/OR PINION — Remove and Install All 480 and 490 Models	.4	_____
21-20	ACCELERATOR SWITCH — Remove, Install and Check Adjustment. All 480 and 490 Models	.4	_____
21-21	VACUMOTIVE WIRE HARNESS CHECK. — All 480 and 490 Models With Overdrive — Add	.5 .2	_____ _____



DRIVE-MASTER — ALL MODELS

OPERATION	DESCRIPTION	TIME	PRICE
DRIVE-MASTER			
22-1	DRIVE -MASTER ADJUSTMENT - Includes bell crank yoke, clutch power cylinder piston travel, cushion point test for clutch engagement, throttle lock cable, power cylinder rod, transfer diaphragm rod, check for free movement at throttle linkage, throttle cross rod, shift shaft transfer key ball socket, check all rod retainer clips, wire terminals, transmission switch boot, governor switch boot, position remote control shift lever and tighten set screw in transfer key hub, check all vacuum line connections and hoses. All Models	.9	
22-2	DRIVE -MASTER CHECK-UP - With test lamp and test harness. All Models	1.5	

DRIVE-MASTER LEGEND

1. Power Unit Air Intake Pipe Assy.	38. Bellcrank Rod and Ball Joint Assy.
2. Power Unit Vacuum Pipe Assy.	39. Valve Lever Cam Adjusting Screw Nut
3. Power Unit Mounting Bracket Studs	40. Transfer Diaphragm Solenoids
4. Clutch Unit Bellcrank Bracket Assy.	41. Solenoids to Power Cylinder Tube Assy.
5. Accelerator Switch to Cross Shaft Rod	42. Power Cylinder Assembly
6. Power Unit to Air Cleaner Pipe Assy.	43. Transfer Diaphragm Assembly
7. Accelerator Switch	44. Power Cylinder Mounting Stud
8. Clutch Power Cylinder Tension Spring	45. Power Cylinder Piston Guard
9. Clutch Power Unit Mounting Bracket	46. Transfer Diaphragm and Rod Assy.
10. Clutch Unit Compensator Trip Lever	47. Transfer Rod Lock Nut
11. Clutch Unit Compensator Lever Spring	48. Transfer Diaphragm Engaging Rod Assy.
12. Clutch Unit Solenoid Valve Assy.	49. Transmission Control Switch Assy.
13. Throttle Lock Solenoid Valve Assy.	50. Selector Switch Lever
14. Solenoid to Power Shift Pipe Assy.	51. Neutral and Limit Switch Rod Assy.
15. Clutch Power Unit Solenoid Gasket	52. Power Unit Mounting Bracket Assy.
16. Vacuum Pipe Assy.	53. Transfer Rod Ball Joint
17. Clutch Power Unit Cylinder Assembly	54. Transfer Key
18. Throttle Lock Diaphragm Cylinder Assy.	55. Neutral and Limit Switch Rod Lock Nut
19. Throttle Lock Solenoid Tube Assy.	56. Neutral and Limit Switch Trunnion Block
20. Clutch Unit Compensator Lever Shaft	57. Neutral and Limit Switch Rod Lock Nut
21. Clutch Power Unit Piston Rod Guard	58. Shift Shaft Transfer Key, Hub Assy.
22. Clutch Power Unit Piston Rod Assy.	59. Shift Shaft (Hand Shift) Lever Assy.
23. Clutch Unit piston Rod Pivot Bolt	60. Shift Rod to Power Shift Lever pin
24. Clutch Unit Piston Valve Link Pin	61. Transmission Shift Rod Assembly
25. Clutch Unit Piston Valve Link	62. Accelerator Cross Shaft Operating Rod
26. Clutch Unit piston Valve, Rod Assy.	63. Valve Lever Cam Adjusting Screw
27. Clutch Power Unit Valve Lever Bushing	64. Bellcrank to Shift Shaft Lever Rod
28. Clutch Unit Bellcrank and Compensator Assy.	65. Off-On Switch Operating Rod
29. Valve Lever Cam	66. Accelerator Link Bellcrank Shaft
30. Bellcrank to Clutch Coupling Lever Rod	67. Throttle Lock Diaphragm Rod Swivel
31. Accelerator Pedal to Bellcrank Rod Assy.	68. Cross-Over Switch Rod Clip
32. Threaded Sleeve Rod Swivel	69. Hand Shift Bellcrank Support
33. Threaded Sleeve Rod Assy.	70. Throttle Lock Cable Lock Nut
34. Control Lever to Bellcrank Rod Ball Joint	71. Hand Shift Bellcrank
35. Accelerator Pedal Link Bellcrank Stop	72. Cross-Over Switch Rod
36. Accelerator Pedal Link Bellcrank Bracket	73. Shift Rail Switch
37. Throttle Lock Diaphragm Rod Check Nut	74. Governor Switch

OPERATION	DESCRIPTION	TIME	PRICE
DRIVE-MASTER — Continued			
22-3	POWER CYLINDER ASSEMBLY — Remove, Install and Adjust. All Models	1.0	_____
22-4	POWER CYLINDER SOLENOID VALVES AND TRANSFER DIAPHRAGM — Remove and Install. — All Models	1.3	_____
22-5	TRANSFER DIAPHRAGM — Install. — All Models	.5	_____
22-6	POWER CYLINDER MOUNTING BRACKET — Remove and Install. — Includes removing, replacing and adjustment. — All Models	2.6	_____
22-7	TRANSFER DIAPHRAGM ENGAGING ROD AND/OR ROD END AND SLEEVE — Remove, Install and Adjust. — All Models.	.3	_____
22-8	TRANSFER DIAPHRAGM ENGAGING ROD RUBBER BOOT — Remove and Install. — All Models	.4	_____
22-9	POWER UNIT SHIFT STRAP — Remove and Install. — All Models If necessary to replace bushing — Add	.5 .1	_____ _____
22-10	POWER CYLINDER BOOT — Remove and Install. — All Models	.6	_____
22-11	VACUUM LINE OR ELBOW — Remove and Install — one. All Models	.3	_____
22-12	SHIFT SHAFT — Remove and Install. — All Models	.5	_____
22-13	SHIFT SHAFT TRANSFER KEY AND/OR PIN — Remove and Install. — All Models	.4	_____
22-14	SHIFT SHAFT TRANSFER KEY HUB AND/OR BUSHING — Remove and Install. — All Models	.7	_____
22-15	SHIFT SHAFT POWER LEVER STOP AND LOCK SCREW — Remove and Install. — All Models	.4	_____
22-16	22-16 SHIFT SHAFT HAND SHIFT LEVER — Remove and Install. All Models If necessary to replace bushing	.7 .2	_____ _____
22-17	SHIFT SHAFT POWER SHIFT LEVER — Remove and Install. All Models If necessary to replace bushing — Add	.7 .2	_____ _____
22-18	SHIFT SHAFT LEVER DETENT BALL AND/OR SPRING — Remove and Install. — All Models	1.0	_____
22-19	DRIVE-MASTER TO REMOTE CONTROL TUBE BELLCRANK ROD ASSEMBLY AND/OR BALL JOINT — Remove and Install. — All Models	.2	_____
22-20	DRIVE-MASTER TRANSMISSION SWITCH—Remove, Install and Adjust. — All Models	1.8	_____
22-21	POWER CYLINDER SHIFT STRAP — Remove and Install. All Models	.2	_____
22-22	SELECTOR SWITCH OPERATING ROD OR TRANSFER SWITCH OPERATING ROD — Remove and Install. — All Models	.3	_____

OPERATION	DESCRIPTION	TIME	PRICE
DRIVE-MASTER — Continued			
22-23	GOVERNOR SWITCH AND/OR PINION — Remove and Install. All Models	.3	_____
22-24	NEUTRAL AND LIMIT SWITCH ROD ASSEMBLY — Remove, Install and Adjust. — All Models	.4	_____
22-25	CLUTCH SWITCH OPERATING ROD OR DRIVE-MASTER TRANSMISSION SHIFT ROD — Remove and Install. — All Models.	.3	_____
22-26	THROTTLE LOCK DIAPHRAGM CYLINDER — Remove and Install. All Models	.3	_____
22-27	THROTTLE LOCK DIAPHRAGM — Remove and Install. All Models	.4	_____
22-28	THROTTLE LOCK SOLENOID — Remove and Install. All Models	.2	_____
22-29	SHIFT RAIL SWITCH — Remove and Install. — All Models	.4	_____
22-30	ACCELERATOR SWITCH — Remove, Install and Adjust. All Models	.4	_____
22-31	INSTRUMENT PANEL SWITCH — Remove and Install. All Models	.3	_____
22-32	DRIVE-MASTER WIRE HARNESS CHECK. — All Models With Overdrive	.9 1.2	_____ _____
22-33	DRIVE-MASTER WIRE HARNESS — Remove and Install. All 480, 490 and 500 Models With Drive-Master and Overdrive — All 480 and 490 Models All 500 Series and "A" Series Models	.8 1.8 2.5	_____ _____ _____
HYDRA-MATIC TRANSMISSION			
23-1	HYDRA-MATIC TRANSMISSION — Remove and Install. All Models To remove and replace torus members or cover — Add	4.3 .5	_____ _____
23-2	HYDRA-MATIC TRANSMISSION — Overhaul. — Includes remove, install, disassembly, inspections and reassembly (by units). All Models	8.3	_____
23-3	TRANSMISSION ASSEMBLY — Overhaul. — Includes remove and install, disassembly, inspection of each individual unit of transmission and adjustments. — All Models	12.3	_____
23-4	HYDRA-MATIC TRANSMISSION — Drain and Refill. — All Models	.7	_____
23-5	HYDRA-MATIC TRANSMISSION — #3 Frame Crossmember — Remove and Install. — All Models	1.4	_____
23-6	TRANSMISSION ASSEMBLY — Inspection. Includes remove and install oil pan, inspect drums and rear pump drive gear, oil pan for metal shavings — does not include any other disassembly. NOTE: Cancel this operation if other work is authorized. All Models	1.5	_____

OPERATION	DESCRIPTION	TIME	PRICE
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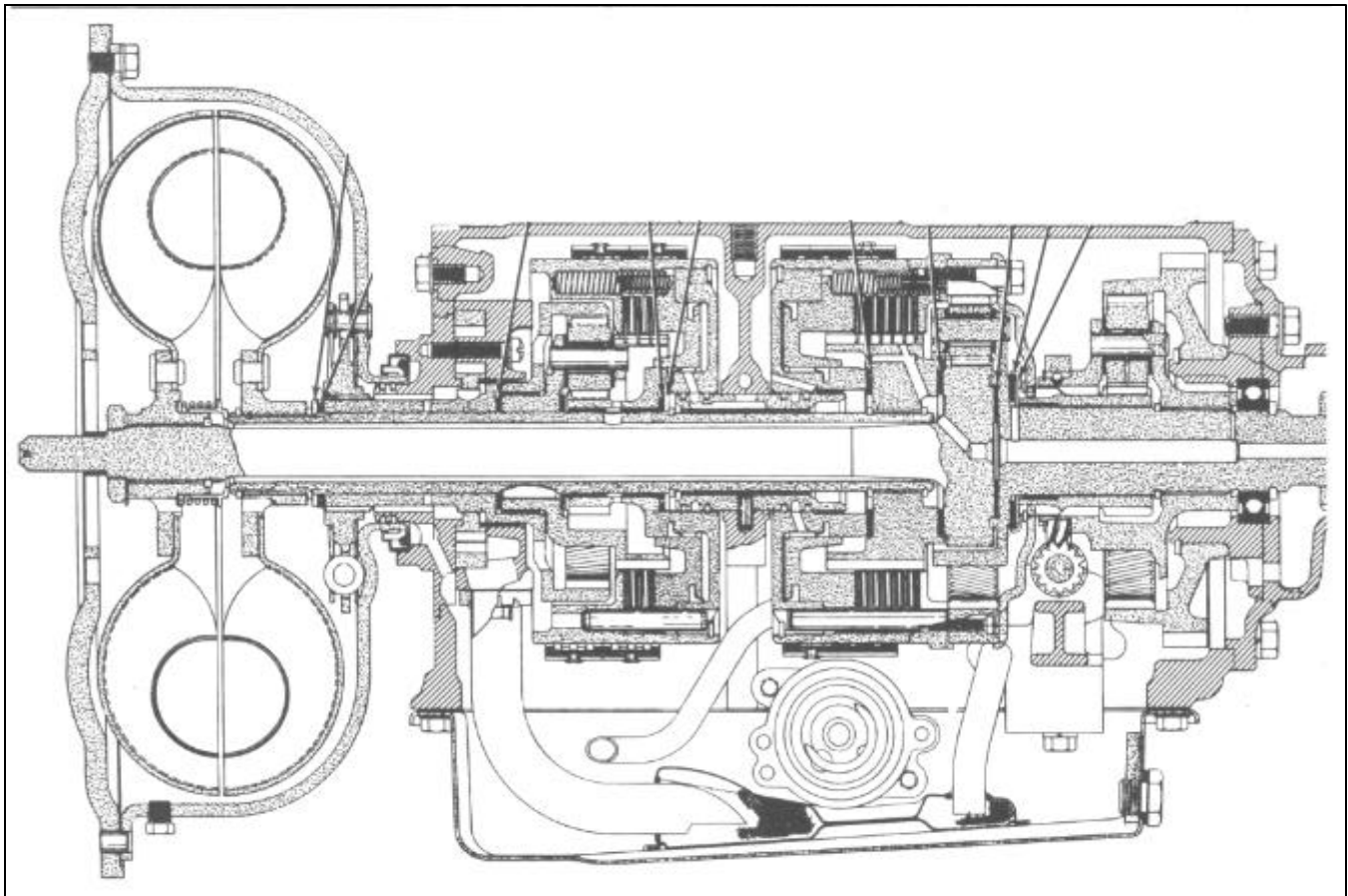
HYDRA-MATIC—Continued

FLYWHEEL AND HOUSING

23-7	REMOVE AND INSTALL FLYWHEEL. — When transmission is removed. All Models	.5	_____
23-8	REMOVE AND INSTALL FLYWHEEL HOUSING. — When transmission is removed. — All Models	.7	_____
23-9	REMOVE AND INSTALL MAINSHAFT BUSHING. — When transmission is removed. — All Models	.7	_____
23-10	REMOVE AND INSTALL FLYWHEEL HOUSING. — Includes remove and install transmission, torus members, torus cover and aligning and dowing flywheel housing to engine support plate. — All Models	5.1	_____

REGULATOR VALVE, OIL PUMPS AND GOVERNOR

23-11	OIL PRESSURE CHECK. — Includes remove and install floor mat and inspection hole cover. — All Models	.6	_____
23-12	OIL PRESSURE REGULATOR VALVE BODY SPRING AND/OR PLUNGER — Remove and Install. — Includes remove and install floor board. All Models	1.5	_____



HYDRA-MATIC TRANSMISSION

OPERATION	DESCRIPTION	TIME	PRICE
HYDRA-MATIC—Continued			
23-13	FRONT OIL PUMP ASSEMBLY — Remove and Install. — Includes making necessary adjustments. — All Models	5.7	_____
23-14	FRONT OIL PUMP ASSEMBLY — OVERHAUL. — Includes remove and install transmission and necessary adjustments. — All Models	6.4	_____
23-15	REAR OIL PUMP AND GOVERNOR ASSEMBLY — Remove and Install. — Includes making necessary adjustments. — All Models	2.0	_____
23-16	REAR OIL PUMP ASSEMBLY AND GOVERNOR OVERHAUL. — Includes clean side cover and oil pan, remove and install valve body and reverse anchor, replace any necessary parts in rear pump and governor, reinstall and check governor run out, and adjust reverse anchor. — All Models	3.1	_____
23-17	TRANSMISSION BOTTOM OIL PAN AND / OR GASKET — Remove and Install. — All Models Side cover and/or gasket — All Models	.7 .7	_____ _____
23-18	FRONT PUMP COVER OIL SEAL — Replace. — Includes remove and install transmission. — All Models	5.4	_____
23-19	TRANSMISSION OIL PUMP ASSEMBLIES (FRONT AND REAR) — Overhaul. — Includes remove and install transmission and disassembly and reassembly of both pumps and governor, cleaning oil pan and making necessary adjustments. — All Models	9.5	_____
23-20	TRANSMISSION GOVERNOR — Overhaul. — Includes remove and install side cover, valve body and governor, replace necessary parts and check governor runout. — All Models	2.6	_____
CONTROL VALVE			
23-21	CONTROL VALVE ASSEMBLY — Remove and Install. — Includes remove and install valve body and adjusting manual and throttle lever linkage. — All Models	2.6	_____
23-22	CONTROL VALVE ASSEMBLY — OVERHAUL. — Includes check oil pressure, adjust control linkage and neutral safety switch. All Models	.9	_____
23-2	REAR OIL SEAL — Remove and Install. — All Models	1.8	_____
PLANETARY UNITS			
23-24	TRANSMISSION CLUTCH PLATE ASSEMBLIES — Overhaul. — Includes removal, disassembly, assembly and installing transmission, and making necessary adjustments. — All Models	9.1	_____
23-25	INTERMEDIATE SHAFT — Remove and Install. — Includes remove, disassemble, assemble and reinstall transmission and make necessary adjustments, does not include disassembly of any units.—All Models	8.8	_____
23-26	FRONT PLANETARY UNIT DRIVE GEAR — Remove and Install. Includes remove and install transmission and servo units and adjusting servos. — All Models	8.5	_____

OPERATION	DESCRIPTION	TIME	PRICE
HYDRA-MATIC—Continued			
23-27	REVERSE GEAR ANCHOR BRACKET AND/OR BELLCRANK — Remove and Install. — Includes checking backlash. — All Models	2.5	_____
23-28	REVERSE GEAR ASSEMBLY — OVERHAUL. — Includes remove and install side cover and oil pan, rear pump and governor assembly All Models	7.3	_____
SERVOS			
23-29	SERVO — FRONT OR REAR — Remove and Install. — Includes remove and install the bottom oil pan and adjustment of both servos. All Models	1.7	_____
23-30	SERVO — FRONT — OVERHAUL. — Includes remove, install, cleaning bottom oil pan and install new gasket and adjust both servos. All Models	2.0	_____
23-31	SERVO — REAR — OVERHAUL. — Includes remove, install, cleaning bottom oil pan and install new gasket and adjust both servos. All Models	2.0	_____
23-32	SERVOS (BOTH) OVERHAUL. — Includes remove, install and adjust, cleaning bottom oil pan and install new gasket. — All Models	2.5	_____
23-33	SERVO BANDS — Replace one or both. Includes remove and install transmission and units necessary to enable band replacement and adjustment of band. — All Models	8.1	_____
SHIFT CONTROL LEVER			
23-34	REMOTE CONTROL. SHIFT LEVER — Remove and Install. All Models	.3	_____
23-35	REMOTE CONTROL SHIFT LEVER AND HOUSING. — Includes remove and install steering wheel and setting quadrant with selector switch. All Models	2.3	_____
ADJUSTMENTS			
23-36	ENGINE IDLE SPEED ADJUSTMENT. — All Models	.1	_____
23-37	THROTTLE LINKAGE ADJUSTMENT. Lever at transmission — All Models Lever at engine	.4 .1	_____ _____
23-38	SHIFTER ROD ADJUSTMENT. — All Models	.2	_____
23-39	NEUTRAL LIMIT SWITCH ADJUSTMENT. — All Models	.1	_____
23-40	EXTERNAL BAND ADJUSTMENT (WITH GAUGE). All Models	.6	_____
23-41	INTERNAL BAND ADJUSTMENT. — All Models	1.3	_____

OPERATION	DESCRIPTION	TIME	PRICE
HYDRA-MATIC—Continued			
23-42	CHECK OIL LEVEL AND BAND ADJUSTING SCREWS. All Models	.2	_____
23-43	CHECK FOR OIL LEAKS. — All Models	.2	_____
23-44	ROAD TEST. — All Models	.6	_____
23-45	CHECK MANUAL CONTROL AND THROTTLE CONTROL ADJUSTMENTS. — All Models	.2	_____
23-46	SERVOS — ADJUST FRONT AND REAR. — All Models	.4	_____

NOTES

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CONVERSION TABLE

	\$ 2.50	\$ 2.75	\$ 3.00	\$ 3.25	\$ 3.50	\$ 3.75	\$ 4.00
.1	.25	.28	.30	.33	.35	.38	.40
.2	.50	.55	.60	.65	.70	.75	.80
.3	.75	.83	.90	.98	1.05	1.13	1.20
.4	1.00	1.10	1.20	1.30	1.40	1.50	1.60
.5	1.25	1.38	1.50	1.63	1.75	1.88	2.00
.6	1.50	1.65	1.80	1.95	2.10	2.25	2.40
.7	1.75	1.93	2.10	2.28	2.45	2.63	2.80
.8	2.00	2.20	2.40	2.60	2.80	3.00	3.20
.9	2.25	2.48	2.70	2.93	3.15	3.38	3.60
1.0	2.50	2.75	3.00	3.25	3.50	3.75	4.00
1.1	2.75	3.03	3.30	3.58	3.85	4.13	4.40
1.2	3.00	3.30	3.60	3.90	4.20	4.50	4.80
1.3	3.25	3.58	3.90	4.23	4.55	4.88	5.20
1.4	3.50	3.85	4.20	4.55	4.90	5.25	5.60
1.5	3.75	4.13	4.50	4.88	5.25	5.63	6.00
1.6	4.00	4.40	4.80	5.20	5.60	6.00	6.40
1.7	4.25	4.68	5.10	5.53	5.95	6.38	6.80
1.8	4.50	4.95	5.40	5.85	6.30	6.75	7.20
1.9	4.75	5.23	5.70	6.18	6.65	7.13	7.60
2.0	5.00	5.50	6.00	6.50	7.00	7.50	8.00
2.1	5.25	5.78	6.30	6.83	7.35	7.88	8.40
2.2	5.50	6.05	6.60	7.15	7.70	8.25	8.80
2.3	5.75	6.23	6.90	7.48	8.05	8.63	9.20
2.4	6.00	6.60	7.20	7.80	8.40	9.00	9.60
2.5	6.25	6.88	7.50	8.13	8.75	9.38	10.00
2.6	6.50	7.15	7.80	8.45	9.10	9.75	10.40
2.7	6.75	7.43	8.10	8.78	9.45	10.13	10.80
2.8	7.00	7.70	8.40	9.10	9.80	10.50	11.20
2.9	7.25	7.98	8.70	9.43	10.15	10.88	11.60
3.0	7.50	8.25	9.00	9.75	10.50	11.25	12.00
3.1	7.75	8.53	9.30	10.08	10.85	11.63	12.40
3.2	8.00	8.80	9.60	10.40	11.20	12.00	12.80
3.3	8.25	9.08	9.90	10.73	11.55	12.38	13.20
3.4	8.50	9.35	10.20	11.05	11.90	12.75	13.60
3.5	8.75	9.63	10.50	11.38	12.25	13.13	14.00
3.6	9.00	9.90	10.80	11.70	12.60	13.50	14.40
3.7	9.25	10.18	11.10	12.03	12.95	13.88	14.80
3.8	9.50	10.45	11.40	12.35	13.30	14.25	15.20
3.9	9.75	10.73	11.70	12.68	13.65	14.63	15.60
4.0	10.00	11.00	12.00	13.00	14.00	15.00	16.00
4.1	10.25	11.28	12.30	13.33	14.35	15.38	16.40
4.2	10.50	11.55	12.60	13.65	14.70	15.75	16.80
4.3	10.75	11.83	12.90	13.98	15.05	16.13	17.20
4.4	11.00	12.10	13.20	14.30	15.40	16.50	17.60
4.5	11.25	12.38	13.50	14.63	15.75	16.88	18.00
4.6	11.50	12.65	13.80	14.95	16.10	17.25	18.40
4.7	11.75	12.93	14.10	15.28	16.45	17.63	18.80
4.8	12.00	13.20	14.40	15.60	16.80	18.00	19.20
4.9	12.25	13.48	14.70	15.93	17.15	18.38	19.60

CONVERSION TABLE—Continued

	\$ 2.50	\$ 2.75	\$ 3.00	\$ 3.25	\$ 3.50	\$ 3.75	\$ 4.00
5.0	12.50	13.75	15.00	16.25	17.50	18.75	20.00
5.1	12.75	14.03	15.30	16.58	17.85	19.13	20.40
5.2	13.00	14.30	15.60	16.90	18.20	19.50	20.80
5.3	13.25	14.58	15.90	17.23	18.55	19.88	21.20
5.4	13.50	14.85	16.20	17.55	18.90	20.25	21.60
5.5	13.75	15.13	16.50	17.88	19.25	20.63	22.00
5.6	14.00	15.40	16.80	18.20	19.60	21.00	22.40
5.7	14.25	15.68	17.10	18.53	19.95	21.38	22.80
5.8	14.50	15.95	17.40	18.85	20.30	21.75	23.20
5.9	14.75	16.23	17.70	19.18	20.65	22.13	23.60
6.0	15.00	16.50	18.00	19.50	21.00	22.50	24.00
6.1	15.25	16.78	18.30	19.83	21.35	22.88	24.40
6.2	15.50	17.05	18.60	20.15	21.70	23.25	24.80
6.3	15.75	17.33	18.90	20.48	22.05	23.63	25.20
6.4	16.00	17.60	19.20	20.80	22.40	24.00	25.60
6.5	16.25	17.88	19.50	21.13	22.75	24.38	26.00
6.6	16.50	18.15	19.80	21.45	23.10	24.75	26.40
6.7	16.75	18.43	20.10	21.78	23.45	25.13	26.80
6.8	17.00	18.70	20.40	22.10	23.80	25.50	27.20
6.9	17.25	18.98	20.70	22.43	24.15	25.88	27.60
7.0	17.50	19.25	21.00	22.75	24.50	26.25	28.00
7.1	17.75	19.53	21.30	23.08	24.85	26.63	28.40
7.2	18.00	19.80	21.60	23.40	25.20	27.00	28.80
7.3	18.25	20.08	21.90	23.73	25.55	27.38	29.20
7.4	18.50	20.35	22.20	24.05	25.90	27.75	29.60
7.5	18.75	20.63	22.50	24.38	26.25	28.13	30.00
7.6	19.00	20.90	22.80	24.70	26.60	28.50	30.40
7.7	19.25	21.18	23.10	25.03	26.95	28.88	30.80
7.8	19.50	21.45	23.40	25.35	27.30	29.25	31.20
7.9	19.75	21.73	23.70	25.68	27.65	29.63	31.60
8.0	20.00	22.00	24.00	26.00	28.00	30.00	32.00
8.1	20.25	22.28	24.30	26.33	28.35	30.38	32.40
8.2	20.50	22.55	24.60	26.65	28.70	30.75	32.80
8.3	20.75	22.83	24.90	26.98	29.05	31.13	33.20
8.4	21.00	23.10	25.20	27.30	29.40	31.50	33.60
8.5	21.25	23.38	25.50	27.63	29.75	31.88	34.00
8.6	21.50	23.65	25.80	27.95	30.10	32.25	34.40
8.7	21.75	23.93	26.10	28.28	30.45	32.63	34.80
8.8	22.00	24.20	26.40	28.60	30.80	33.00	35.20
8.9	22.25	24.48	26.70	28.93	31.15	33.38	35.60
9.0	22.50	24.75	27.00	29.25	31.50	33.75	36.00
9.1	22.75	25.03	27.30	29.58	31.85	34.13	36.40
9.2	23.00	25.30	27.60	29.90	32.20	34.50	36.80
9.3	23.25	25.58	27.90	30.23	32.55	34.88	37.20
9.4	23.50	25.85	28.20	30.50	32.90	35.25	37.60
9.5	23.75	26.13	28.50	30.88	33.25	35.63	38.00
9.6	24.00	26.40	28.80	31.20	33.60	36.00	38.40
9.7	24.25	26.68	29.10	31.53	33.95	36.38	38.80
9.8	24.50	26.95	29.40	31.85	34.30	36.75	39.20
9.9	24.75	27.23	29.70	32.18	34.65	37.13	39.60
10.0	25.00	27.50	30.00	32.50	35.00	37.50	40.00

SUGGESTED CHANGE IN FLAT RATE TIME

Mail to Service Department:
Hudson Motor Car Company, Detroit, Michigan

DATE

DISTRIBUTOR OR DEALER.....

CITY AND STATE.....

We Suggest the Following Change on Operation No.....

Description of Operation..... Year and Model.....

These changes are based on our actual shop experience. We find the time required in performing this operation as shown by three time studies to be:

First Time Study	Second Time Study	Third Time Study	Present Time	Suggested Time
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Our procedure in performing this operation and tool suggestions are as follows:

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Service Manager.....

SUGGESTED CHANGE IN FLAT RATE TIME

Mail to Service Department:
Hudson Motor Car Company, Detroit, Michigan

DISTRIBUTOR OR DEALER.....

CITY AND STATE.....

We Suggest the Following Change on Operation No.....

Description of Operation..... Year and Model.....

These changes are based on our actual shop experience. We find the time required in performing this operation as shown by three time studies to be:

First Time Study	Second Time Study	Third Time Study	Present Time	Suggested Time
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Our procedure in performing this operation and tool suggestions are as follows:

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Service Manager.....

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SUGGESTED CHANGE IN FLAT RATE TIME

Mail to Service Department:
Hudson Motor Car Company, Detroit, Michigan

DATE

DISTRIBUTOR OR DEALER.....

CITY AND STATE.....

We Suggest the Following Change on Operation No.....

Description of Operation..... Year and Model.....

These changes are based on our actual shop experience. We find the time required in performing this operation as shown by three time studies to be:

First Time Study	Second Time Study	Third Time Study	Present Time	Suggested Time
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Our procedure in performing this operation and tool suggestions are as follows:

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Service Manager.....

SUGGESTED CHANGE IN FLAT RATE TIME

Mail to Service Department:
Hudson Motor Car Company, Detroit, Michigan

DISTRIBUTOR OR DEALER.....

CITY AND STATE.....

We Suggest the Following Change on Operation No.....

Description of Operation..... Year and Model.....

These changes are based on our actual shop experience. We find the time required in performing this operation as shown by three time studies to be:

First Time Study	Second Time Study	Third Time Study	Present Time	Suggested Time
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Our procedure in performing this operation and tool suggestions are as follows:

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Service Manager.....

[illegible][illegible]

