

HUDSON

SERVICE OPERATION TIME SCHEDULE



**1948-1954
MODELS**

HUDSON MOTOR CAR DIVISION
AMERICAN MOTORS CORPORATION
DETROIT 15, MICHIGAN

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INTRODUCTION

This Service Operation Time Schedule covers suggested time values applying to the operations required in the servicing of the 1948 through 1954 Hudson Models. It is intended for use as a guide by the Distributor or Dealer in establishing fair and competitive service charges to Hudson owners.

The time values suggested in this schedule are based on the performance of the complete operation following procedures outlined in the Mechanical Procedure Manual, with the necessary special tools and equipment and by mechanics of average ability.

Factory adjustment of Replacement Certificates is on the basis of the established times shown in this schedule.

Except where otherwise shown, the times apply only to Hudson Cars carrying standard equipment. This should be taken into consideration in quoting the owner for any operation involving work on a car on which special equipment has been added.

Printed forms are provided in the back of this book for reporting Dealers' shop experiences as related to the times shown in this schedule. Your cooperation in making use of these forms when suggesting changes in time or commenting on operations will assist us in improving its usefulness.

DESCRIPTIVE TERMS

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 explained below.

"REMOVE & INSTALL" — means to take off or out the part or parts, together with any other part or parts necessary to gain access, and install the same or new parts, making the required adjustments.

"INSTALL" also applies to the initial installation of a part, accessory, or optional equipment item.

"OVERHAUL" signifies removal of an assembly from the car, disassembly, inspection of all parts, rebuilding the assembly, using the same or new parts, installing the assembly, making necessary adjustments, and lubrication.

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

To expedite pricing and quoting, a labor conversion table is provided at the back of the schedule.

MODEL DESIGNATION

SERIES	YEAR						
	1948	1949	1950	1951	1952	1953	1954
Super Six							
Commodore Six	481	491	501	5A			
Super Eight	482	492	502	6A	6B		
Commodore Eight	483	493	503				
Pacemaker Six	484	494	504	8A	8B		
Pacemaker Six Deluxe			500	4A	4B		
Hornet			50A			7C	7D
Hornet Special				7A	7B		6D
Wasp						4C	4D
Super Wasp					5B	5C	5D
Jet						1C	1D
Super Jet						2C	2D
Jet-Liner							3D

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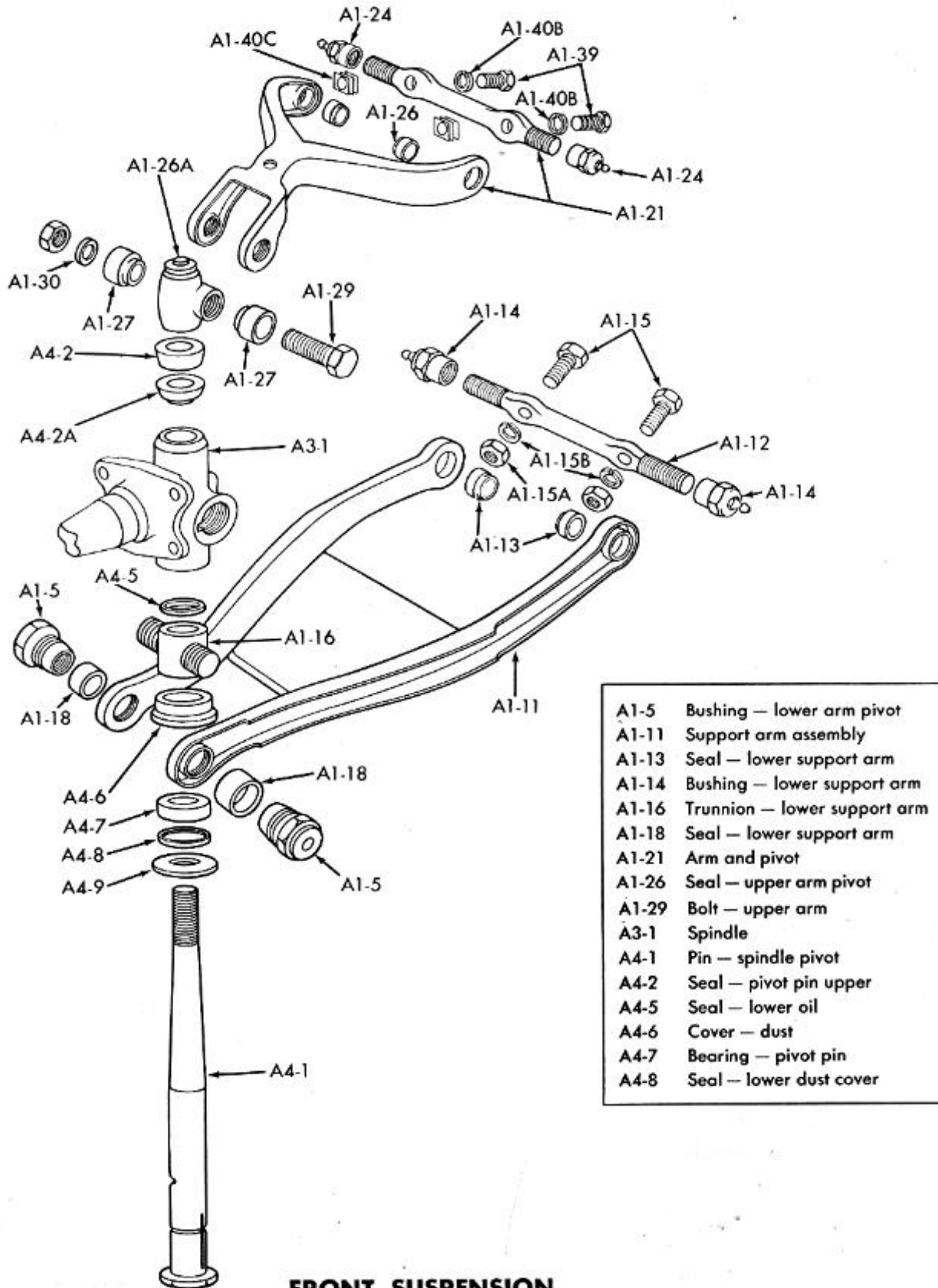
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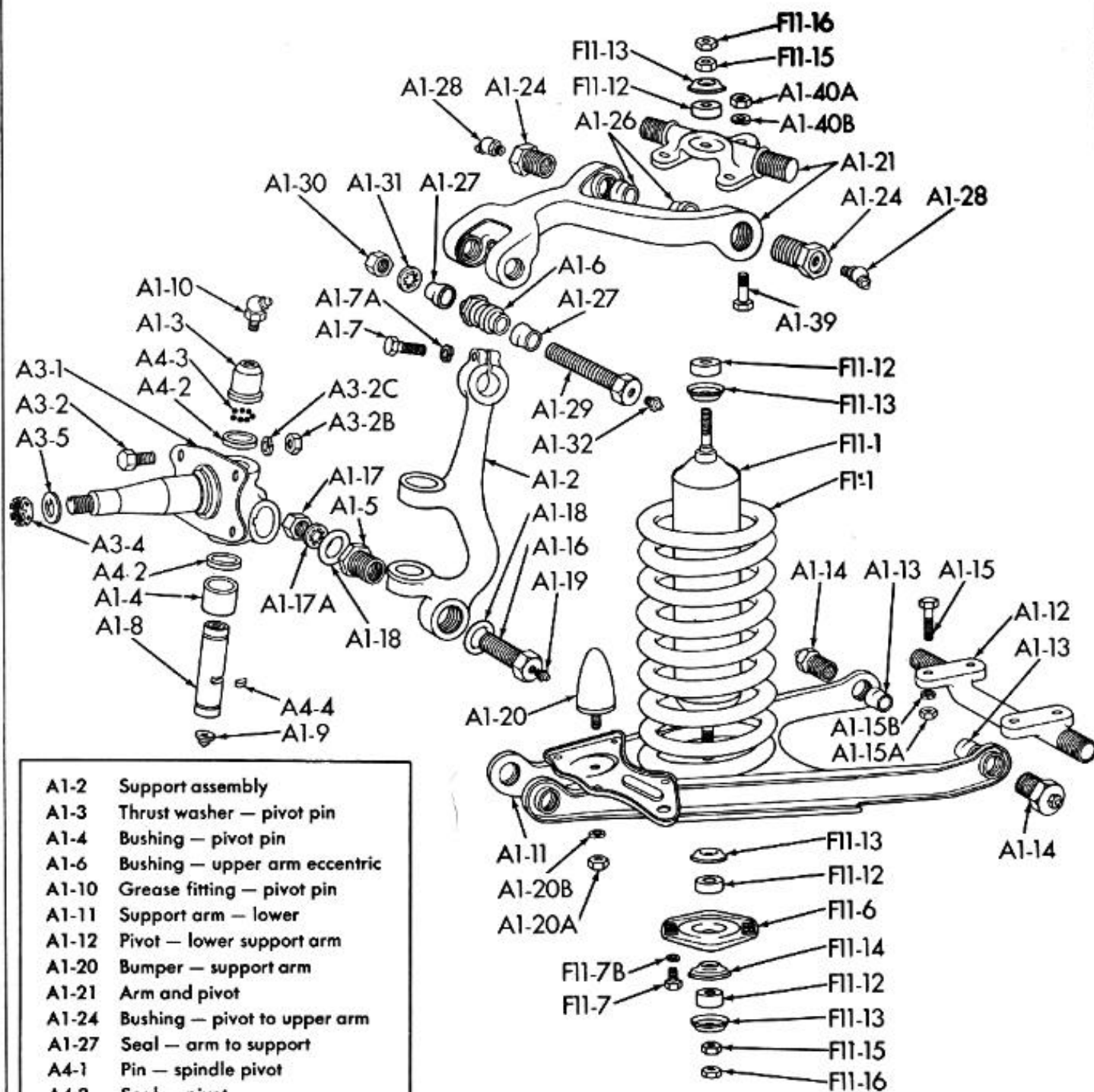
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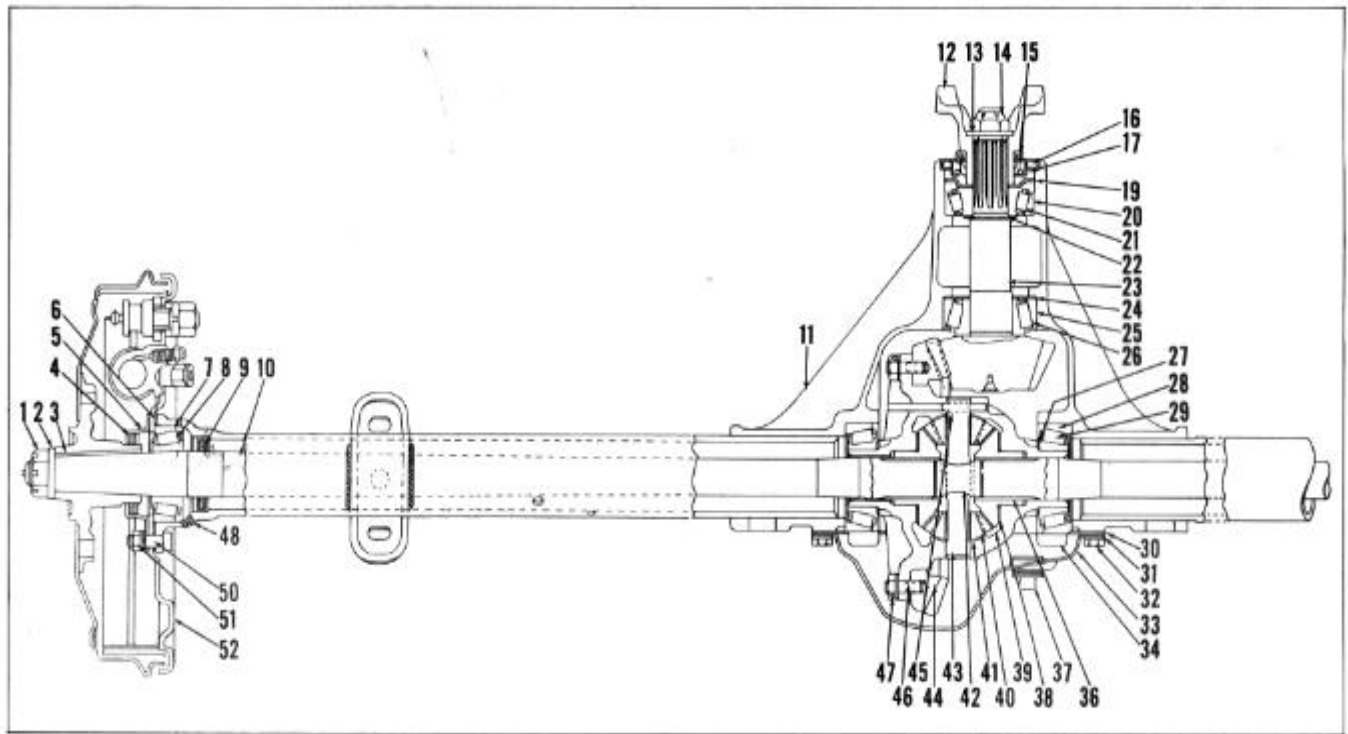
OPERATION	DESCRIPTION	TIME	PRICE
FRONT SUSPENSION			—
1.1	FRONT SUSPENSION OVERHAUL — Both Sides Rebush and replace any parts necessary — Includes adjusting caster, camber and toe-in. All Models	6.0	_____
LOWER SUPPORT ARMS			
1-2	LOWER SUPPORT ARM — Remove and Install. All Models — One Side Both Sides	1.3 2.5	_____ _____
1-3	LOWER SUPPORT ARM INNER PIVOT BUSHINGS — Remove and Install. All Models — One Side Both Sides	.4 .7	_____ _____
14	LOWER SUPPORT ARM INNER PIVOT — Remove and Install. All Models — One Side Both Sides	.5 .9	_____ _____
1-5	LOWER SUPPORT ARM OUTER BOLT AND/OR BUSHING — Remove and Install. All Models Except Jet — One Side Both Sides	.6 1.1	_____ _____
1-6	LOWER SUPPORT ARM TRUNNION BUSHINGS — Remove and Install. Jet Only — One Side Both Sides	.4 .7	_____ _____
1-7	LOWER SUPPORT ARM TRUNNION AND BUSHINGS—Remove and Install. Jet Only — One Side Both Sides	2.0 3.8	_____ _____
UPPER SUPPORT ARMS			
1-8	UPPER SUPPORT ARM — Remove and Install — Includes adjust. ing caster and camber. All Models — Left Side Right Side	1.5 1.3	_____ _____
1-9	UPPER SUPPORT ARM INNER PIVOT BUSHINGS — Remove and Install. All Models — Right Side Left Side	6 .7	_____ _____
1-10	UPPER SUPPORT ARM ECCENTRIC BUSHING AND/OR BOLT — Remove and Install — Includes adjusting caster and camber. All Models Except Jet — One Side Both Sides	.7 1.1	_____ _____
1-11	UPPER SUPPORT ARM INNER PIVOT — Remove and Install. All Models Except Jet — One Side Both Sides Jet Only — One Side Both Sides	1.4 2.7 1.6 2.9	_____ _____ _____ _____



OPERATION	DESCRIPTION	TIME	PRICE
1-12	SUPPORT ARM RUBBER BUMPERS — Remove and Install. All Models — One Side Both Sides	.3 .5	_____ _____
1-13	UPPER SUPPORT STEERING SPINDLE PIVOT AND BOLT - - Remove and Install. Jet Only — One Side Both Sides	.7 1.3	_____ _____
STEERING SPINDLE AND WHEEL BEARINGS			
1-14	STEERING SPINDLE AND/OR PIVOT PIN AND THRUST BEARING — Remove and Install. All Models Except Jet — One Side Both Sides Jet Only — One Side Both Sides	1.3 2.1 1.5 2.7	_____ _____ _____ _____
1-15	STEERING SPINDLE PIVOT PIN AND SUPPORT BUSHINGS — Remove and Install. All Models Except Jet — One Side Both Sides	1.7 3.2	_____ _____
1-16	STEERING SPINDLE SUPPORT — Remove and Install. All Models Except Jet — One Side	1.9	_____
1-17	WHEEL BEARINGS — Remove, clean, repack, install and adjust. All Models — One Side Both Sides	.6 .9	_____ _____
1-18	WHEEL BEARINGS — Adjust Only. All Models — Both Sides	.3	_____
1-19	WHEEL HUB AND DRUM ASSEMBLY — Remove and Install — Includes cleaning, repacking, and adjusting Wheel Bearings. All Models — One Side Both Sides	.5 .9	_____ _____
1-20	SPINDLE GREASE RETAINER AND WASHER — Remove and Install. All Models — One Side Both Sides	.3 .5	_____ _____
SPRINGS, SHOCK ABSORBERS AND STABILIZER			
1-21	COIL SPRINGS AND/OR SILENCER — Remove and Install. All Models — One Side Both Sides	1.0 1.8	_____ _____
1-22	SHOCK ABSORBER AND/OR RUBBER GROMMETS — Remove and Install. All Models — One Side Both Sides	.5 .9	_____ _____
1-23	SHOCK ABSORBER ANCHOR PLATE — Remove and Install. All Models -- One Side Both Side	.2 .3	_____ _____
1-24	FRONT STABILIZER — Remove and Install. All Models	.7	_____
1-25	FRONT STABILIZER MOUNTING BRACKETS TO FRAME —Remove and Install. All -Models	.5	_____

OPERATION	DESCRIPTION	TIME	PRICE
1-26	FRONT STABILIZER CONNECTORS AND/OR BUSHINGS — Remove and Install. All Models — One Side Both Sides	.3 .5	_____ _____
STEERING ARMS AND TIE RODS			
1-27	CENTER STEERING ARM AND PIVOT ASSEMBLY — Remove and Install. All Models	1.0	_____
1-28	CENTER STEERING ARM PIVOT — Remove and Install. All Models	1.8	_____
1-29	CENTER STEERING ARM BEARINGS, SPACERS, BRACKET OR SEALS — Remove and Install. All Models	1.2	_____
1-30	TIE ROD ASSEMBLY — Remove and Install — Includes adjusting toe-in. All Models — One Side Both Sides	.4 .7	_____ _____
1-31	TIE ROD CLAMP — Remove and Install. All Models — One Side Both Sides	.3 .6	_____ _____
1-32	TIE ROD END (INNER) RIGHT OR LEFT — Remove and Install. All Models — One Side	.5	_____
1-33	TIE ROD END (OUTER) RIGHT OR LEFT — Remove and Install. All Models — One Side	.4	_____
1-34	STEERING ARM — RIGHT OR LEFT — Remove and Install. All Models	.7	_____
1-35	DRAG LINK ASSEMBLY — Remove and Install — Includes steering check and any necessary corrections. All Models Except Jet Jet Only With Power Steering	.8 .4 1.2	_____ _____ _____
1-36	DRAG LINK DUST COVER — Remove and Install. All Models	.3	_____
1-37	DRAG LINK BEARING AND/OR SPRING — Remove and Install. All Models — One End Both Ends	.4 .7	_____ _____
1-38	DRAG LINK — ADJUST All Models Except Jet	.5	_____
ALIGNMENT			
1-39	CASTER, CAMBER AND TOE-IN — ADJUST All Models	1.5	_____
1-40	CASTER, CAMBER AND TOE-IN — CHECK All Models	.5	_____
1-41	TOE-IN — ADJUST ONLY All Models	.6	_____

OPERATION	DESCRIPTION	TIME	PRICE
REAR AXLE			
TWO TYPES OF REAR AXLE USED ARE — WELDED REAR COVER WITH A REMOVABLE CARRIER — DESIGNATED AS 1st TYPE AND A REMOVABLE REAR COVER WITH A FIXED CARRIER — DESIGNATED AS 2nd TYPE.			
2-1	AXLE ASSEMBLY — Remove and Install — COMPLETE UNIT — Includes bleeding brake lines. All Models	3.7	_____
2-2	AXLE ASSEMBLY — OVERHAUL — Includes Remove and Install and complete disassembly and reassembly of Rear Axle and bleeding brakes. All Models	8.0	_____
2-3	AXLE HOUSING ASSEMBLY — Remove and Install — Includes disassembly, inspection, reassembly and bleeding brake lines. All Models — 1st Type	6.5	_____
		7.2	_____
2-4	DIFFERENTIAL ASSEMBLY — Remove and Install — Axle housing in Car — Includes bleeding brakes. All Models — 2nd Type	2.3	_____
2-5	DIFFERENTIAL ASSEMBLY — Overhaul when removed from Axle. Includes removing and installing drive gear and replacing case, gears, shaft, thrust washers or spacer block. All Models	.8	_____
2-6	DIFFERENTIAL SIDE BEARINGS — Remove and Install — Axle housing in car — Includes bleeding brakes. All Models	3.0	_____
2-7	DRIVE GEAR AND PINION — Remove and Install and Adjust. All Models — 2nd Type	6.5	_____
		4.2	_____
2-8	DRIVE GEAR AND PINION — Adjust — Includes Remove and Install Axle Assembly. All Models — 2nd Type	6.5	_____
		3.7	_____
2-9	DIFFERENTIAL CARRIER AND GEAR SET ASSEMBLY OR HOUSING GASKET — Remove and Install. All Models — 1st Type	2.2	_____
2-10	DIFFERENTIAL CARRIER — Tighten to axle housing. All Models — 1st Type	.4	_____
2-11	DIFFERENTIAL CARRIER AND GEAR SET ASSEMBLY — Overhaul — Includes disassembly and replacing all necessary parts and adjusting drive gear and pinion	4.7	_____
2-12	DRIVE PINION BEARINGS — FRONT AND REAR — Remove and Install — Also includes adjustment of drive gear and pinion. All Models — 1st Type	3.8	_____
		6.5	_____
2-13	DRIVE PINION OIL SEAL All Models	1.1	_____



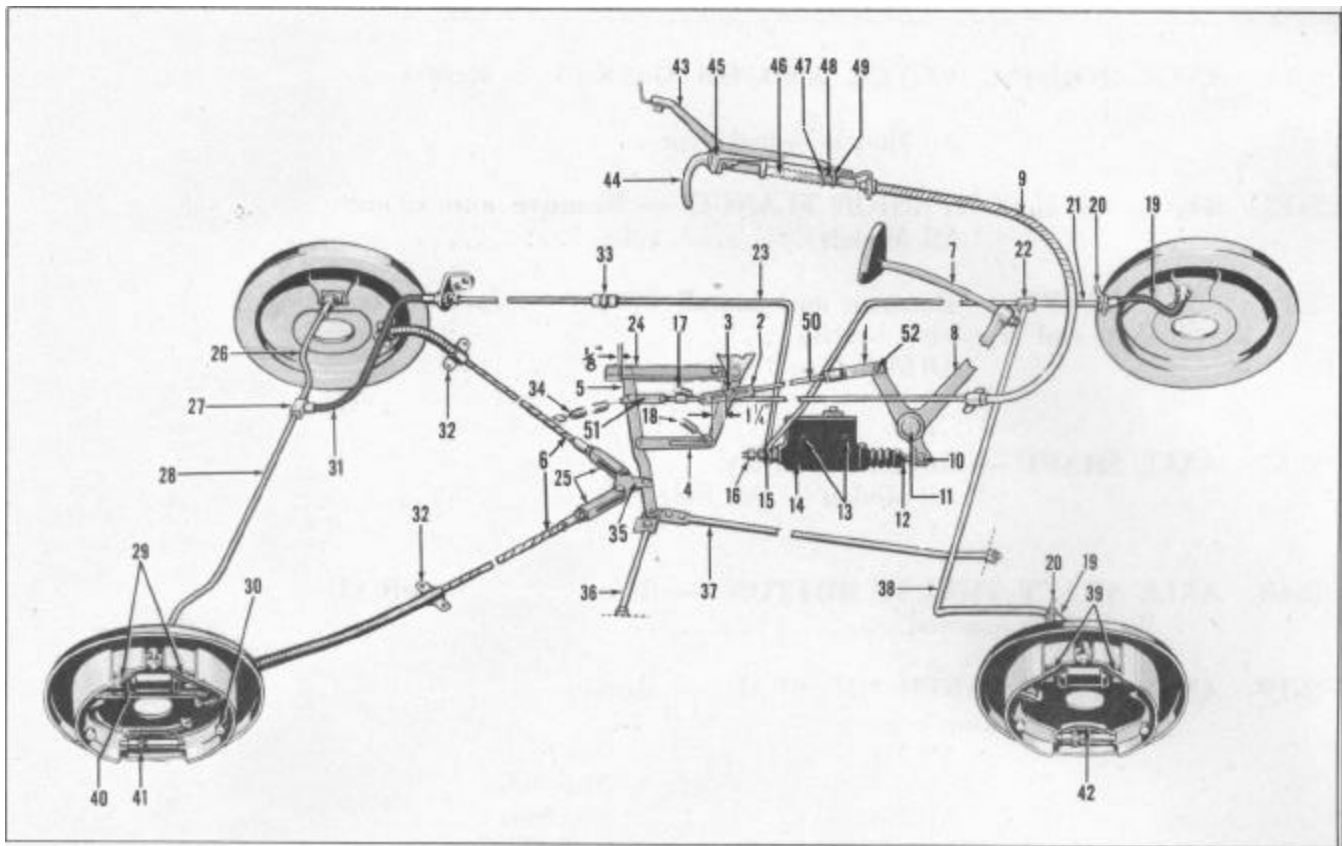
REAR AXLE

- | | |
|---|--|
| 1. Axle shaft nut | 27. Differential side bearing shim |
| 2. Axle shaft washer | 28. Differential side bearing cup |
| 3. Axle shaft key | 29. Differential side bearing cone |
| 4. Wheel bearing adjusting cap oil seal | 30. Housing cover gasket |
| 5. Wheel bearing oil seal cap | 31. Housing cover bolt lockwasher |
| 6. Wheel bearing adjusting shims | 32. Housing cover bolt |
| 7. Wheel bearing cone | 33. Differential housing cover |
| 8. Wheel bearing cup | 34. Differential side bearing cap |
| 9. Wheel bearing inner oil seal | 35. Differential bearing cap bolt |
| 10. Axle shaft | 36. Differential gear |
| 11. Carrier and tube assembly | 37. Housing cover filler plug |
| 12. Companion flange | 38. Differential gear thrust washer |
| 13. Drive pinion washer | 39. Differential case |
| 14. Drive pinion nut | 40. Differential pinion |
| 15. Drive pinion dirt shield | 41. Differential pinion thrust washer |
| 16. Drive pinion oil seal | 42. Axle shaft spacer |
| 17. Drive pinion oil seal gasket | 43. Differential pinion shaft |
| 18. Drive pinion felt wick | 44. Drive gear |
| 19. Drive pinion oil Slinger | 45. Differential pinion shaft locating pin |
| 20. Drive pinion front bearing cup | 46. Drive gear bolts |
| 21. Drive pinion front bearing cone | 47. Drive gear bolt lock |
| 22. Drive pinion front bearing shims | 48. Wheel bearing grease hole plug |
| 23. Drive pinion | 49. Wheel bearing oil seal cap gasket |
| 24. Drive pinion rear bearing shims | 50. Wheel bearing adjusting cap bolt |
| 25. Drive pinion rear bearing cup | 51. Wheel bearing adjusting cap nut |
| 26. Drive pinion rear bearing cone | 52. Brake backing plate |

OPERATION	DESCRIPTION	TIME	PRICE
2-14	AXLE HOUSING COVER AND/OR GASKET — Remove and Install. All Models — 2nd Type	.4	_____
2-15	REAR AXLE COMPANION FLANGE — Remove and Install. All Models	.6	_____
2-16	AXLE SHAFT — Remove and Install (One) — Includes replacing shaft and repacking bearing. All Models — 1st Type	1.1	_____
	2nd Type	1.7	_____
2-17	AXLE SHAFT — Adjust End Play. All Models — One Side — 1st Type	.6	_____
	2nd Type	1.0	_____
2-18	AXLE SHAFT THRUST BUTTON — Remove and Install (One). With shaft removed	.4	_____
2-19	AXLE SHAFT INNER OIL SEAL — Remove and Install — Includes repacking bearing. All Models — 1st Type — One Side	1.2	_____
	Both Sides	2.0	_____
	All Models — 2nd Type — One Side	1.5	_____
	Both Sides	2.7	_____
2-20	AXLE SHAFT OUTER OIL SEAL — Remove and Install — Includes cleaning brakes and drums. All Models — 1st & 2nd Types — One Side	.7	_____
	Both Sides	1.3	_____
2-21	WHEEL BEARINGS — Remove and Install — Includes cleaning and repacking bearings. All Models — 1st Type — One Side	1.0	_____
	Both Sides	1.7	_____
	All Models — 2nd Type — One Side	1.8	_____
	Both Sides	2.5	_____

WHEELS AND TIRES

3-1	TIRE — Remove and Install. All Models — One	4	_____
	Two	.7	_____
3-2	WHEELS AND TIRES — Remove and Install (Five) — Rotate and balance. All Models	1.8	_____
3-3	FRONT WHEELS — Align — Includes caster, camber, toe-in and setting steering gear on high point. All Models	1 5	_____
3-4	FRONT WHEEL BEARINGS — Adjust Both. All Models	.3	_____



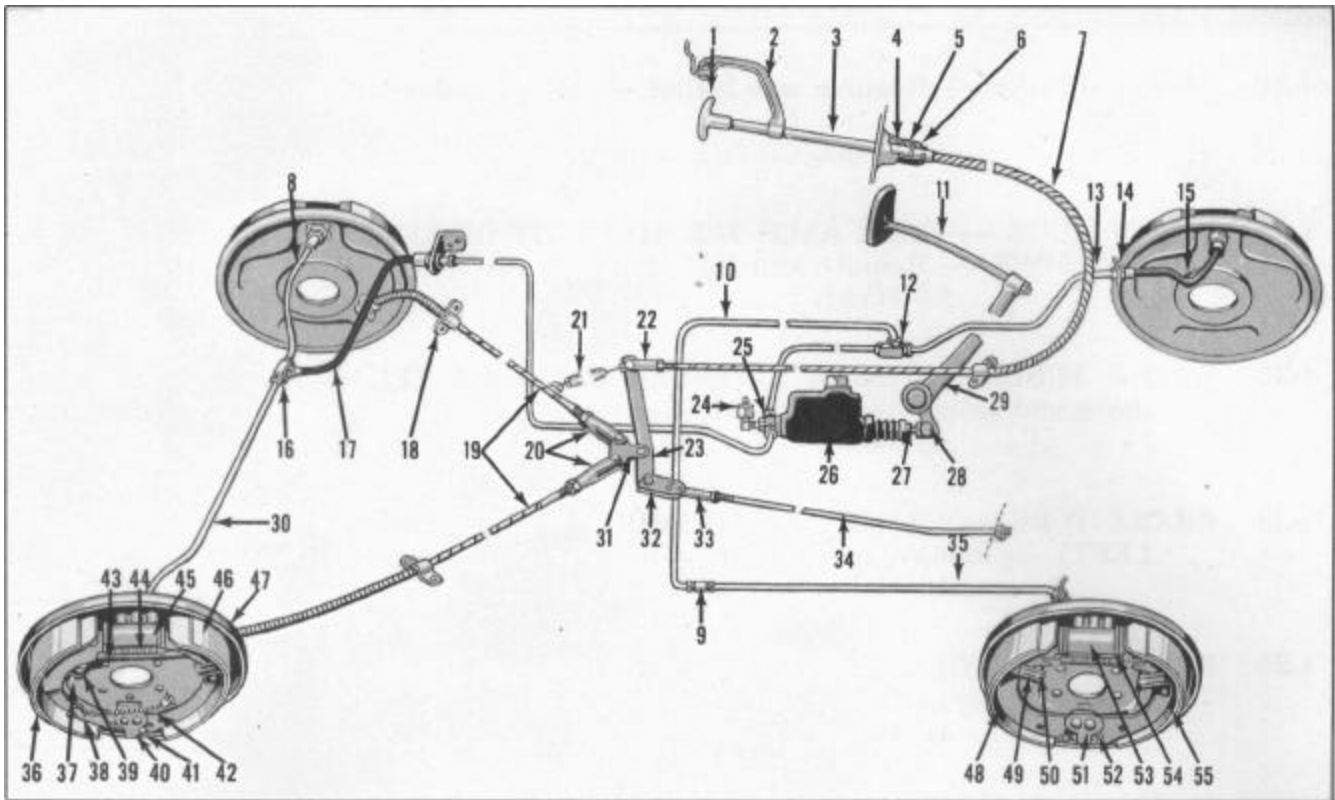
BRAKE ARRANGEMENT - ALL EXCEPT JET AND POWER BRAKES

- | | |
|--|---|
| 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
3-5	FRONT WHEEL BEARINGS & CUPS — Remove and Install — Includes cleaning, repacking and adjusting. All Models — One Wheel Both Wheels	.6 1.0	_____ _____
3-6	FRONT WHEEL GREASE RETAINER AND WASHER — Remove and Install. All Models — One Wheel Two Wheels	.3 .5	_____ _____
3-7	HUB AND BRAKE DRUM (FRONT) — Remove and Install — Includes clean and repack and adjust bearings. All Models — One Wheel Both Wheels	.6 1.0	_____ _____
3-8	HUB AND BRAKE DRUM AND/OR HUB KEY (REAR) — Remove and Install. All Models — One Wheel Both Wheels	.4 .7	_____ _____
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 or- dered, 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 Except Jet Jet Only	1.0 .8	_____ _____
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	1.5	_____
4-6	BRAKES — Reline and Adjust — Includes removing drums, cleaning backing plates, lubriplate shoe contact points, install new shoes and lining, re pack and adjust front wheel bearings, and refill master cylinder. Time allowance includes relining shoes. All Models — Four Wheels Two Wheels If necessary to bleed brakes, add	3.7 1.9 .7	_____ _____ _____
4-7	BRAKE BACKING PLATE — Remove and Install — Includes removing and installing necessary parts, adjust brakes and bleed lines. All Models — One Front One Rear	1.6 1.9	_____ _____

OPERATION	DESCRIPTION	TIME	PRICE
4-8	BRAKE DRUM AND HUB — Remove and Install — Includes packing wheel bearings and adjusting. All Models — One Front One Rear	.6 .4	 _____
4-9	BRAKE DRUMS — Reface — When removed from car. All Models — One Two Four	.4 .7 1.3	 _____ _____
4-10	WHEEL CYLINDER — Remove and Install — Includes bleeding lines and adjusting brakes. All Models — One Front Two Front One Rear Two Rear All Four	1.0 1.8 1.3 2.0 3.0	 _____ _____ _____ _____ _____
4-11	WHEEL CYLINDER — RECONDITION WHEN REMOVED — Includes hone, clean and replace necessary parts. All Models — One Four	.4 1.4	 _____ _____
4-12	WHEEL CYLINDER — BLEEDER SCREW — Remove and Install. All Models	.2	_____
4-13	MASTER CYLINDER — Remove and Install — Includes bleeding. All Models	1.0	_____
4-14	MASTER CYLINDER — Overhaul — Includes remove and install, honing cylinder, replace necessary parts and bleed lines. All Models	1.5	_____
4-15	MASTER CYLINDER — Overhaul — When removed from car. All Models	.6	_____
4-16	MASTER CYLINDER OUTLET FITTING AND/OR GASKET—Remove and Install. All Models If necessary to bleed brakes — add	.4 .7	 _____ _____
4-17	MASTER CYLINDER STOP LIGHT SWITCH — Remove and Install. All Models If necessary to bleed brakes — add	.3 .7	 _____ _____
4-18	MASTER CYLINDER FILLER CAP AND/OR GASKET—Remove and Install. All Models	.2	_____
BRAKE HOSE AND TUBES			
4-19	BRAKE HOSE — Remove and Install — Includes bleeding lines. All Models — One Front One Rear	.9 .8	 _____ _____

OPERATION	DESCRIPTION	TIME	PRICE
4-20	BRAKE TUBES — Remove and Install — All — Includes bleeding lines. All Models	1.8	_____
4-21	BRAKE TUBE — REAR AXLE TEE TO RIGHT OR LEFT REAR CYLINDER — Remove and Install — Includes bleeding lines. All Models	.8	_____
4-22	BRAKE TUBE — MASTER CYLINDER TO FRAME TEE — Remove and Install — Includes bleeding lines. All Models	.9	_____
4-23	BRAKE TUBE — FRAME TEE TO FRONT WHEEL (RIGHT OR LEFT) — Remove and Install — Includes bleeding lines. All Models	.0	_____
4-24	FRAME TEE OR REAR AXLE TEE — Remove and Install — Includes bleeding lines. All Models	.9	_____
BRAKE CABLES AND LINKAGE			
4-25	BRAKE CABLES — Remove and Install — Includes cleaning, free-up and lubricate. All Models — One Two	.9 1.5	_____ _____
4-26	BRAKE PEDAL LEVER, SHAFT AND HOUSING ASSEMBLY — Remove and Install. All Models To Rebush — Add	1.0 .3	_____ _____
4-27	BRAKES — MECHANICAL FOLLOW-UP PULL ROD — Remove and Install. All Models	.4	_____
4-28	BRAKES — MECHANICAL FOLLOW-UP — Adjustment. All Models	.3	_____
4-29	BRAKE — PULL BACK SPRINGS — Any One — Remove and Install. All Models	.2	_____
4-30	BRAKE PEDAL ROD — Remove and Install. All Models	.4	_____
4-31	BRAKE PEDAL TO MASTER CYLINDER PUSH ROD — Remove and Install. All Models	.5	_____



BRAKE ARRANGEMENT - JET AND POWER BRAKES

- | | |
|--------------------------------------|---------------------------------|
| 1. Hand brake lever grip | 29. Brake pedal lever |
| 2. Hand brake mounting bracket | 30. Rear wheel brake tube |
| 3. Hand brake ratchet rod | 31. Brake cable toggle assembly |
| 4. Hand brake cable sleeve | 32. Cable lever pivot plate |
| 5. Hand brake cable retainer | 33. Cable lever brace clevis |
| 6. Hand brake dust grommet | 34. Cable lever pivot brace |
| 7. Hand brake cable | 35. Right front brake tube |
| 8. Left rear wheel tube | 36. Secondary shoe |
| 9. Brake tube connector | 37. Adjusting eccentric |
| 10. Frame connector tube | 38. Brake cable lever |
| 11. Brake pedal rod | 39. Brake hold down spring |
| 12. Front brake tee | 40. Anchor ramp |
| 13. Brake tube assembly | 41. Anchor spring |
| 14. Front brake hose connector | 42. Brake cable |
| 15. Front brake hose assembly | 43. Brake shoe link |
| 16. Rear axle brake tee | 44. Brake shoe pull back spring |
| 17. Rear brake hose | 45. Wheel cylinder |
| 18. Rear brake cable support bracket | 46. Primary shoe |
| 19. Rear brake cables | 47. Brake backing plate |
| 20. Rear brake clevis | 48. Secondary shoe |
| 21. Brake cable return spring | 49. Adjusting eccentric |
| 22. Brake cable clevis | 50. Brake hold down spring |
| 23. Brake cable lever | 51. Anchor ramp |
| 24. Stop light switch | 52. Anchor spring |
| 25. Master cylinder outlet fitting | 53. Wheel cylinder |
| 26. Master cylinder assembly | 54. Brake pull back spring |
| 27. Master cylinder push rod | 55. Primary shoe |
| 28. Master cylinder clevis and pin | |

OPERATION	DESCRIPTION	TIME	PRICE
HAND BRAKE			
4-32	HAND BRAKE CABLE LEVER TOGGLE — Remove and Install. All Models	.6	_____
4-33	HAND BRAKE CABLE — Adjust. All Models	.3	_____
4-34	HAND BRAKE LEVER — Remove and Install. All Models	.4	_____
4-35	HAND BRAKE RATCHET STABILIZER SPRINGS — Remove and Install. All Models	.3	_____
4-36	HAND BRAKE RATCHET ASSEMBLY — Remove, free-up and install. All Models	.5	_____
4-37	HAND BRAKE COMPLETE ASSEMBLY — Remove and Install. All Models	1.0	_____
4-38	HAND BRAKE CABLE — Remove and Install. All Models	.6	_____

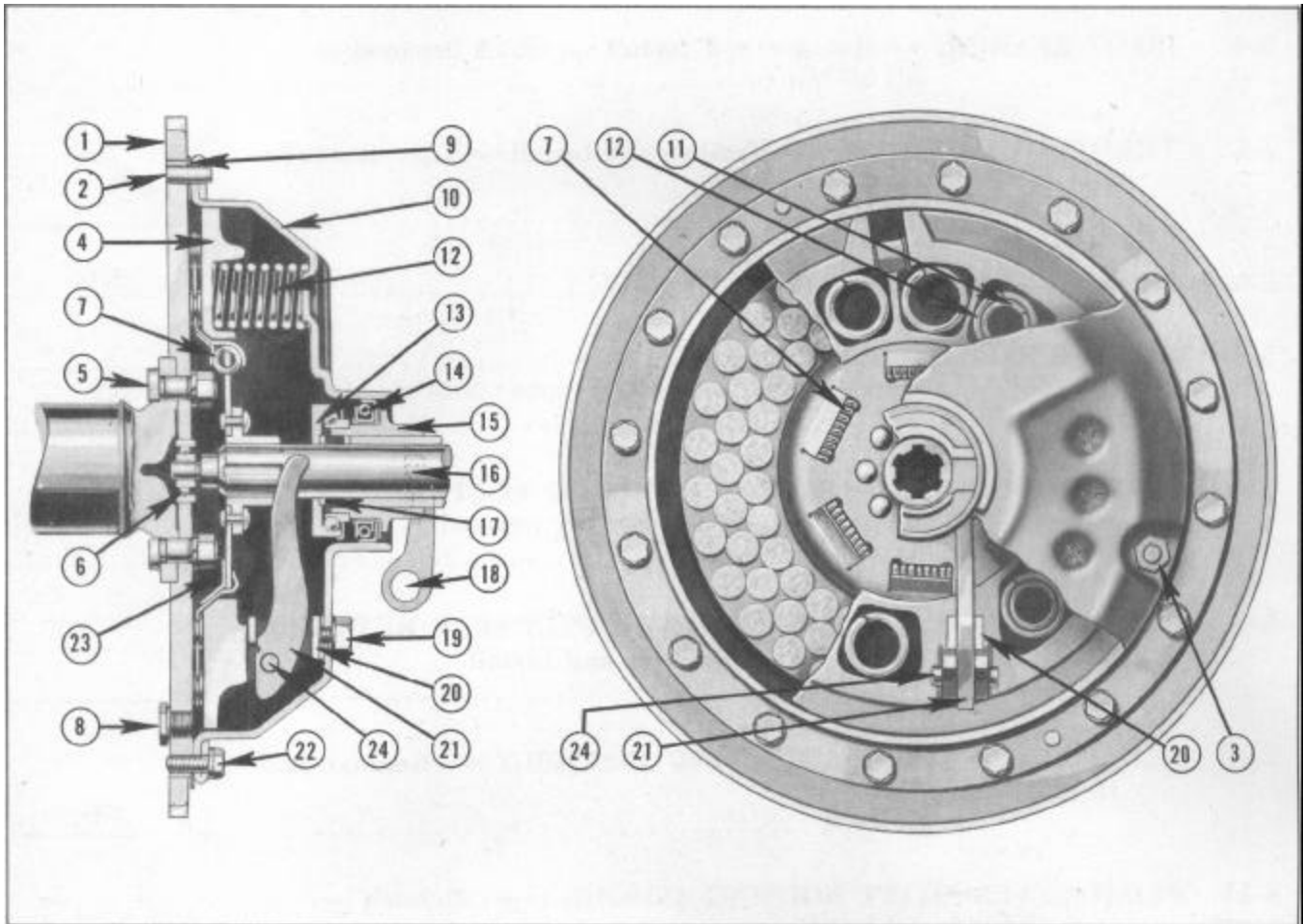
POWER BRAKES

4-39	MASTER UNIT ASSEMBLY — Remove and Install	1.3	_____
4-40	POWER BRAKE MASTER CYLINDER ASSY.—Remove and Install. Add to Operation 4-39	.3	_____
4-41	MASTER UNIT ASSEMBLY — Overhaul — When removed	1.2	_____
4-42	POWER BRAKE VACUUM TANK — Remove and Install	.3	_____
4-43	ADJUST BRAKE PEDAL CLEARANCE	.3	_____
4-44	VACUUM CHECK VALVE OR HOSE — Remove and Install	.2	_____

NOTES

OPERATION	DESCRIPTION	TIME	PRICE
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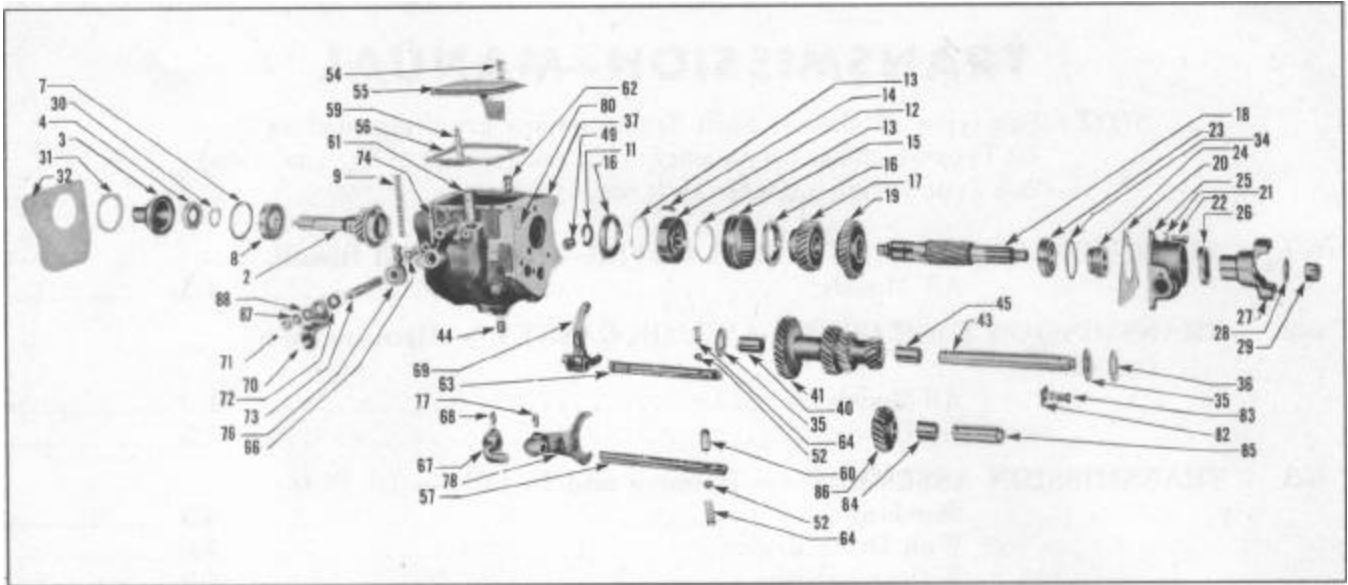
OPERATION	DESCRIPTION	TIME	PRICE
5-4	PILOT BEARING — Remove and Install — Clutch Removed — All Models	.4	_____
5-5	THROW OUT BEARING — Remove and Install — Transmission Removed. All Models	.4	_____
5-6	PEDAL — Adjust Clearance — All Models	.3	_____
5-7	DRAIN & REFILL — 1st Type Flush Clutch — using 20% carbon tetra chloride and 80% acetone	.3 .4	_____ _____
5-8	SHIFTER YOKE, SHIFTER SHAFT AND/OR COUPLING — Remove and Install and Rebush — Housing removed. 1st Type	.7	_____
5-9	CROSS SHAFT AND COUPLING LEVER, FELT SEAL, RETAINER OR RUBBER BUSHING — Remove and Install. 1st Type	.5	_____
5-10	PEDAL LEVER SHAFT & HOUSING ASSEMBLY — Remove and Install. 1st Type	1.0	_____
5-11	PEDAL LEVER SHAFT HOUSING ASSEMBLY — Rebush — Includes Remove and Install. 1st Type	1.3	_____
5-12	THROWOUT LEVER — Remove and Install — 2nd Type	1.0	_____
5-13	HOUSING PAN — Remove and Install — All Models	.4	_____
5-14	DRIVEN DISC — Reface — Clutch Removed From Car. 2nd Type	.5	_____
5-15	PEDAL RETURN OR OVER CENTER SPRING — Remove and Install. All Models	.3	_____
5-16	PEDAL LEVER — Remove and Install — 2nd Type Rebush — Add	.8 .3	_____ _____
5-17	PEDAL LINKAGE — Overhaul — 2nd Type	1.1	_____
5-18	PEDAL LEVER SHAFT — Remove and Install — 2nd Type	1.0	_____
5-19	THROWOUT LEVER RELEASE ROD — Remove and Install. 2nd Type	.4	_____
5-20	CROSS SHAFT SUPPORT — Remove and Install — 2nd Type.4	_____



CLUTCH — ALL MODELS EXCEPT JET

- | | |
|-----------------------------------|--------------------------------------|
| 1. Flywheel | 13. Clutch throwout bearing |
| 2. Flywheel dowel pin | 14. Throwout bearing oil seal |
| 3. Clutch cover driving lug | 15. Clutch collar |
| 4. Pressure plate | 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 |

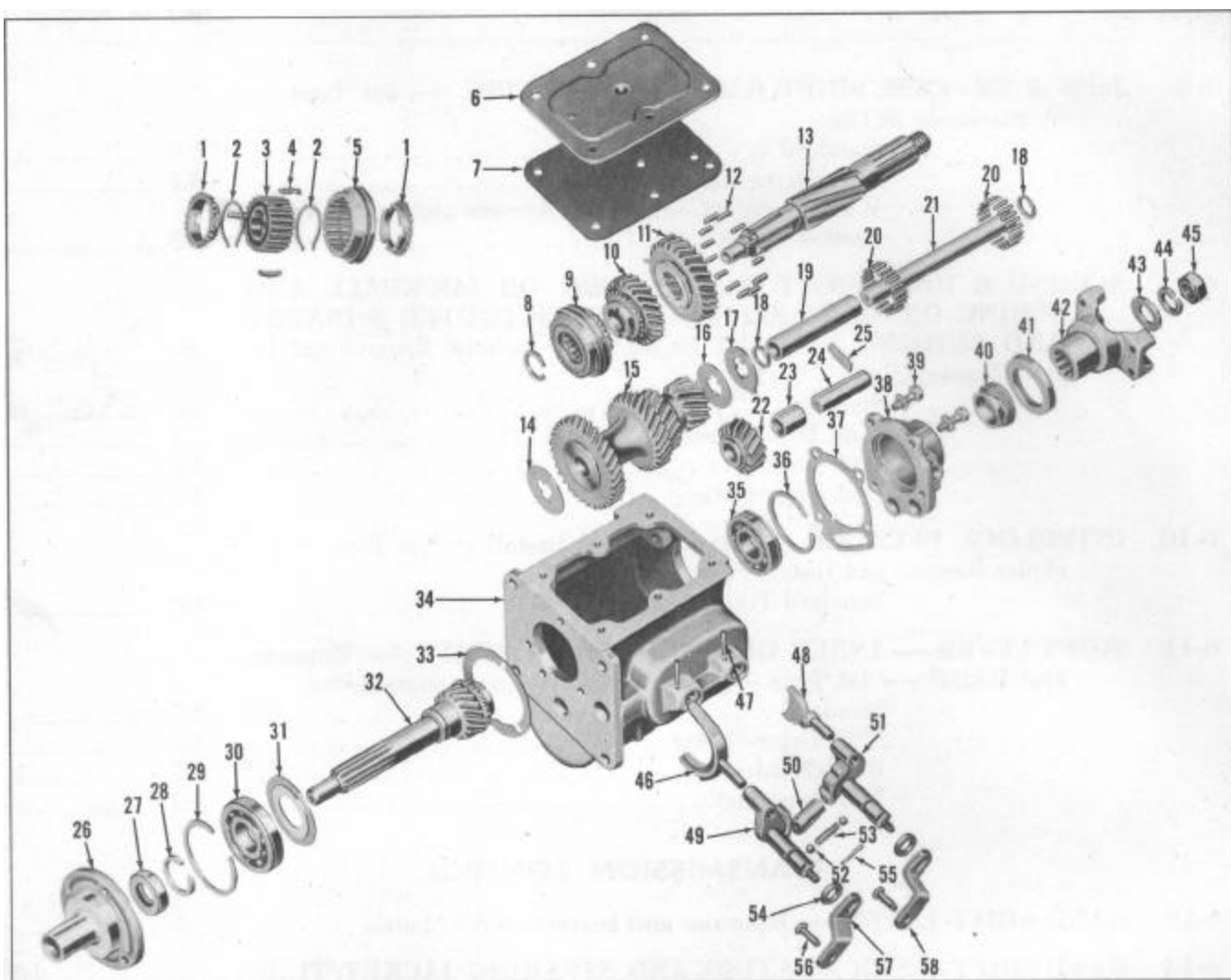
OPERATION	DESCRIPTION	TIME	PRICE
TRANSMISSION — MANUAL			
NOTE: Two types of Manual Shift Transmissions are designated as — 1st Type which has only a <i>single shift rod</i> (at side of Transmission) 2nd Type having a <i>double shift rod</i> .			
6-1	TRANSMISSION OPENING FLOOR COVER-Remove and Install. All Models	1.1	_____
6-2	TRANSMISSION CASE COVER AND/OR GASKET - Remove and Install. All Models Except Jet	1.3	_____
	Jet Only	1.5	_____
6-3	TRANSMISSION ASSEMBLY - Remove and Install - 1st Type		
	Standard	4.3	_____
	With Drive-Master	4.6	_____
	With Overdrive	4.8	_____
	With Supermatic	5.0	_____
	Standard - 2nd Type - Includes Jet	1.4	_____
	With Overdrive	1.8	_____
6-4	OVERHAUL - Standard - Includes replacing any or all parts.		
	All Models - 1st Type	6.8	_____
	With Drive-Master	7.1	_____
	With Overdrive	7.8	_____
	With Supermatic	8.0	_____
	Standard - 2nd Type - Includes Jet	3.9	_____
	With Overdrive	4.9	_____
	Overhaul When Removed - All Models - Standard	2.5	_____
	With Overdrive	3.5	_____
6-5	MAIN DRIVE GEAR, BEARING, RETAINER AND/OR OIL SEAL — Remove and Install - Includes remove and install transmission.		
	All Models - 1st Type	4.8	_____
	With Drive-Master	5.1	_____
	With Overdrive	5.3	_____
	With Supermatic	5.5	_____
	Standard - 2nd Type	3.4	_____
	With Overdrive	3.8	_____
6-6	MAINSHAFT — Remove and Install — Includes any gear on shaft, synchronizer and rear bearing — 1st Type - Includes remove and install transmission.		
	Standard	6.3	_____
	With Overdrive	6.7	_____
	With Drive-Master	6.5	_____
	With Supermatic	6.9	_____
	Standard - 2nd Type	3.4	_____
	With Overdrive	4.9	_____
6-7	MAINSHAFT REAR BEARING - Remove and Install - 1st Type — Transmission in car.		
	Standard	1.2	_____
	With Overdrive	1.5	_____
	2nd Type - Rear Bearing - Includes Remove and In- stall Transmission	3.4	_____
	Rear Oil Seal - Transmission in Car	.7	_____



TRANSMISSION - FIRST TYPE

- | | |
|-------------------------------------|---------------------------------------|
| 2. Main drive gear | 40. Cluster bushing front |
| 3. Gear bearing retainer | 41. Countershaft gear cluster |
| 4. Gear oil seal | 43. Countershaft |
| 7. Bearing retainer ring | 44. Drain plug |
| 8. Gear bearing | 45. Cluster bushing rear |
| 9. Shaft pilot bearing | 49. Filler plug |
| 11. Shift hub lock ring | 52. Rail lock ball |
| 12. Synchronizer shift sleeve hub | 54. Cover screw |
| 13. Synchronizer spring | 55. Transmission cover |
| 14. Synchronizer shift plate | 56. Cover gasket |
| 15. Synchronizer shift sleeve | 57. Low and reverse shift rail |
| 16. Synchronizer ring | 59. Shift selector lever |
| 17. Shaft intermediate gear | 60. Shift rail interlock |
| 18. Main shaft | 61. Selector shaft bushing |
| 19. Low and reverse gear | 62. Breather |
| 20. Gear housing gasket | 63. High and second shift rail |
| 21. Speedometer gear housing washer | 64. High and second ball spring |
| 22. Gear housing bolt | 66. High and second rail stop screw |
| 23. Shaft rear bearing | 67. Low and reverse shifter |
| 24. Speedometer gear | 68. Low and reverse shifter set screw |
| 25. Speedometer gear housing | 69. High and second shift fork |
| 26. Gear housing oil seal | 70. Shift lever outer |
| 27. Companion flange | 71. Shift shaft nut |
| 28. Flange washer | 72. Shift shaft seal |
| 29. Flange nut | 73. Shift shaft |
| 30. Gear lock ring | 74. Shift shaft pin |
| 31. Retainer gasket | 76. Shift lever, inner |
| 32. Case gasket | 77. Low and reverse fork set screw |
| 34. Main shaft bearing snap ring | 78. Low and reverse shift fork |
| 35. Cluster thrust washer | 80. Expansion plug |
| 36. Cluster steel washer | 82. Counter shaft lock plate |
| 37. Transmission case | 83. Lock plate screw |
| | 84. Idler gear bushing |
| | 85. Idler gear shaft |
| | 86. Reverse idler gear |

OPERATION	DESCRIPTION	TIME	PRICE
6-8	LOW & REVERSE SHIFT RAIL AND/OR FORK — 1st Type — Transmission in Car.		
	Standard	2.9	_____
	With Drive-Master	3.1	_____
	With Overdrive — Includes Remove and Install Transmission	6.3	_____
6-9	SECOND & HIGH SHIFT RAIL & FORK OR LOCKBALL AND SPRING OR SHIFT SELECTOR LEVER (OUTER & INNER) AND BUSHING AND SET SCREW — Includes Remove and Install Transmission — 1st Type.		
	Standard	4.8	_____
	With Drive-Master	5.1	_____
	With Overdrive	5.3	_____
	With Supermatic	5.5	_____
6-10	INTERLOCK PLUNGER — Remove and Install — 1st Type — Includes Remove and Install Floor Boards.		
	Standard Transmission	3.0	_____
6-11	SHIFT LEVER — INNER OR OUTER SHIFT SHAFT — Remove and Install — 1st Type — Unnecessary to remove transmission.		
	Standard	3.3	_____
	With Drive-Master	3.5	_____
	With Overdrive	3.7	_____
	With Supermatic	3.9	_____
TRANSMISSION CONTROL			
6-12	HAND SHIFT LEVER — Remove and Install — All Models	4	_____
6-13	HAND SHIFT LEVER AND TUBE AND STEERING JACKET TUBE — Remove and Install.		
	All Models	2.2	_____
	With Direction Indicator — Add	.4	_____
6-14	HAND SHIFT LEVER TUBE AND ROD ASSEMBLY—Remove and Install.		
	1st Type	1.7	_____
	2nd Type	1.0	_____
	With Direction Indicator — Add	.4	_____
6-15	TUBE BRACKET — UPPER — Remove and Install.		
	All Models	.7	_____
	With Direction Indicator — Add	.4	_____
6-16	HAND SHIFT LEVER AND FULCRUM BRACKET—Remove and Install.		
	1st Type Only	1.9	_____
	With Direction Indicator — Add	.4	_____
6-17	TUBE BRACKET — UPPER — Remove and Install.		
	1st Type	2.3	_____
	2nd Type	1.9	_____
	With Direction Indicator — Add	.4	_____
6-18	TUBE PUSH ROD OR PUSH ROD ENDS — Remove and Install.		
	All Models — 1st Type	1.4	_____



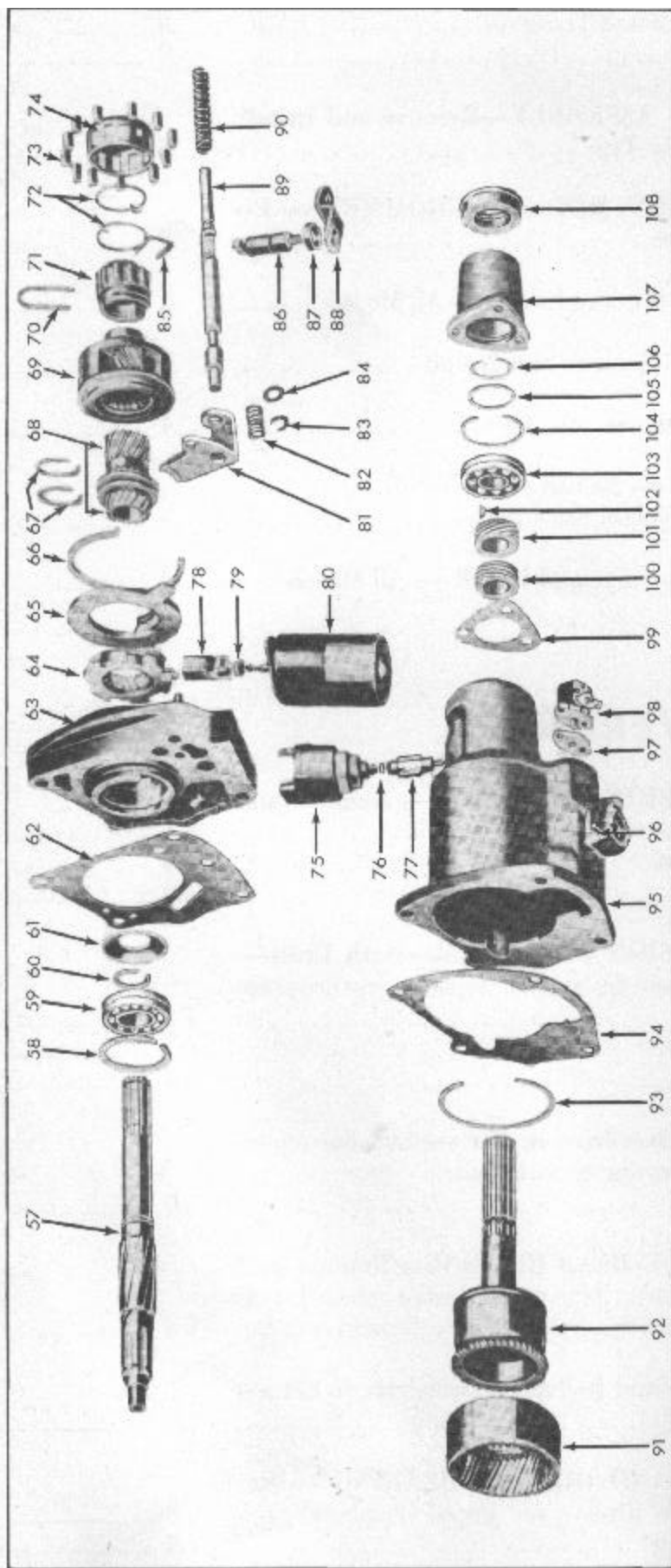
TRANSMISSION - SECOND TYPE

- | | | |
|--------------------------------------|---|---|
| 1. Synchronizer rings | 22. Reverse idler gear | 40. Speedometer drive gear |
| 2. Synchronizer springs | 23. Reverse idler gear bushing | 41. Mainshaft oil seal |
| 3. Synchronizer hub | 24. Reverse idler gear shaft | 42. Companion flange |
| 4. Synchronizer shift plates | 25. Idler and C. S. lock plate | 43. Mainshaft plain washer |
| 5. Synchronizer sleeve | 26. Main drive gear bearing retainer | 44. Mainshaft lock washer |
| 6. Cover | 27. Main drive gear oil seal | 45. Mainshaft nut |
| 7. Cover gasket | 28. Main drive gear snap ring | 46. Shift fork (second and high) |
| 8. Mainshaft snap ring | 29. Main drive gear bearing snap ring | 47. Taper pin |
| 9. Synchronizer assembly | 30. Main drive gear bearing | 48. Shift shoe (low and reverse) |
| 10. Second speed gear and bushing | 31. Main drive gear oil retaining washer | 49. Shift shaft (second and high) |
| 11. Low and reverse gear | 32. Main drive gear | 50. Shift lever interlock sleeve |
| 12. Mainshaft front rollers | 33. Main drive gear bearing retainer gasket | 51. Shift shaft (low and reverse) |
| 13. Mainshaft | 34. Transmission case | 52. Shift rail lock ball |
| 14. C. S. thrust washer (front) | 35. Mainshaft bearing (rear) | 53. Shift rail lock ball spring |
| 15. C. S. gear cluster | 36. Mainshaft bearing snap ring | 54. Shift shaft oil seals |
| 16. C. S. rear thrust washer (inner) | 37. Mainshaft rear bearing retainer gasket | 55. Shift lever interlock pin |
| 17. C. S. rear thrust washer (outer) | 38. Mainshaft rear bearing retainer | 56. Control lever outer clevis pin |
| 18. C. S. bearing washers | 39. Retainer bolts | 57. Second and high control lever (outer) |
| 19. C. S. gear spacer | | 58. Low and reverse control lever (outer) |
| 20. C. S. bearing rollers | | |
| 21. Countershaft | | |

OPERATION	DESCRIPTION	TIME	PRICE
6-19	CABLE, CASING AND BRACKET ASSEMBLY — Remove and Install. 1st Type — Standard Transmission With Overdrive	.8 .9	_____ _____
6-20	BELL CRANK AND BUSHING ASSEMBLY—Remove and Install. All Models — 1st Type	.6	_____
6-21	BELL CRANK TO TRANSMISSION ROD AND GROMMET — Remove and Install — 1st Type	2	_____
6-22	COMPANION FLANGE — Remove and Install — All Models	.8	_____
6-23	SPEEDOMETER HOUSING — Remove and Install	.9	_____
6-24	SPEEDOMETER CABLE — Remove and Install	.4	_____
6-25	SPEEDOMETER DRIVE GEAR — Remove and Install. All Models — Transmission in Car	.9	_____
6-26	SPEEDOMETER PINION — Remove and Install — All Models3	_____

OVERDRIVE

7-1	OVERDRIVE AND TRANSMISSION ASSEMBLY — Remove and Install — 1st Type — Includes replace either unit With Drive-Master Jet Only	5.1 5.4 4.9	_____ _____ _____
7-2	OVERDRIVE AND TRANSMISSION — Overhaul—Both Units— 1st Type — Includes Remove and Install and replace any necessary parts in either unit With Drive-Master Jet Only	7.8 8.1 5.4	_____ _____ _____
7-3	OVERDRIVE — Overhaul — Overdrive in Car — Includes replacing any parts except adapter, bearing or mainshaft. All Models	2.9	_____
7-4	OVERDRIVE HOUSING AND/OR REAR BEARING—Remove and Install — All Models — Includes Remove and Install solenoid, governor switch and shift rail switch on new housing -- Overdrive in car	1.4.	_____
7-5	OIL SEAL — REAR — Remove and Install — Overdrive in Car — All Models	7	_____
7-6	TRANSMISSION MAINSHAFT AND/OR REAR BEARING — Re- move and Install — Includes Remove and Install Overdrive With Drive-Master	6.8 7.8	_____ _____
7-7	OVERDRIVE MAINSHAFT — Remove and Install — Overdrive in Car — All Models	1.3	_____



57. Mainshaft

- 58. Trans. mainshaft snap ring
- 59. Trans. mainshaft bearing
- 60. Trans. mainshaft snap ring
- 61. Bearing oil baffle
- 62. O/D to trans. case gasket
- 63. Overdrive housing adapter
- 64. Sun gear plate and baffle
- 65. Sun gear plate cover
- 66. Cover plate snap ring
- 67. Sun gear snap rings
- 68. Sun gear and shifting collar

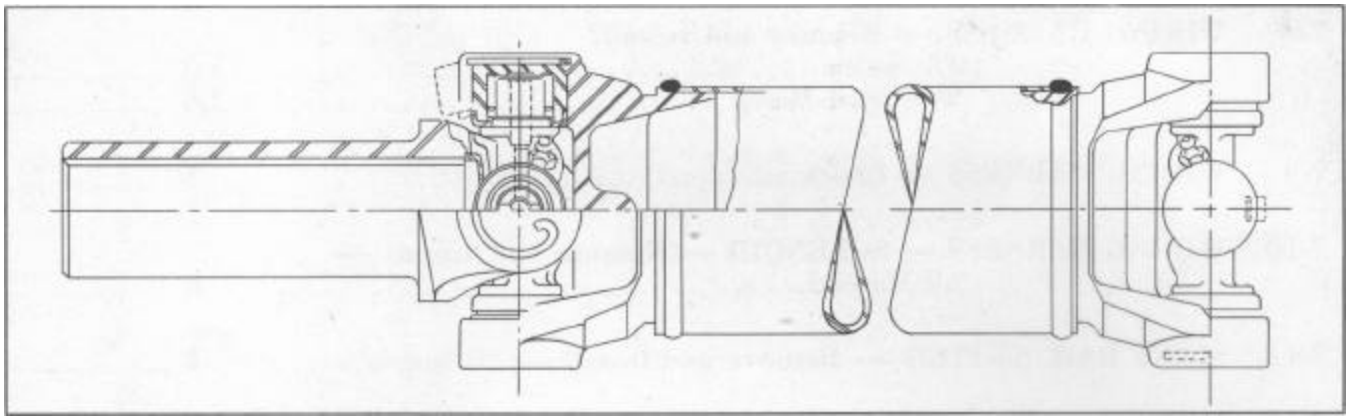
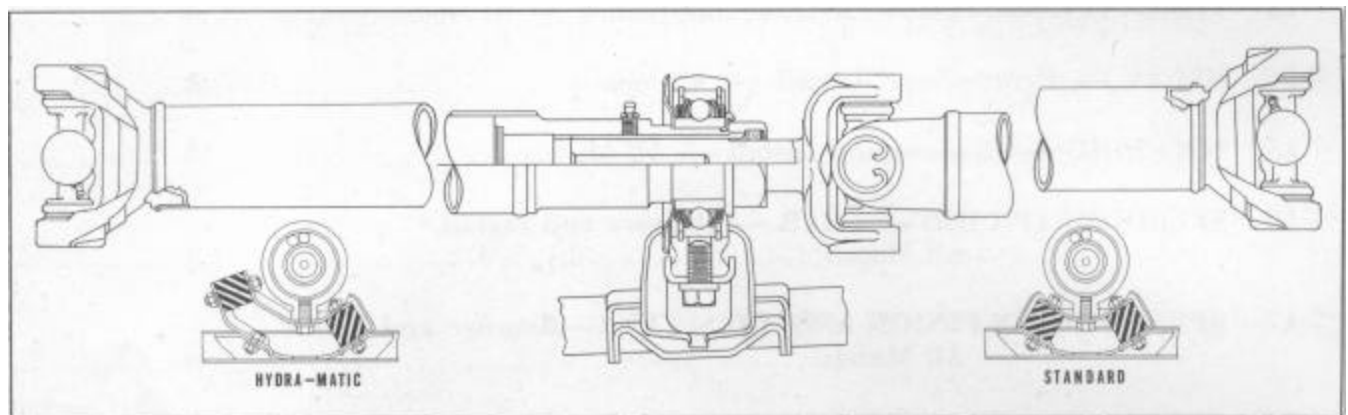
OVERDRIVE

- 69. Pinion cage assembly
- 70. Pinion cage retainer
- 71. Cam assembly
- 72. Cam roller retainer springs
- 73. Cam roller
- 74. Cam roller retainer
- 75. Governor switch
- 76. Lock ring
- 77. Governor pinion
- 78. Sun gear pawl
- 79. Sun gear pawl oil seal
- 80. Solenoid assembly
- 81. Shift fork
- 82. Shift rail sleeve spring

- 83. Lockup rail "C" washer
- 84. Lockup rail washer cup
- 85. Cam retainer clip
- 86. Control shaft
- 87. Control shaft oil seal
- 88. Control lever
- 89. Shift rail
- 90. Shift rail retractor spring
- 91. O/D mainshaft ring gear
- 92. O/D mainshaft output shaft
- 93. Snap ring
- 94. Overdrive housing gasket
- 95. Overdrive housing

- 96. Control shaft locating pin
- 97. Control switch gasket
- 98. Control switch
- 99. Retainer gasket
- 100. Governor drive gear
- 101. Speedometer drive gear
- 102. Woodruff key
- 103. Rear bearing
- 104. Rear brg. retainer snap ring
- 105. Rear bearing spacer washer
- 106. Output shaft snap ring
- 107. Rear bearing retainer
- 108. Output shaft oil seal

OPERATION	DESCRIPTION	TIME	PRICE
7-8	WIRING HARNESS — Remove and Install. All Models With Drive-Master	1.0 1.6	
7-9	WIRING HARNESS — Check	.5	
7-10	WIRING HARNESS — SOLENOID — Remove and Install — All Models	.6	
7-11	SHIFT RAIL SWITCH — Remove and Install — All Models	.4	
7-12	GOVERNOR SWITCH — Remove and Install — All Models	.4	
7-13	THROTTLE SWITCH — Remove and Install — All Models	.4	
7-14	RELAY — Remove and Install — All Models	.4	
7-15	SOLENOID — Remove and Install — All Models	.4	
7-16	SPEEDOMETER DRIVE GEAR — Remove and Install. All Models	1.4	
7-17	SPEEDOMETER PINION AND/OR SLEEVE—Remove and Install. All Models	.4	
7-18	SHIFT RAIL AND/OR FORK — Remove and Install — Overdrive in Car. 1st Type 2nd Type and Jet With Overdrive Removed	2.7 1.6 .7	
7-19	STATIONARY GEAR, PAWL AND/OR BALK RING — Remove and Install. All Models — Overdrive Removed Overdrive in Car	.7 1.9	
1-20	CONTROL CABLE ASSEMBLY — Remove and Install. All Models	.6	
7-21	CONTROL SHAFT — Remove and Install — Overdrive in Car. All Models	1.9	
7-22	ADAPTOR AND/OR GASKETS — Remove and Install — Includes Remove and Install Overdrive. All Models With Drive-Master	3.2 3.5	
7-23	INTERLOCK PLUNGER — Remove and Install. All Models — Includes Remove and Install Overdrive . With Drive-Master	5.6 5.8	
7-24	GOVERNOR DRIVE GEAR — Remove and Install — All Models	1.4	

**JET MODELS****ALL MODELS EXCEPT JET****PROPELLER SHAFT**

8-1	PROPELLER SHAFT ASSEMBLY — FRONT OR REAR — Remove and Install. All Models Except Jet	1.5	_____
8-2	PROPELLER SHAFTS AND UNIVERSAL JOINTS ASSEMBLY — Remove and Install. All Models Except Jet	1.9	_____
8-3	UNIVERSAL JOINT — TRUNNION, BEARINGS, CUPS & SEALS (1 JOINT) — Remove and Install. All Models Except Jet	1.0	_____
8-4	UNIVERSAL JOINTS — Overhaul (Three) — Includes Remove and Install. All Models Except Jet	2.4	_____
8-5	SLEEVE YOKE — Remove and Install	1.0	_____
8-6	"U" BOLTS — FRONT OR RER — Remove and Install. All Models	.5	_____
8-7	"U" BOLTS — Tighten — All All Models	.5	_____

[illegible]

ENGINE—UPPER SECTION

H2-1 Cylinder and piston assembly
 H2-15 Pipe — water distribution
 H3-1 Cylinder head
 H3-5 Gasket — cylinder head
 H3-10 Cap screw — cylinder head
 H3-11 P/Washer — Cylinder head cap screw
 H3-14 Water outlet — cylinder head
 H3-16 Gasket — cylinder head water outlet
 H3-17 Bolt — water outlet front
 H3-18 L/Washer — water outlet bolt
 H3-20 Thermostat
 H3-30 Spark plug
 H4-1 Exhaust — Manifold assembly
 H4-10 Damper — exhaust
 H4-23 Stud — intake to exhaust
 H4-24 Stud — exhaust manifold
 H4-26 Nut — exhaust manifold
 H4-27 P/Washer — exhaust manifold
 H4-35 Elbow — exhaust manifold
 H4-36 Gasket — elbow to manifold
 H4-37 Nut — exhaust manifold
 H5-1 Intake manifold
 H5-15 Clamp — manifold
 H5-32 Nut
 H5-34 Plain washer
 H5-35 Gasket
 H1 1-35 Cover — valve chamber
 H11-40 Screw — valve cover
 H11-d5 Breather tube
 H11-49 Gasket — breather tube
 H11-53 Screw — breather tube
 H13-1 Oil pump assembly
 H13-2 Gasket — oil pump
 H13-5 Cap screw — oil pump
 H14-1 Water pump
 H14-2 Bolt — pump to cylinder
 H14-3 Bolt — pump to cylinder
 H14-13 Gasket — pump to cylinder
 H14-26 Pulley — water pump
 H14-30 Fan belt
 H14-31 Fan blade
 H14-32 Cap screw
 H14-33 Lock washer
 N1-1 Carburetor assembly
 N1-4 Gasket — carburetor
 N 1-6 Deflector — heat
 N1-9 Nut — carburetor
 N1-14 Tube and cover assembly
 N4-1 Fuel pump
 N4-8 Sleeve — pump to cylinder
 N4-9 Bolt — pump to cylinder
 N4-18 Spacer — fuel pump

ENGINE- LOWER SECTION

H6-1 Crankshaft
 H6-2 Bolt — flywheel
 H6-3 Bushing — mainshaft pilot
 H6-4 Retainer
 H6-11 Screw — main bearing cap
 H6-13 Lock plate — main bearing cap
 H6-19 Dowel — main bearing cap
 H8-6 Bearing — connecting rod
 H9-1 Piston
 H9-2 Pin — piston ring
 H9-3 Piston pin
 H9-4 Lock — piston

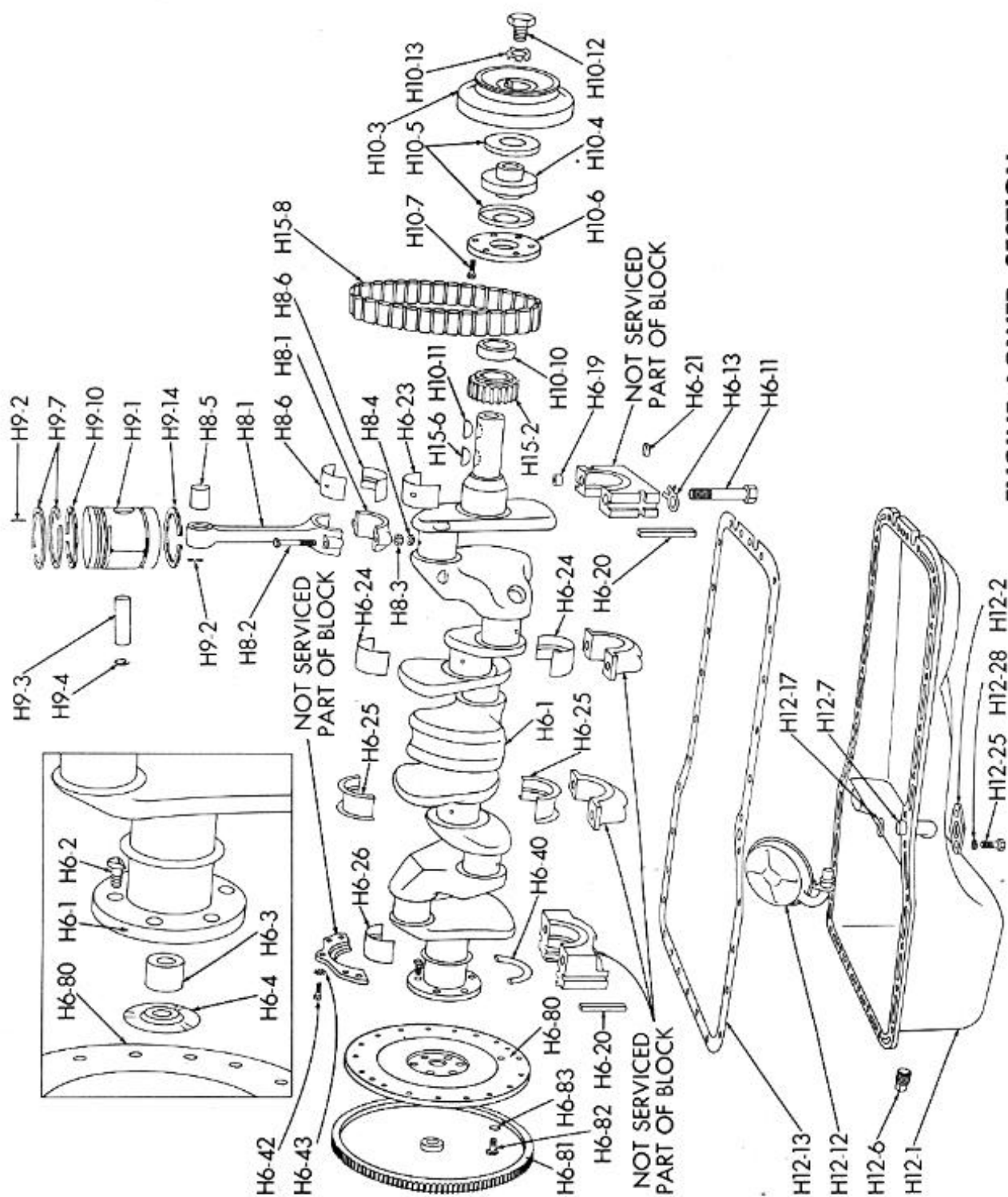
H9-7 Ring — piston upper
 H9-10 Ring — piston upper — oil
 H9-14 Ring — piston lower — oil
 H10-3 Vibration dampener
 H10-4 Hub
 H10-5 Facing — front
 H10-6 Plate — cover
 H10-7 Bolt — cover
 H10-10 Spacer
 H10-11 Key
 H12-1 Pan assembly
 H12-2 Flange — suction pipe
 H12-6 Plug — oil drain
 H12-7 Pipe — oil suction
 H12-12 Screen — oil pan
 H12-13 Gasket — oil pan
 H12-17 Seal — oil pan
 H12-25 Bolt — oil pan
 H12-28 Lock washer — oil pan bolt
 H15-2 Sprocket — crankshaft
 H15-6 Key — sprocket
 H15-8 Timing chain
 H6-23 No. 1 bearing — crankshaft
 H6-24 No. 2 bearing — crankshaft
 H6-25 No. 3 bearing — crankshaft
 H6-26 No. 4 bearing — crankshaft
 H6-40 Seal — rear main bearing
 H6-80 Flywheel
 H6-81 Starter gear — flywheel
 H6-82 Plug — flywheel drain
 H6-83 Gasket — drain plug
 H8 -1 Connecting rod
 H8-2 Bolt — connecting rod
 H8-3 Nut — connecting rod bolt
 H8-4 Companion nut
 H8-5 Bushing — piston pin

ENGINE CAMSHAFT AND VALVES

H7-1 Camshaft
 H7-7 No. 1 bearing — camshaft
 H7-8 No. 2 bearing — camshaft
 H7-9 No. 3 bearing — camshaft
 H7-10 No. 4 bearing — camshaft
 H7-21 Thrust plate — camshaft
 H7-22 Bolt — thrust plate
 H7-23 Lock
 H11-1 Valve — inlet
 H11-3 Valve — exhaust
 H 1 1-6 Guide — inlet
 H11-8 Guide — exhaust
 H11-11 Spring — valve
 H1 1-13 Seat — valve spring
 H11-15 Retainer — valve seat
 H11-18 Tappet
 H11-20 Adjusting screw
 H15-1 Sprocket — camshaft
 H15-5 Bolt — sprocket
 H15-9 Trough — oil
 H15-10 Bolt
 H15-11 Cover — timing chain
 H15-12 Shoe — timing cover
 H15-13 Rivet — cover shoe
 H15-14 Bumper — timing chain
 H15-18 Oil seal — timing cover
 H15-19 Gasket — timing cover
 H15-21 Bolt — timing cover
 H 15-23 Lock washer

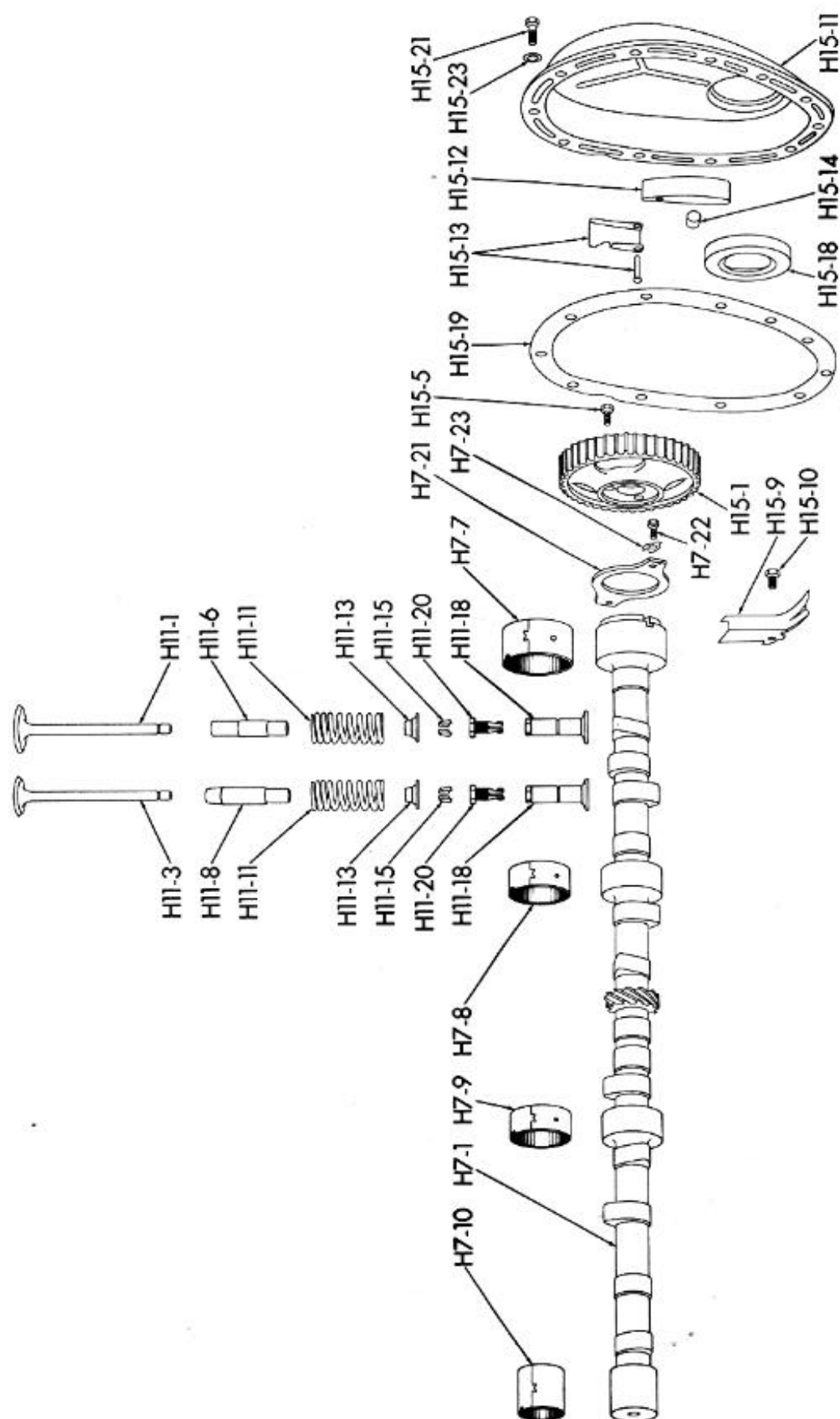
OPERATION	DESCRIPTION	TIME	PRICE
ENGINE			
9-1	ENGINE AND TRANSMISSION ASSEMBLY—Remove and Install.		
	All Models — 6 Cyl. Except Jet	6.2	_____
	Jet	4.7	_____
	8 Cyl.	6.7	_____
	With Drive-Master — Add	.8	_____
	With Overdrive — Add	.5	_____
	With Supermatic — Add	1.2	_____
	With Hydra-Matic, Automatic, or Power Steering — Add EACH	1.4	_____
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. Except Jet	8.3	_____
	Jet	6.7	_____
	8 Cyl.	8.8	_____
	With Drive-Master — Add	1.8	_____
	With Overdrive — Add	.5	_____
	With Supermatic — Add	2.2	_____
	With Hydra-Matic, Automatic, or Power Steering — Add EACH	1.4	_____
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. Except Jet	10.1	_____
	Jet	9.0	_____
	8 Cyl.	11.0	_____
	With Drive-Master — Add	1.8	_____
	With Overdrive — Add	.5	_____
	With Supermatic — Add	2.2	_____
	With Hydra-Matic, Automatic, or Power Steering — Add EACH	1.4	_____
94	CYLINDER BLOCK AND PISTON ASSEMBLY — Install — Includes remove and install subassemblies from old to new block, refacing valves and seats, aligning rods, install piston and rod assemblies, reinstall engine assembly and minor tune-up.		
	All Models — 6 Cyl. Except Jet	21.2	_____
	Jet	19.6	_____
	8 Cyl.	23.2	_____
	With Drive-Master — Add	1.8	_____
	With Overdrive — Add	.5	_____
	With Supermatic — Add	2.2	_____
	With Hydra-Matic, Automatic, or Power Steering — Add EACH	14	_____
9-5	ENGINE — Paint — Includes remove and install spark plugs and ignition wires.		
	All Models — Standard	1.0	_____
	With Drive-Master	1.5	_____

OPERATION	DESCRIPTION	TIME	PRICE
SUPPORT PLATES AND MOUNTINGS			
9-6	ENGINE SUPPORT PLATE (FRONT) — Remove and Install. All Models	3.4	_____
9-7	ENGINE SUPPORT PLATE (REAR) — Remove and Install. All Models — Standard With Drive-Master — Add With Overdrive — Add With Supermatic — Add	5.5 .8 .5 1.2	_____ _____ _____ _____
9-8	ENGINE MOUNTINGS (FRONT) — Remove and Install — Both All Models	1.0	_____
9-9	ENGINE MOUNTINGS (REAR) — Remove and Install — Both All Models — Standard With Hydra-Matic or Automatic	.6 1.0	_____ _____
CAMSHAFT AND MAIN BEARINGS			
9-10	CAMSHAFT — Remove and Install — Includes adjusting tappets and setting timing. All Models — 6 Cyl. 8 Cyl	5.1 5.7	_____ _____
9-11	CAMSHAFT — EXPANSION PLUG AND/OR OIL GALLERY PLUG — Remove and Install. All Models Except Jet Jet (Includes remove and install engine) With Overdrive, Drive-Master, Automatic, Hydra-Matic, or Power Steering — Add EACH	5.6 6.3 1.4	_____ _____ _____
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 — Add With Overdrive — Add With Supermatic — Add With Hydra-Matic or Automatic — Add	9.2 10.2 .8 .5 1.2 2.0	_____ _____ _____ _____ _____ _____
9-13	MAIN BEARINGS — Remove and Install — All — With Engine in Car — Includes removing and install oil pan. All Models — 6 Cyl. With Drive-Master -- Add	3.3 .2	_____ _____
9-14	MAIN BEARINGS — Remove and Install—All—Engine removed from car — (Using factory reamed bearings) . All Models — 6 Cyl . 8 Cyl. :	2.6 2.8	_____ _____
9-15	MAIN BEARINGS — Remove and Install—All—Engine removed from car — Includes line ream. All Models — 8 Cyl.	3.9	_____



ENGINE LOWER SECTION

OPERATION	DESCRIPTION	TIME	a
9-16	MAIN BEARING — OIL LEAK CORRECTION — Includes remove and install oil pan and repacking cap. All Models — 6 Cyl. — Front Rear (Includes crankshaft seal) 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			
9-17	CRANKSHAFT — Remove and Install — Includes remove and install engine. All Models — 6 Cyl. Except Jet Jet 8 Cyl. With Drive-Master — Add With Overdrive — Add With Supermatic, Hydra-Matic, Automatic, or Power Steering — Add	10.9 9.3 11.8 .8 .5 1.4	_____ _____ _____ _____ _____ _____
9-18	VIBRATION DAMPENER — Remove and Install — Includes remove and install radiator. All Models With Power Steering -- Add	1.3 .3	_____ _____
9-19	TIMING COVER GASKET OR OIL SEAL AND SPACER — Remove and Install. All Models With Power Steering Add	2.3 .3	_____ _____
9-20	TIMING CHAIN AND/OR CAMSHAFT SPROCKET — Remove and Install — Includes checking timing. All Models — 6 Cyl. With Power Steering — Add Crankshaft Sprocket — Add	.3.1 .3 .2	_____ _____ _____ _____
9-21	TIMING GEARS — Remove and Install — Includes checking timing. 8 Cyl.	2.6	_____
9-22	FLYWHEEL ASSEMBLY — Remove and Install or Tighten. All Models — 1st Type Transmission (Manual Shift) . With Drive-Master — Add With Overdrive — Add With Supermatic — Add All Models — 2nd Type Transmission (Manual Shift) . With Overdrive — Add With Hydra-Matic or Automatic (Transmission removed) — Add	5.2 .6 .3 1 1 2.8 .4 .5	_____ _____ _____ _____ _____ _____ _____
9-23	FLYWHEEL GEAR — Remove and Install. When flywheel is removed from engine	.6	_____



ENGINE CAMSHAFT & VALVES

OPERATION	DESCRIPTION	TIME	PRICE
CYLINDER BLOCK AND HEAD			
9-24	CYLINDER BLOCK — HONE ALL CYLINDERS — Cylinder head and pistons removed. All Models — 6 Cyl 8 Cyl	4.7 5.9	_____ _____
9-25	CYLINDER BLOCK — HONE ONE CYLINDER — Cylinder head and pistons removed. All Models Each additional cyl. — Add	1.0 .7	_____ _____
9-26	CYLINDER BLOCK — Rebore — All Cylinders — Cylinder head and pistons removed — Includes remove and install studs on 8 Cyl. All Models — 6 Cyl. 8 Cyl.	5.5 7.2	_____ _____
9-27	CYLINDER BLOCK HEAD STUD — Remove and Install — All. All Models — 8 Cyl.	1.0	_____
9-28	CYLINDER BLOCK HEAD STUD — Remove and Install — One — Broken Stud. All Models — 8 Cyl.	.4	_____
9-29	CYLINDER HEAD — Tighten. All Stud Nuts Or Cap Screws With Torque Wrench. All Models — 6 Cyl 8 Cyl. With Twin Carburetors — Add	.4 .5 .3	_____ _____ _____
9-30	CYLINDER HEAD — COMPRESSION TEST -- All Cylinders. All Models — 6 Cyl. 8 Cyl With Twin Carburetors — Add	.8 .9 .3	_____ _____ _____
9-31	CYLINDER HEAD AND/OR GASKET — Remove and Install — Includes removing carbon, and cleaning and adjusting plugs. All Models — 6 Cyl. 8 Cyl. With Twin Carburetors or Power Steering — Add With Drive-Master — Add To drill out and replace a broken stud or cap screw — Add	1.8 2.3 .3 .8 4	_____ _____ _____ _____ _____
CONNECTING RODS, PISTONS AND RUNGS			
9-32	CONNECTING RODS — Align — All — Includes remove and install cylinder 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 With Power Steering — Add	7.1 8.4 .8 .3	_____ _____ _____ _____

OPERATION	DESCRIPTION	TIME	PRICE
9-33	CONNECTING RODS — Align — All — When removed from engine — Includes installing new rings on pistons. All Models — 6 Cyl 8 Cyl.	1.6 2.0	
9-34	CONNECTING RODS — Remove and Install a complete set of new connecting rods, using old pistons — when removed from engine — Align rods. All Models — 6 Cyl. 8 Cyl.	1.0 1.3	
9-35	CONNECTING ROD — Remove and Install — One Only — Includes remove and install oil pan, cylinder head, remove ridge from wall and remove and install one connecting rod, piston and rings. All Models — 6 Cyl. 8 Cyl. With Twin Carburetors or Power Steering — Add With Drive-Master — Add For Each Additional Rod — Add	4.6 5.6 .3 .8 .5	
9-36	CONNECTING RODS — BEARING SHELLS — Remove and Install — All — Includes remove and install oil pan. All Models — 6 Cyl Remove and Install — One For Each Additional Rod Bearing — Add With Drive-Master — Add With Twin Carburetors or Power Steering — Add EACH	3.7 1.6 .3 .2 .3	
9-37	CONNECTING ROD BUSHINGS (UPPER) — Ream and Fit Pins — All — Rods removed. All Models — 6 Cyl 8 Cyl. One Only	2.2 2.7 .4	
9-38	PISTON — Remove and Install — One — With Rings — When oil pan and cylinder head are removed. All Models	.8	
9-39	PISTON, RINGS, AND PINS — Remove and Install — One Cylinder — Includes remove and install oil pan and cylinder head, remove ridge from wall and remove and install piston, rings and aligning rod. All Models — 6 Cyl 8 Cyl With Drive-Master For each additional piston — Add If necessary to hone one cylinder — Add To hone each additional cylinder — Add With Twin Carburetors or Power Steering — Add EACH	4.8 5.3 .8 .7 1.0 .7 .3	
9-40	PISTON RINGS — Remove and Install — Piston out of engine. All Models — One Piston	.2	
941	PISTON PIN — Remove and Install — One — When piston and rod are removed — Includes ream bushings, fit pin and align rod. All Models — Each Pin	.4	

OPERATION	DESCRIPTION	TIME	PRICE
ENGINE COMBINATION OPERATION #1			
9-42	MINOR ENGINE TUNE-UP — Includes clean and regap or replace spark plugs, adjust or replace distributor points, check ignition timing, adjust carburetor and climatic control, clean fuel pump sediment bowl, clean and/or re-oil air cleaner.		
	All Models — 6 Cyl.	1.5	_____
	8 Cyl.	1.7	_____
	With Drive-Master	1.6	_____
	With Twin Carburetors — Add	.2	_____
ENGINE COMBINATION OPERATION #2			
9-43	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. Check throttle control linkage, and throttle valve lever. Includes adjusting tappets.		
	NOTE: If necessary to overhaul carburetor — add Operation 18-2.		
	All Models — 6 Cyl.	3.3	_____
	8 Cyl.	3.7	_____
	With Drive-Master — Add	.2	_____
	With Twin Carburetors, Hydra-Matic, or Automatic — Add EACH	.3	_____
9-44	ENGINE COMBINATION OPERATION #3—Continued		
	VALVES AND/OR SPRINGS AND TAPPET ASSEMBLIES — Remove and Install — Includes remove and install cylinder head, valve covers, refacing valves and seats, adjusting tappets and minor engine tune-up.		
	All Models — 6 Cyl.	6.0	_____
	8 Cyl.	7.3	_____
	With Drive-Master — Add	.8	_____
	With Twin Carburetors or Power Steering — Add EACH	.3	_____
9-45	ENGINE COMBINATION OPERATION #4		
	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.		
	All Models — 6 Cyl.	14.2	_____
	8 Cyl.	15.3	_____
	If necessary to hone cylinders —		
	6 Cyl. — Add	4.7	_____
	8 Cyl. — Add	5.9	_____
	With Drive-Master — Add	.8	_____
	With Twin Carburetors or Power Steering — Add EACH	.8	_____

OPERATION	DESCRIPTION	TIME	PRICE
ENGINE COMBINATION OPERATION #5			
9-46	VALVES, RINGS AND CONNECTING ROD BEARINGS — Includes grinding valves, clean carbon, replace piston rings and connecting rod bearings and minor tune-up. All Models — 6 Cyl	10.9	_____
	With Twin Carburetors or Power Steering — Add EACH	.3	_____
ENGINE COMBINATION OPERATION #6			
9-47	VALVES, VALVE GUIDES AND SPRINGS — Includes remove and install cylinder head, refacing valves and seats, replacing all guides and springs and minor tune-up. All Models — 6 Cyl	9.5	_____
	8 Cyl	11.0	_____
	With Drive-Master — Add	.8	_____
	With Twin Carburetors or Power Steering — Add EACH	.3	_____
VALVES, SPRINGS, TAPPETS AND GUIDES			
9-48	TAPPETS — Adjust All — Includes remove and install right front wheel and valve tappet covers. All Models — 6 Cyl.	1.5	_____
	8 Cyl.	1.9	_____
9-49	TAPPET ASSEMBLIES — Remove and Install — All — Including Guides — Includes remove and install cylinder head and adjusting tappets. All Models — 8 Cyl	4.8	_____
9-50	TAPPET ASSEMBLY — Remove and Install — One — Unnecessary to remove cylinder head — Includes remove and install valve covers. All Models — 8 Cyl.	1.5	_____
9-51	TAPPET ASSEMBLIES — Remove and Install — All — Unnecessary to remove cylinder head or valves—Includes remove oil pan and valve covers and camshaft and adjust tappets. All Models — 6 Cyl.	6.7	_____
9-52	VALVE TAPPET COVERS — Remove and Install — Includes replacing gasket. All Models — 6 Cyl. — Front	.3	_____
	Rear	.4	_____
9-52	VALVE TAPPET COVERS — Continued All Models — 8 Cyl. — Front	.3	_____
	Rear	.5	_____
9-53	VALVES — Grind — Includes remove carbon, adjust tappets and minor engine tune-up. All Models — 6 Cyl	6.4	_____
	8 Cyl.	7.1	_____
	With Drive-Master — Add	.6	_____
	With Twin Carburetors or Power Steering — Add EACH	.3	_____

OPERATION	DESCRIPTION	TIME	PRICE
9-54	VALVES AND/OR VALVE SPRINGS — 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 With Twin Carburetors or Power Steering — Add EACH	3.3 3 4 .2 .8 .3	_____ _____ _____ _____ _____
9-55	VALVE GUIDES — Remove and Install — When valves are removed. All Models — One Guide Each Additional Guide	.3 .3	_____ _____
ENGINE LUBRICATION			
9-56	OIL CHECK VALVE — Remove and Install. All Models — 6 Cyl , 8 Cyl. With Drive-Master — 6 Cyl. With Hydra-Matic or Automatic Transmission	.3 .4 1 1 .5	_____ _____ _____ _____
9-57	OIL PAN ASSEMBLY — Remove, Clean Screen and Pan and Install — Includes replacing gaskets. All Models — 6 Cyl 8 Cyl With Drive-Master -- Add	1.6 2.1 .2	_____ _____ _____
9-58	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	_____ _____ _____
9-59	OIL PUMP — Overhaul — Includes remove and install and checking timing. All Models	1.1	_____
9-60	OIL PUMP SUCTION PIPE — Remove and Install. All Models — 8 Cyl	.2	_____
9-61	OIL PUMP TO CHECK VALVE PIPE — Remove and Install. All Models	.3	_____
9-62	OIL PRESSURE SWITCH — Remove and Install. All Models — 6 Cyl.	4	_____
9-63	OIL PRESSURE INDICATOR LIGHT — See "Instrument Panel" under Body Section.		
9-64	OIL PRESSURE CHECK — Includes re move a install pressure switch and install test gauge. All Models — 6 Cyl.	.4	_____

OPERATION	DESCRIPTION	TIME	PRICE
BODY AND HARDWARE			
DOORS			
10-1	DOOR ASSEMBLY — Complete — Remove and Install. All Models — Front Rear	1.5 1.7	_____ _____
10-2	DOOR ASSEMBLY — Skeleton — Remove and Install — Does not include painting. Includes trim, glass and hardware. All Models — Front Rear	4.5 4.0	_____ _____
10-3	DOOR (FRONT) WINDOW REGULATOR ASSEMBLY — Remove and Install. All Models Except Jet Jet Only	1.6 1.0	_____ _____
104	DOOR (REAR) WINDOW REGULATOR ASSEMBLY — Remove and Install. All Models Except Jet Jet Only	1.3 1.0	_____ _____
10-5	DOOR VENTILATING WING REGULATOR ASSEMBLY (CRANK TYPE) — Remove and Install. All Models	2.0	_____
10-6	DOOR VENTILATING WING REGULATOR ASSEMBLY (FRIC-TION TYPE) — Remove and Install. All Models	1.2	_____
10-7	DOOR WINDOW REGULATOR HANDLES AND/OR ESCUTCH-EONS — Remove and Install — One All Models	.2	_____
10-8	DOOR ARM RESTS — FRONT OR REAR — Remove and Install — One All Models Except 1954 Hornet, Wasp and Jet 1954 Hornet, Wasp and Jet	.2 .8	_____ _____
10-9	DOOR HANDLE (INSIDE) AND/OR ESCUTCHEON — Remove and Install — One All Models	.2	_____
10-10	DOOR HANDLE — OUTSIDE — Remove and Install — One. All Models	.2	_____
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 Except Jet — Front Rear Jet Only — Front or Rear	2.2 1.7 1.1	_____ _____ _____
10-13	DOOR LOCK REMOTE CONTROL ASSEMBLY — Remove and Install. All Models — Front or Rear	1.5	_____

OPERATION	DESCRIPTION	TIME	PRICE
10-14	DOOR LOCK STRIKER PLATE — Remove and Install and Adjust. All Models	.3	_____
10-15	DOOR CHECK STRAP — Remove and Install. All Models	1.3	_____
10-16	DOOR HINGE AND/OR HINGE PIN — Remove and Install. All Models — Front Upper and Lower and Rear Lower Upper Rear	.6 .2	_____ _____
WEATHERSTRIPPING			
10-17	FRONT DOOR OPENING WEATHERSTRIP — UPPER — RIGHT OR LEFT — Remove and Install. All Models	.4	_____
10-18	FRONT DOOR OPENING WEATHERSTRIP — LOWER—RIGHT OR LEFT — Remove and Install. All Models	.3	_____
10-19	FRONT DOOR OPENING WEATHERSTRIP — FRONT PILLAR (Dogleg) — Remove and Install. All Models Except Jet	.4	_____
10-20	FRONT DOOR (FRONT) WEATHERSTRIP AT BELT LINE (S-Rubber) — Remove and Install. All Models	.3	_____
10-21	FRONT DOOR (FRONT) WEATHERSTRIP — LOWER — Remove and Install — Right or Left. All Models	.3	_____
10-22	FRONT DOOR VENTILATING WING (CRANK TYPE) WEATHERSTRIP — Remove and Install. All Models	2.2	_____
10-23	FRONT DOOR VENTILATING WING (FRICTION TYPE) WEATHERSTRIP — Remove and Install. All Models Except Jet Jet Only	2.0 1.2	_____ _____
10-24	REAR DOOR BOTTOM WEATHERSTRIP — Remove and Install. All Models — Sedans Broughams and Coupes	.5 .6	_____ _____
10-25	REAR DOOR OPENING WEATHERSTRIP — FRONT — Remove and Install — One. All Models	.2	_____
10-26	REAR DOOR WEATHERSTRIP — REAR — Remove and Install — One. All Models	.2	_____
10-27	REAR DOOR WEATHERSTRIP — UPPER — Remove and Install — One. All Models	.4	_____

OPERATION	DESCRIPTION	TIME	PRICE
10-28	QUARTER WINDOW WEATHERSTRIP — Remove and Install. All Models — Sedans Broughams and Coupes	.9 1.2	_____ _____
DOOR LINERS			
10-29	FRONT DOOR INNER PANEL LINER — INNER — Remove and Install — One. All Models Except Jet — Sedans Broughams and Coupes Jet Only	.9 .7 .5	_____ _____ _____
10-30	FRONT DOOR INNER PANEL LINER — OUTER — Remove and Install — One. All Models — Sedans Broughams and Coupes	2.6 2.7	_____ _____
10-31	REAR DOOR INNER PANEL LINER — INNER — Remove and Install — One. All Models Except Jet — Sedans Jet Only	.6 .5	_____ _____
10-32	REAR DOOR INNER PANEL LINER — OUTER — Remove and Install — One. All Models — Sedans	1.9	_____
10-33	QUARTER WINDOW INNER PANEL LINER — OUTER — Remove and Install — One. All Models — Broughams and Coupes	3.7	_____
10-34	QUARTER WINDOW WATER BAFFLE — Remove and Install — One. All Models — Sedans	3.1	_____
SEATS, SEAT TRACK AND UPHOLSTERY			
10-35	FRONT SEAT AND SEAT TRACK ASSEMBLY — Remove and Install. All Models	.8	_____
10-36	FRONT SEAT TRACK Remove Install RIGHT OR LEFT Jet Only	.5	_____
10-37	REAR SEAT BACK ASSEMBLY — Remove and Install. All Models Except Jet — 3 Pieces 1 Piece Jet Only	.7 .6 .5	_____ _____ _____
10-38	FRONT SEAT BACK ROBE HANGERS — Remove and Install. All Models Except Jet — Sedans — One Broughams and Coupes — Two Jet Only	.5 .6 .3	_____ _____ _____

OPERATION	DESCRIPTION	TIME	PRICE
10-39	SEAT CUSHION — UPHOLSTERY — Includes Remove and Install seat covering — factory cut to size. All Models — Sedans	1.5	_____
10-40	REAR SEAT BACKS — UPHOLSTERY — Includes Remove and Install covering — factory cut to size. Commodore Models All Others	1.6 1 0	_____ _____
10-41	FRONT SEAT BACK — UPHOLSTERY — Includes Remove and Install covering — factory cut to size. All Models	2.0	_____
10-42	REAR SEAT CENTER ARM REST — UPHOLSTERY — Remove and Install. All Models — Cloth Trim	.9	_____ _____
WINDSHIELD			
10-43	WINDSHIELD' GLASS AND/OR WEATHERSTRIP — Remove and Install. All Models — One Side Both Sides One Piece Windshield Jet Only — With Outside Chrome Mouldings — Add . .	1.5 2.9 1.8 .5	_____ _____ _____ _____
10-44	WINDSHIELD — Reseal to eliminate leaks. All Models	.5	_____
10-45	WINDSHIELD GARNISH MOULDING — RIGHT OR LEFT — Remove and In- stall. All Models	.3	_____
10-46	WINDSHIELD WIPER ARMS — Adjust Travel. All Models	.3	_____
10-47	WINDSHIELD WIPER CONTROL KNOB ASSEMBLY — Remove and Install. All Models	.3	_____
10-48	WINDSHIELD WIPER MOTOR — Remove and Install. All Models	.5	_____
10-49	WINDSHIELD WIPER PULLEY HOUSING AND CABLE — Remove and Install. All Models	.7	_____ _____
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	_____

OPERATION	DESCRIPTION	TIME	PRICE
WINDOWS, REGULATORS AND MOULDINGS			
10-52	DOOR GLASS — Remove and Install. All Models Except Jet — Sedans — Front	1.8	_____
	Rear	1.3	_____
	Broughams and Coupes	2.0	_____
	Jet Only — Front or Rear	1.0	_____
10.53	DOOR VENTILATING WING GLASS — Remove and Install. All Models Except Jet	1.8	_____
	Jet Only — Front or Rear	1.3	_____
10.54	QUARTER WINDOW GLASS — Remove and Install. All Models — Sedans	.6	_____
	Broughams and Coupes	.7	_____
10-55	QUARTER WINDOW HINGE BRACKET — Remove and Install. Hollywood Models	1.2	_____
10-56	REAR WINDOW (SINGLE) GLASS AND/OR WEATHERSTRIP — Remove and Install. All Models	1.8	_____
	With Chrome Moulding — Add	.5	_____
10.57	REAR WINDOW (DOUBLE) GLASS AND/OR WEATHERSTRIP — Remove and Install. All Models — One Side	2.8	_____
	Both Sides	3.0	_____
10-58	DOOR GLASS RUN CHANNEL — Remove and Install. All Models Except Jet — Sedan — Front	1.8	_____
	Rear	1.3	_____
	Brougham and Coupes	1.9	_____
	Jet Only — Front or Rear	1.1	_____
10-59	CENTER BAR GLASS RUN — Remove and Install. All Models	1.0	_____
10-60	WINDOW REGULATOR ASSEMBLIES — Free Up — Includes remove moulding to oil mechanism. All Models	.5	_____
10-61	QUARTER WINDOW REGULATOR ASSEMBLY — Remove and Install. All Models — Broughams and Coupes	2.0	_____
10-62	QUARTER WINDOW GARNISH MOULDING — Remove and Install. All Models — Broughams and Coupes	.3	_____
10-63	DOOR WINDOW GARNISH MOULDING — Remove and Install. All Models — Front or Rear	.3	_____
10-64	FRONT DOOR REVEAL MOULDING — Remove and Install. All Models Except Jet — Sedans and Broughams	1.3	_____
10-65	REAR DOOR REVEAL MOULDING — Remove and Install. All Models — Sedans	.8	_____

OPERATION	DESCRIPTION	TIME	PRICE
BODY INTERIOR TRIM			
10-66	DOOR WINDLACE — Remove and Install — Complete. All Models— One Door	.5	_____
10-67	QUARTER TRIM PANEL — Remove and Install. All Models — Sedans	.6	_____
	Broughams and Coupes	.9	_____
10-68	FLOOR MAT — FRONT OR REAR TONNEAU OR REAR COMPARTMENT — Re move and Install. All Models	.2	_____
10-69	COWL KICK PANEL — Remove and Install. All Models	.4	_____
10-70	DOOR POCKET TRIM PANEL — Remove and Install. All Models	.7	_____
10.71	DOOR PILLAR POST TRIM PANEL — Remove and Install. All Models	.4	_____
10-72	DOOR TRIM PANEL — FRONT AND REAR — OUTER — Remove and Install. All Models	.3	_____
10-73	DOOR POCKET MOULDING — Remove and Install. All Models — Each	.3	_____
10-74	HEADLINING — Remove and Install. All Models — Sedans and Broughams	5.5	_____
	Coupes	5.0	_____
10-75	ROOF PANEL INSULATION — Replace or Install New. All Models — Sedans	5.9	_____
	Broughams and Coupes	5.4	_____
10-76	SUN VISOR — Remove and Install — One. All Models	.2	_____
10-77	REAR COMPARTMENT DOOR — Remove and Install and Align. All Models	1.0	_____
10-78	REAR COMPARTMENT DOOR WEATHERSTRIP — Remove and Install. All Models	.9	_____
10.79	REAR COMPARTMENT DOOR NAME PLATE — Remove and Install. All Models	.3	_____
10-80	REAR COMPARTMENT DOOR LOCK ASSEMBLY — Remove and Install. All Models — 480-490-500	.5	_____

OPERATION	DESCRIPTION	TIME	PRICE
10-81	REAR COMPARTMENT DOOR LOCK HANDLE AND/OR CYLINDER — Remove and Install. All Models — 480-490-500 All Others — Lock and Cylinder	.3 .5	 _____
10-82	REAR COMPARTMENT DOOR LATCH OPERATING LEVER — Remove and Install — One. All Models — 480-490-500	.3	_____
10-83	REAR COMPARTMENT DOOR HINGE AND/OR SPRING — Remove and Install. All Models	.5	_____
10-84	REAR COMPARTMENT DOOR STRIKER — Remove and Install. All Models	.2	_____
INSTRUMENT PANEL AND INSTRUMENTS			
10-85	INSTRUMENT PANEL ASSEMBLY COMPLETE — Remove and Install. All Models — Commodores 480-490-500 and "A" Series Supers 480-490-500 and "A" Series . . .	4.6 4.0	 _____
10-86	INSTRUMENT PANEL CLUSTER ASSEMBLY — Remove and Install. All Models — "A," "B" and "C" Series	1.3	_____
10-87	INSTRUMENT CLUSTER ASSEMBLY — Remove and Install. All Jet and 1954 Models	1.5	_____
10-88	INSTRUMENT CLUSTER GLASS — Remove and Install. 1954 Hornet and Wasp Jet	1.8 5	 _____
1089	INSTRUMENT PANEL TOP COVERING (LEATHER) — Remove and Install. Jet Models All Others	2.5 1 3	 _____
10-90	INSTRUMENT FINISH PANEL — Remove and Install. All Models — Center Section — 480-490-500 Series . . Left Section — 480-490 Series Left Section — 500 Series	.7 .3 .7	 _____ _____
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	.4	_____

OPERATION	DESCRIPTION	TIME	PRICE
10-95	RHEOSTAT — LIGHT SWITCH — Remove and Install	.2	_____
10-96	STARTER BUTTON SWITCH — Remove and Install. All Models	.2	_____
10-97	STARTER SWITCH AND IGNITION LOCK ASSEMBLY — Remove and Install	.4	_____
10-98	SPEEDOMETER HEAD — Remove and Install. All Models — 480-490-500 Series	.5	_____
	"A," "B," and "C" Series Except Jet	.7	_____
	Jet and 1954 Hornet and Wasp	1.8	_____
10-99	SPEEDOMETER LENS — Remove and Install. All Models — 480-490-500, "A," "B" and "C" Series .	.7	_____
10-100	SPEEDOMETER CABLE ASSEMBLY — Remove and Install. All Models	.6	_____
10-101	SPEEDOMETER CABLE — Remove and Install. All Models	.4	_____
10-102	SPEEDOMETER PINION — Remove and Install. All Models	.4	_____
10-103	CLOCK — Remove and Install. All Models — 480-490-500, "A," "B" and "C" Series Except Jet	.7	_____
	Jet and 1954 Hornet and Wasp	1.8	_____
10-104	INSTRUMENT PANEL LIGHT BULB — Remove and Install — Any One		
	All Models Except Jet	.2	_____
	Jet — High Beam	1.0	_____
10-105	FUEL OR TEMPERATURE GAUGE — Remove and Install. All Models — 480-490-500, "A," "B" and "C" Series Except Jet	.7	_____
	Jet and 1954 Hornet and Wasp	1.8	_____
10-106	DIMMER SWITCH — Remove and Install. All Models	.4	_____

CONVERTIBLE BODY

TOP COVERING, MOTOR AND PUMP ASSEMBLY AND OPERATING CYLINDERS

10-107	TOP — COMPLETE ASSEMBLY — Remove and Install and Adjust — Bows, top covering attached. All Models	5.5	_____
10-108	TOP COVERING — Remove and Install — Includes rear curtain. All Models	7.4	_____
10-109	TOP COVERING — Remove and Install — Less rear curtain. All Models	5.5	_____

OPERATION	DESCRIPTION	TIME	PRICE
10-110	TOP REAR CURTAIN AND EXTENSION OR REAR BOW MOULDING — Remove and Install. All Models	4.3	_____
10-111	REAR CURTAIN (ONLY) — Remove and Install. All Models	1.0	_____
10-112	REAR CURTAIN WINDOW FRAME — Remove and Install .	.7	_____
10-113	REAR CURTAIN WINDOW FRAME WEATHERSTRIP — Remove and Install	.7	_____
10-114	REAR CURTAIN LOWER MOULDING — Remove and Install. All Models	.4	_____
10-115	HYDRAULIC MOTOR AND PUMP ASSEMBLY — Refill. All Models	.6	_____
10-116	HYDRAULIC MOTOR AND PUMP ASSEMBLY — Drain and refill system. All Models	1.5	_____
10-117	HYDRAULIC MOTOR AND PUMP ASSEMBLY — Remove and Install. All Models	2.2	_____
10-118	REAR QUARTER WINDOW REGULATOR — CYLINDER — Remove and Install — Includes draining and refilling system. All Models	3.5	_____
10-119	TOP CONTROL VALVE ASSEMBLY — Remove and Install. All Models	1.0	_____
10-120	TOP OPERATING CYLINDER AND YOKE, ANCHOR OR CLEVIS PIN ASSEMBLY — Remove and Install. All Models — One Side	1.5	_____
10-121	QUARTER PILLAR ASSEMBLY — Remove and Install. All Models — One Side	.8	_____
10-122	TOP QUARTER PILLAR UPPER BRACKET — Remove and Install — Right or Left Hand. All Models — One Two	1.5 2.9	_____ _____
10-123	QUARTER PILLAR RAIL — Remove and Install — Right or Left Hand. All Models	1.0	_____
TOP HEADER, BOWS, SIDE RAILS, AND MOULDINGS			
10-124	TOP FRONT HEADER ASSEMBLY — Remove and Install. All Models	2.5	_____
10-125	HEADER TO SIDE RAIL BRACKET — Remove and Install — Right or Left Hand. All Models	2.0	_____

OPERATION	DESCRIPTION	TIME	PRICE
10-126	HEADER — FRONT LOWER OR UPPER MOULDING — Remove and Install. All Models	.4	_____
10-127	HEADER MOULDING — REAR — Remove and Install. All Models	.4	_____
10-128	TOP REAR BOW MOULDING — Remove and Install. All Models	.4	_____
10-129	TOP PADS — Two — Remove and Install. All Models	4.5	_____
10-130	QUARTER FLAP RETAINER — Remove and Install — Right or Left Hand. All Models	.2	_____
10-131	TOP HOLD-DOWN CLAMP ASSEMBLY OR BALANCE LINK — Remove and Install — Right or Left Hand. All Models	.2	_____
10-132	TOP FRONT SIDE RAIL HINGE — Remove and Install — Right or Left Hand. All Models	1.0	_____
10-133	FRONT SIDE RAIL #2 BOW CONTROL LINK BRACKET — Remove and Install — Right or Left Hand. All Models	.2	_____
10-134	#2 BOW CONTROL LINK ASSEMBLY — Remove and Install — Right or Left Hand. All Models	.4	_____
10-135	#2 BOW CONTROL LINK ASSEMBLY — REAR — Remove and Install — Right or Left Hand. All Models	.7	_____
10-136	#3 BOW — Remove and Install. All Models	2.2	_____
10-137	TOP PIVOT BRACKET BRACE — Remove and Install — Right or Left Hand. All Models	.8	_____
DOOR WINDOWS, REGULATORS, AND SWITCHES			
10-138	DOOR WINDOW HYDRAULIC HOSE — Remove and Install. All Models	1.0	_____
10-139	DOOR WINDOW REGULATOR ASSEMBLY — HYDRAULIC — Right or Left Hand — Remove and Install. All Models	1.8	_____
10-140	DOOR WINDOW REGULATOR ASSEMBLY — MANUAL CONTROL — Remove and Install. — Right or Left Hand. All Models	2.0	_____

OPERATION	DESCRIPTION	TIME	PRICE
10-141	DOOR WINDOW REGULATOR ROLLER GUIDE TIE BAR ASSEMBLY — Remove and Install — Right or Left Hand. All Models	2.0	_____
10-142	DOOR WINDOW REGULATOR CROSS ARM ASSEMBLY — MANUAL — Remove and Install — Right or Left Hand. All Models	2.0	_____
10-143	DOOR WINDOW STOP BUMPER — Remove and Install or Adjust — Right or Left Hand. All Models	.4	_____
10-144	DOOR WING FRAME AND GLASS ASSEMBLY — Remove and Install — Right or Left Hand. All Models	1.0	_____
10-145	DOOR WING GLASS — Remove and Install — Right or Left Hand. All Models	.4	_____
10-146	DOOR WINDOW CENTER BAR GLASS RUN — Remove and Install — Right or Left Hand. All Models	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 — Right or Left Hand. All Models	1.1	_____
10-150	QUARTER WINDOW HINGE OR BRACKET — Remove and Install — Right or Left Hand. All Models	.8	_____
10-151	QUARTER WINDOW REGULATOR ASSEMBLY — MANUAL CONTROL — Remove and Install. — Right or Left Hand. All Models	1.5	_____
10-152	QUARTER WINDOW REGULATOR ASSEMBLY — HYDRAULIC — Remove and Install. All Models	1.8	_____
10-153	QUARTER WINDOW REGULATOR GUIDE — Remove and Install — Right or Left Hand. All Models -	1.4	_____
10-154	QUARTER WINDOW REGULATOR PANEL ASSEMBLY — Remove and Install — Right or Left Hand. All Models	.9	_____

OPERATION	DESCRIPTION	TIME	PRICE
10-155	QUARTER WINDOW ASSEMBLY — Remove and Install or Reseal — Right or Left Hand. All Models	.7	_____
DOOR HINGES, LOCKS AND MOULDINGS			
10-156	DOOR WINDOW OR FRONT SEAT BACK VALANCE — Remove and Install — Right or Left Hand. All Models	.3	_____
10-157	QUARTER BELT MOULDING — Remove and Install — Right or Left Hand. All Models	.7	_____
10-158	REAR BELT MOULDING — Remove and Install. All Models	4.3	_____
10-159	DOOR BELT MOULDING — Remove and Install — Right or Left Hand. All Models	1.3	_____
10-160	DOOR HINGE ASSEMBLY — UPPER OR LOWER — Remove and Install — Right or Left Hand. All Models	.6	_____
10-161	DOOR LOCK ASSEMBLY — Remove and Install — Right or Left Hand. All Models	1.7	_____
10-162	DOOR REMOTE CONTROL ASSEMBLY — Remove and Install — Right or Left Hand. All Models	1.6	_____
BODY INTERIOR TRIM AND SEATS			
10-163	PILLAR WINDLACE ASSEMBLY — FRONT OR REAR — Remove and Install — Right or Left Hand. All Models	.2	_____
10-164	REAR FLOOR SIDE CARPET ASSEMBLY — Remove and Install — Right or Left Hand. All Models	.4	_____
10-165	REAR FLOOR MAT AND PAD ASSEMBLY—Remove and Install. All Models	.6	_____
10-166	FRONT SEAT FRAME AND BACK — COMPLETE — Remove and Install. All Models	.4	_____
10-167	REAR SEAT BACK SUPPORT — Remove and Install — Right or Left Hand. All Models	.8	_____
10-168	REAR SEAT CENTER ARM REST — Upholstery—Includes remove and install. All Models	1.5	_____
10-169	QUARTER TRIM SUPPORT PANEL ASSEMBLY — FRONT — Remove and Install — Right or Left Hand. All Models	.3	_____

OPERATION	DESCRIPTION	TIME	PRICE
10-170	QUARTER TRIM SUPPORT PANEL ASSEMBLY — REAR — Remove and Install — Right or Left Hand. All Models	.7	_____
WEATHERSTRIPPING			
10-171	DOOR OPENING OR BELT WEATHERSTRIP — Remove and Install — Right or Left Hand. All Models	.3	_____
10-172	DOOR BOTTOM WEATHERSTRIP — Remove and Install — Right or Left Hand. All Models	6	_____
10-173	DOOR REAR WEATHERSTRIP — Remove and Install — Right or Left Hand. All Models	.3	_____
10-174	DOOR WING RETAINER AND WEATHERSTRIP — Remove and Install — Right or Left Hand. All Models	1.5	_____
10-175	DOOR WING WEATHERSTRIP — Remove and Install — Right or Left Hand. All Models	.6	_____
10-176	CENTER BAR AND WEATHERSTRIP ASSEMBLY — Remove and Install. All Models	1.7	_____
10-177	CENTER BAR VENT WING WEATHERSTRIP — Remove and Install — Right or Left Hand. All Models	2.0	_____
10-178	DOOR WINDOW MOULDING AND WEATHERSTRIP ASSEMBLY — Remove and Install — Right or Left Hand. All Models	.2	_____
10-179	QUARTER WINDOW MOULDING AND WEATHERSTRIP ASSEMBLY — Remove and Install — Right or Left Hand. All Models	.1	_____
10-180	QUARTER WINDOW WEATHERSTRIP — FRONT — Remove and Install — Right or Left Hand. All Models	.2	_____
10-181	QUARTER WINDOW BELT WEATHERSTRIP — Remove and Install — Right or Left Hand. All Models	.7	_____
10-182	FOLDING TOP HEADER JOINT WEATHERSTRIP—UPPER OR LOWER — Remove and Install. All Models	4	_____
10-183	WINDSHIELD FRONT PILLAR WEATHERSTRIP — Remove and Install. All Models	2	_____
10-184	TOP SIDE RAIL WEATHERSTRIP — FRONT, INTERMEDIATE OR REAR — Remove and Install — Right or Left Hand. All Models	.3	_____

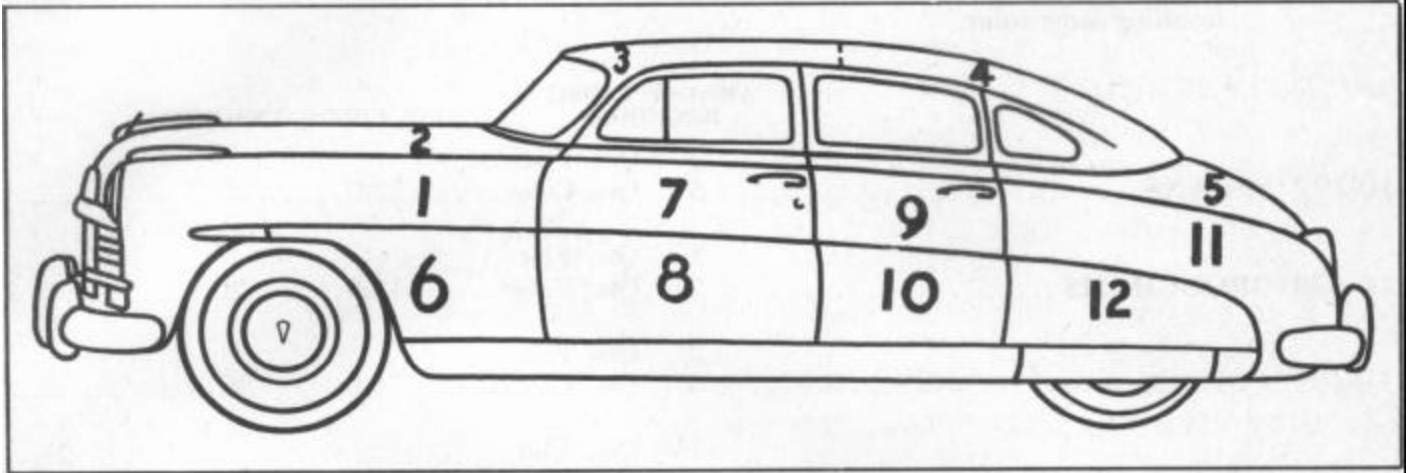
BODY REFINISHING

PAINT MATERIAL

The suggested time and amount of paint material for each operation is shown after the area locations as indicated by numbers on the car paint sketch below.

This includes completely sanding, priming and refinishing the area as indicated on the sketch.

The time allowances also include masking of mouldings or hardware and polishing out finish. All Models except Jet. For all Jet bodies, 1/10 less than time shown.

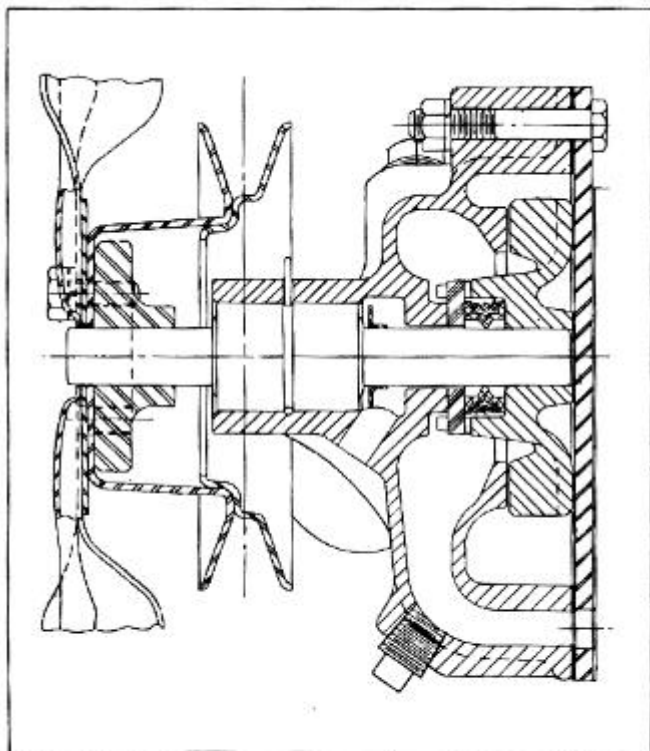
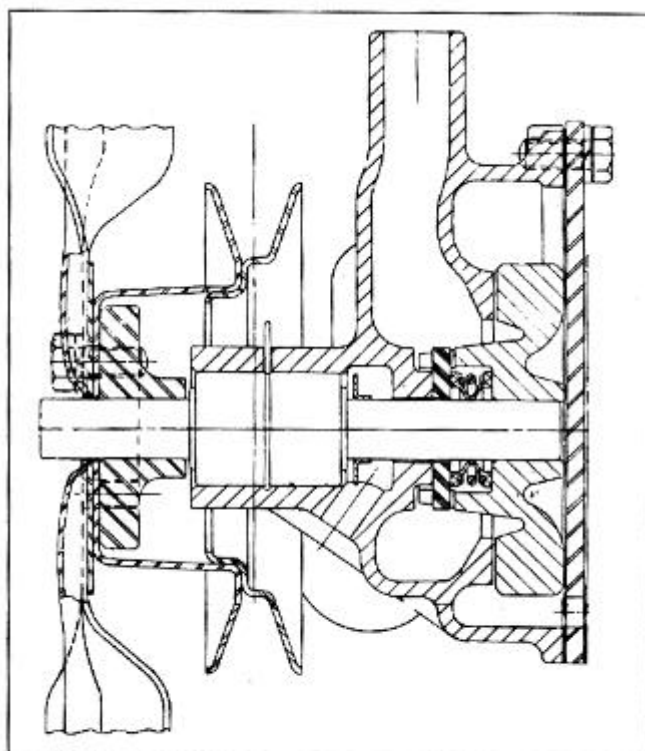


OPER. NO.	DESCRIPTION	PAINTING MATERIAL REQUIRED		
10-185-1	FRONT FENDER — (Upper One Side) — Refinish — All Models	1 Pt.	1.5	_____
10-186-2	HOOD — (Complete Area) — Refinish — All Models . .	1-1/2 Qt.	3.0	_____
10-187-3	ROOF PANEL — (Front) — Refinish — All Models . . .	1 Qt.	2.0	_____
10-188-4	ROOF PANEL — (Rear) — Refinish — All Models	1 Qt.	2.0	_____
10-189-5	REAR COMPARTMENT DOOR — (Complete Area) — (Refinish) — All Models	1 Qt.	2.0	_____
10-190-6	FRONT FENDER (Lower) — (One Side) — Refinish — All Models	1/2 Pt.	1.0	_____
10-191-7	FRONT DOOR UPPER PANEL — (One Side) — Refinish — All Models	1/2 Pt.	1.0	_____
10-192-8	FRONT DOOR LOWER PANEL — (One Side) — Refinish — All Models	1/2 Pt.	1.0	_____
10-193-9	REAR DOOR UPPER PANEL — (One Side) — Refinish — All Models	1/2 Pt.	1.0	_____

		AMOUNT FINISH REQUIRED	ONE COLOR	TWO COLOR		
10-197	SEDANS	2 5	Qts Flat Qts Color	22.0	23.5	_____
10-198	BROUGHAMS	2 5	Qts Flat Qts Color	19.0	20.5	_____
10-199	COUPES	2 5	Qts Flat Qts Color	20.0	21.5	_____
10-200	CONVERTIBLES	1-1/2 4	Qts Flat Qts Color	16.0	17.5	_____
10-201	REMOVING ALL BODY PAINT DOWN TO METAL — Includes removing mouldings and all masking.					
	All Models — Closed Bodies				8.0	_____
	Convertibles				5.9	_____
10-202	LIQUID GLAZE — Includes wash, clean, seal and Liquid Glaze.					
	Closed Bodies				4.0	_____
	Convertibles				3.0	_____

[illegible]

OPERATION	DESCRIPTION	TIME	PRICE
COOLING SYSTEM			
11-1	COOLING SYSTEM — Drain, Flush and Refill. All Models	.5	_____
11-2	WATER JACKET COVER OR GASKET — Remove and Install. All Models — 8 Cyl.	1.4	_____
	With Drive-Master	2.4	_____
11-3	CYLINDER WATER JACKET PLUGS — Remove and Install. All Models — 6 Cyl. — 3 Plugs	1.5	_____
	Front Plug	.7	_____
	Center Plug	.6	_____
	Rear Plug	.4	_____
11-4	RADIATOR CORE — Remove and Install — Includes drain and refill. 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	_____

**6-CYLINDER WATER PUMP****8-CYLINDER WATER PUMP**

OPERATION	DESCRIPTION	TIME	PRICE
11-8	WATER PUMP TO WATER JACKET HOSE — Remove and Install. All Models — 8 Cyl.	.3	_____
11-9	RADIATOR BY-PASS HOSE — Remove and Install. All Models — 8 Cyl.	.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	_____

WATER PUMP AND FAN

11-12	WATER PUMP ASSEMBLY — Remove and Install. All Models	1.0	_____
	With Power Steering — Add	.2	_____
11-13	WATER PUMP — Overhaul — Includes remove and install, disassembly and inspection and replacement of any 'necessary parts. All Models	1.7	_____
	With Power Steering — Add	.2	_____
11-14	FAN BLADES — Remove and Install. All Models	.3	_____
11-15	FAN BELT — Remove and Install and Adjust. All Models	.3	_____
	With Power Steering — Add	.2	_____
11-16	FAN BELT — Adjust Only. All Models	.2	_____
11-17	WATER DISTRIBUTING TUBE — Remove and Install. All Models	3.0	_____
	TEMPERATURE INDICATOR ELEMENT — Remove and Install — (Cylinder Head Unit). All Models	.3	_____
	With Power Steering — Add	.2	_____
11-18	TEMPERATURE GAUGE — Remove and Install — See "Instruments" in Body Section.		
11-19	WEATHER CONTROL RANCO VALVE — Remove and Install. All Models	.5	_____

OPERATION	DESCRIPTION	TIME	PRICE
EXHAUST SYSTEM MANIFOLDS			
12-1	EXHAUST MANIFOLD AND/OR GASKETS — Remove and Install. All Models — 8 Cyl. 6 Cyl. When necessary to drill out and replace broken stud — Add	1.9 2.2 .4	
12-2	EXHAUST MANIFOLD HEAT TUBE — Remove and Install. All Models	.3	
12-3	EXHAUST MANIFOLD DAMPER VALVE — Remove and Install or Free-up. All Models — 8 Cyl 6 Cyl.	.8 2.0	
12-4	EXHAUST MANIFOLD OUTLET ELBOW AND/OR GASKET — Remove and Install. All Models	.8	
12-5	EXHAUST PIPE FLANGE GASKET — Remove and Install. All Models	.8	
12-6	EXHAUST PIPE — FRONT — Remove and Install. All Models — 8 Cyl. 6 Cyl.	2.0 1.2	
12-7	EXHAUST PIPE — REAR — Remove and Install. All Models	1.0	
12-8	EXHAUST PIPE FRONT CLAMP — Remove and Install. All Models	.5	
12-9	TWIN EXHAUST KIT — Install Complete	4.0	
12-10	MUFFLER — REAR — Remove and Install. All Models	.9	
12-11	MUFFLER CLAMP SUPPORT TO ENGINE REAR SUPPORT PLATE — Remove and Install. All Models	.5	
12-12	MUFFLER — FRONT — Remove and Install. All Models	1.0	
12-13	CLAMP — Remove and Install for Muffler (Rear), Exhaust Pipe or Tail Pipe. All Models — Any One	.3	
12-14	INTAKE MANIFOLD TO CARBURETOR GASKET — Remove and Instal All Models With Twin Carburetors — Add	.4 .3	
12-15	INTAKE MANIFOLD AND/OR GASKETS — Remove and Install. 6 Cyl. Except Jet 8 Cyl. Jet Only With Twin Carburetors — Add	2.2 2.5 1.8 .3	

OPERATION	DESCRIPTION	TIME	PRICE
ELECTRICAL			
13-1	BATTERY — Remove and Install. All Models	.3	_____
13-2	BATTERY HOLD DOWN — Remove and Install. All Models	.2	_____
13-3	BATTERY DRIP TRAY — Remove and Install. All Models	.3	_____
13-4	BATTERY TO FRAME SUPPORT AND/OR BOLTS — Remove and Install — Includes breaking welds. All Models	.6	_____
13-5	BATTERY CABLE TO STARTER MOTOR — Remove and Install. All Models	.2	_____
13-6	BATTERY GROUND STRAP — Remove and Install. All Models	.3	_____
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 AND/OR BRACKET — Remove and Install. All Models	.5	_____
	With Power Steering — To remove and install battery — Add	.3	_____
13-10	GENERATOR — Check charging rate. All Models	.3	_____
	If necessary to adjust — Add	.3	_____
13-11	GENERATOR COMMUTATOR — Clean commutator and brushes and adjust charging rate. All Models	.5	_____
13-12	GENERATOR OVERHAUL — Includes remove and install, clean, repair and replace any necessary parts and test — Includes turning armature and undercutting mica. All Models	1.6	_____
	With Power Steering — To remove and install battery — Add	.3	_____
13-13	GENERATOR VOLTAGE REGULATOR — Remove and Install — Includes adjusting charging rate. All Models		_____
13-14	GENERATOR BRUSHES — Remove and Install — Includes remove and in- stall generator. All Models	5	
	With Power Steering — To remove and install battery — Add	1.1	_____
		.3	_____

OPERATION	DESCRIPTION	TIME	PRICE
13-15	HORN ASSEMBLY AND/OR HORN BRACKET — Remove and Install. All Models — One Two	.4 .7	_____ _____
13-16	HORN ASSEMBLY — Clean and adjust contacts without removing horn. All Models	.4	_____
13-17	HORN RING, HORN BUTTON AND /OR HORN WIRE — Remove and Install. All Models — Ring Above Steering Wheel Ring Below Steering Wheel	.3 .8	_____ _____
13-18	HORN RELAY — Remove and Install. All Models	.2	_____
COIL, DISTRIBUTOR AND SPARK PLUGS			
13-19	COIL — Remove and Install. All Models	.3	_____
13-20	COIL — Test, Make First and Secondary Check — Includes remove and install. All Models	.7	_____ _____
13-21	DISTRIBUTOR ASSEMBLY — Remove and Install — Includes checking ignition timing. All Models — 6 Cyl. 6 Cyl. — With Drive-Master 8 Cyl.	.6 .7 .7	_____ _____ _____
13-22	DISTRIBUTOR ASSEMBLY — Overhaul — Includes remove and install — Disassembly and reassembly, replace any necessary parts, checking mechanical and vacuum advance, dwell, condenser, rotor, cap and setting ignition timing. All Models — 6 Cyl 8 Cyl.	1.5 1.6	_____ _____
13-23	DISTRIBUTOR POINTS — Clean or Replace and Adjust — Includes checking spark timing. All Models With Drive-Master	.6 .7	_____ _____
13-24	DISTRIBUTOR CAP — Remove and Install. All Models	.2	_____
13-25	DISTRIBUTOR CONDENSER — Remove and Install. All Models -- 6 or 8 Cyl. 6 Cyl. — With Drive-Master	.3 .4	_____ _____
13-26	DISTRIBUTOR VACUUM ADVANCE UNIT — Remove and Install — Includes setting ignition timing. All Models	.7	_____
13-27	IGNITION CABLES — Complete Set — Remove and Install. All Models — 6 Cyl 8 Cyl.	.5 .6	_____ _____

OPERATION	DESCRIPTION	TIME	PRICE
13-28	IGNITION SWITCH — Remove and Install. All Models	.4	_____
	To replace ignition switch cable — Add	.4	_____
13-29	SPARK PLUGS — Remove and Install — New. All Models — 6 Cyl .	.3	_____
	8 Cyl	.4	_____
	To clean, adjust and test old plugs — Set — Add	.3	_____
LIGHTS			
13-30	HEADLIGHT ASSEMBLY — Remove and Install — One and Adjust Two.		
	All Models	.8	_____
13-31	HEADLIGHT RIM — Remove and Install. All Models	.2	_____
13-32	HEADLIGHT SEALED BEAM UNIT — Remove and Install — One	.3	_____
13-33	HEADLIGHTS — Adjust Beam Only. All Models	.4	_____
13-34	HEADLIGHT SWITCH AND/OR CIRCUIT BREAKER — Remove and Install	4	_____
13-35	AUXILIARY CIRCUIT BREAKER — Remove and Install	.7	_____
13-36	DIMMER SWITCH — Remove and Install. All Models	.4	_____
13-37	PARKING LIGHTS — Remove and Install. All Models — Except Hornet, Jet and Wasp -- One	.2	_____
	Light Bulb Only — One	.2	_____
13-38	PARKING LIGHT, LENS, ORNAMENT AND/OR GASKET — Remove and Install.		
	Hornet and Wasp and Jet	.7	_____
13-39	PARKING LIGHT ORNAMENT EXTENSION	.3	_____
13-40	HOOD LIGHT CREST OR LENS — Remove and Install. All Models	.4	_____
	Bulb	.2	_____
1341	STOPLIGHT SWITCH — Remove and Install. All Models	.3	_____
13-42	TAIL LIGHT, LENS OR BULB — Remove and Install. All Models	.2	_____
13-43	COURTESY LIGHT OR DOME LIGHT — Remove and Install Lens or Bulb. All Models	.2	_____

OPERATION	DESCRIPTION	TIME	PRICE
13-44	DOME LIGHT SWITCH — Remove and Install — At Door Pillar or Dome. All Models	.2	_____
13-45	LICENSE LIGHT — LENS OR BULB — Remove and Install. All Models	.2	_____
STARTER MOTOR			
13-46	STARTER MOTOR ASSEMBLY — Remove and Install. All Models	.5	_____
	With Drive-Master	1.9	_____
13-47	STARTER MOTOR ASSEMBLY — Overhaul — Includes remove and install, clean, replace any necessary parts. All Models	1.9	_____
	With Drive-Master	3.3	_____
13-48	STARTER MOTOR SOLENOID ASSEMBLY—Remove and Install. All Models — Mounted on Starter Motor	.4	_____
	With Drive-Master	.5	_____
	Mounted on Fender Apron	.2	_____
13-49	STARTER BUTTON ASSEMBLY — Remove and Install. All Models	.2	_____
13-50	STARTER BENDIX DRIVE — Remove and Install With Starter Removed. All Models — Inboard	.3	_____
	Outboard (Hydra-Matic or Automatic Transmission)	.6	_____
13-51	STARTER BENDIX COVER — Install	.5	_____
13-52	STARTER SWITCH AND IGNITION LOCK ASSEMBLY — Remove and Install	4	_____
13-53	SWITCH — NEUTRAL SAFETY — Remove and Install	.2	_____

NOTES

OPERATION	DESCRIPTION	TIME	PRICE
ACCESSORIES			
14-1	BACK-UP LIGHT — Install — Pair. All Models — 1D, 4D and 5D 2D, 3D and 7D With Manual Shift Transmission — Add	1.8 1.4 .2	
14-2	CIGAR LIGHTER — Install	.5	
14-3	CIGAR LIGHTER ELEMENT — Remove and Install. All Models	.1	
14-4	CURB SIGNALS — Install. All Models	.3	
14-5	CLOCK — ELECTRIC — Install — Includes removing old stem wind clock and installing electric type. All Models	.6	
14-6	DIRECTION INDICATOR — Install. All Models — Wiring in Body Body Wiring Installation Included8 1.6	
14-7	DIRECTION INDICATOR FLASHER SWITCH — Remove and Install	.3	
14-8	DOOR GUARD — GASOLINE — Install	.2	
14-9	DOR-GARD — BODY — 4 Doors — Install	.3	
14-10	EXHAUST DEFLECTOR OR EXTENSION — Install. All Models	.1	
14-11	FOG LIGHTS — Install — Two. All Models	1.0	
14-12	FRONT FENDER TOP ORNAMENT KIT — Install. All Models	6	
14-13	FRONT DOOR VENT WING SHIELDS — Install. All Models	2	
14-14	GLARE PROOF MIRROR — Install. All Models	.1	
14-15	HUB CAP KIT (LARGE) — Install. All Models	.2	
14-16	KLEENEX TISSUE DISPENSER — Install. All Models	.2	
14-17	LICENSE PLATE FRAME — Install. All Models — Adjustable Custom	.2 .3	
14-18	OIL FILTERS — Install. All Models — 6 Cyl 8 Cyl	.5 1.5	
14-19	OUTSIDE REAR VIEW MIRROR — Install: All Models	.3	
14-20	RADIO ANTENNA — Install. All Models — Roof Front Fender	.9 1.5	

OPERATION	DESCRIPTION	TIME	PRICE
14-21	RADIO ANTENNA — Remove and Install. All Models — Roof or Fender	.5	_____
14-22	RADIO ASSEMBLY — Install (Initial Installation) — Includes roof antenna and speaker installation. All Models	2.3	_____
	With Fender Antenna	2.9	_____
14-23	RADIO ASSEMBLY — Remove and Install. All Models	1.4	_____
14-24	RADIO DIAL LIGHT BULB — Install. All Models	1.0	_____
14-25	RADIO REAR SEAT SPEAKER — Install. All Models	2.5	_____
14-26	RADIO RECEIVER — Remove and Install. All Models	1.3	_____
14-27	REAR MOUNT — WIRE OR DISC WHEEL — Installation includes all sheet metal work and painting	8.0	_____
14-28	SEAT COVERS — Install. All Models Except Jet, Super Jet & Jet-Liner — Broughams and Coupes	2.2	_____
	Sedans	2.0	_____
	Jet, Super Jet & Jet-Liner — Broughams	1.8	_____
	Sedans	1.6	_____
14-29	SPOTLIGHT — Install. All Models	1.0	_____
14-30	STEERING WHEEL KIT (DELUXE) — Remove and Install. All Models	.6	_____
14-31	TRAFFIC LIGHT VIEWER — Install	.4	_____
14-32	UNDER SEAT HEATER — Install. All Models	3.0	_____
14-33	WEATHER CONTROL — COMPLETE UNIT — Install. All Models	2.3	_____
14-34	WEATHER CONTROL MOTOR — Remove and Install. All Models Except Jet	1.3	_____
	Jet Only	.5	_____
14-35	WEATHER CONTROL RANCO VALVE — Remove and Install. All Models	.7	_____
14-36	WEATHER CONTROL CORE — Remove and Install. All Models Except Jet	1.5	_____
	Jet Only	1.3	_____
14-37	WEATHER CONTROL DASH — CONTROL ASSEMBLY — Remove and Install	1.0	_____
14-38	WEATHER CONTROL MOTOR SWITCH — Remove and Install . .	4	_____
14-39	WHEEL TRIM RINGS KIT — Install. All Models	.5	_____
14-40	WHEEL DISCS — Install — Four	1.0	_____
14-41	WINDOW VENT SHADES — Doors and Quarter Windows. All Models — Broughams and Coupes	.4	_____
	Sedans	.7	_____
14-42	WINDSHIELD WASHER — Install. All Models	1.0	_____
14-43	HYDROVAC POWER BRAKE — Install	2.0	_____
	With Windshield Washer On Left Fender	2.5	_____

OPERATION	DESCRIPTION	TIME	PRICE
FRAME AND SHEET METAL			
15-1	FRONT FRAME ASSEMBLY — Remove and Install—Includes transfer front fenders and radiator assembly, engine, front suspension complete and clutch and brake pedals, master cylinder, etc. Breaking welds re-weld to No. 4 crossmember. Correct camber, caster and toe-in.		
	With Standard Transmission	22.0	_____
	With Overdrive Transmission	23.0	_____
	With Power Steering, Drive-Master, Hydra-Matic or Automatic Transmission	24.5	_____
15-2	FRONT FRAME #2 CROSS MEMBER — 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. Correct camber, caster and toe-in.		
	All Models	3.0	_____
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 or Automatic Transmission	1.4	_____
15-4	FRONT FENDER — Remove and Install.		
	All Models — One Side	3.3	_____
	Jet Only	2.7	_____
	With Undercoating — Add	.5	_____
15-5	FRONT FENDER ORNAMENT OR NAME PLATE — Remove and Install.		
	All Models	.3	_____
15-6	FRONT FENDER SIDE DUST SHIELD — Remove and Install.		
	All Models — Right	.4	_____
	Left	.7	_____
15-7	FRONT FENDER SIDE DUST SHIELD EXTENSION — Remove and Install.		
	All Models	.4	_____
15-8	FRONT FENDER MOULDING AND NAME PLATE — Remove and Install — One.		
	All Models Except Pacemaker	.5	_____
	Pacemaker	.2	_____
15-9	DOOR MOULDINGS — UPPER OR LOWER— Remove and Install— Any Door.		
	All Models	.2	_____
15-10	FRONT FENDER EXTENSION — Remove and Install.		
	All Models	.6	_____
15-11	FRONT FENDER STONE GUARD — Remove and Install.		
	All Models	.4	_____
15-12	REAR FENDER — Remove and Install — Bolted Types — Does not include painting.		
	All Models — Sedans — Right Hand	2.3	_____
	Left Hand	2.5	_____
	Broughams and Coupes — Right Hand .-	3.2	_____
	Left Hand	3.4	_____

OPERATION	DESCRIPTION	TIME	PRICE
15-13	REAR FENDER MOULDING AND ORNAMENT — Remove and Install — One. All Models	.3	_____
15-14	GAS TANK FILLER DOOR — Remove and Install. All Models	.3	_____
15-15	GAS TANK FILLER DOOR SPRINGS — TWO — Remove and Install. All Models	.2	_____
15-16	GAS TANK FILLER NECK GROMMET — Remove and Install. All Models	.2	_____
15-17	COWL VENTILATING ASSEMBLY — Remove and Install. All Models	.8	_____
ROCKER PANELS AND MOULDINGS			
15-18	ROCKER PANEL — Bolted-On Type — Remove and Install — One. All Models	.7	_____
15-19	ROCKER PANEL MOULDING — Remove and Install. All Models	.6	_____
15-20	ROCKER PANEL EXTENSION — Remove and Install — One. All Models	.3	_____
15-21	ROCKER PANEL EXTENSION MOULDING — Remove and Install One. All Models	.1	_____
15-22	ROCKER PANEL REAR OR LOWER MOULDING — Remove and Install — One. All Models	.2	_____
15-23	FENDER (FRONT OR REAR) LOWER MOULDING — Remove and Install — One. All Models	.2	_____
15-24	ROCKER PANEL UPPER AND LOWER MOULDING — Remove and Install — One. All Models	.3	_____
15-25	REAR WHEEL COVER AND ROD ASSEMBLY — Remove and Install — One All Models	.1	_____
15-26	REAR WHEEL COVER — UPPER MOULDING — Remove and Install — One. All Models	.4	_____
15-27	REAR WHEEL COVER — LOWER MOULDING — Remove and Install — One. All Models	.3	_____
15-28	DOOR SCUFF PLATE — Front or Rear — Remove and Install. All Models	.3	_____

OPERATION	DESCRIPTION	TIME	PRICE
HOOD			
15-29	HOOD — Remove and Install and Adjust. All Models	1.0	_____
15-30	HOOD — Adjust — Includes adjusting lock lower support plate All Models	.4	_____
15-31	HOOD LOCK LOWER SUPPORT PLATE—Remove and Install and Adjust. All Models	.3	_____
15-32	HOOD LOCK — UPPER OR LOWER — Remove and Install. All Models	.3	_____
15-33	HOOD PROP — Remove and Install — Right or Left. All Models	.2	_____
15-34	HOOD PROP SPRING — Remove and Install — Right or Left. All Models	.3	_____
15-35	HOOD HINGE — Remove and Install — One. All Models Except Jet Jet Only	.9 .5	_____ _____
15-36	HOOD HINGE RETURN SPRING — Remove and Install — One. All Models	.9	_____
15-37	HOOD CONTROL KNOB AND WIRE ASSEMBLY — Remove and Install. All Models	.3	_____
15-38	HOOD CREST — Remove and Install. All Models Except Hornet and Wasp Hornet & Wasp — Right or Left or Center Section Hornet & Wasp — Complete Hood Crest	.4 .2 .6	_____ _____ _____
15-39	HOOD CREST LIGHT BULB, SOCKET OR WIRE — Remove and Install. All Models	.3	_____
15-40	HOOD LOUVER — UPPER — Remove and Install—Right or Left. All 480, 490 and 500 Series	.2	_____
15-41	HOOD LOUVER — LOWER — Remove and Install — Right or Left. All 480, 490 and 500 Series	.3	_____
GRILLE — 1953 JET, SUPER JET AND ALL 1954 MODELS			
15-42	FRONT FENDER TIE PANEL — Remove and Install	1.3	_____
15-43	GRILLE ORNAMENT — Remove and Install	.3	_____
15-44	MOULDING — UPPER — Remove and Install	.5	_____
15-45	MOULDING — BAFFLE CENTER — Remove and Install. Jet Only Hornet & Wasp — Right or Left	1.1 .7	_____ _____

OPERATION	DESCRIPTION	TIME	PRICE
15-46	LOUVER — LOWER — Remove and Install	1.2	_____
15-47	BAFFLE — LOWER — Remove and Install	2.0	_____
15-48	PARKING LAMP ORNAMENT — RIGHT OR LEFT — Remove and Install	.7	_____
15-49	PARKING LAMP ORNAMENT EXTENSION — RIGHT OR LEFT — Remove and Install.	.3	_____
15-50	DEFLECTOR — RIGHT OR LEFT — Remove and Install	2.3	_____
15-51	GRILLE ASSEMBLY — Remove and Install — Includes replacing all mouldings and louvers and both parking light ornaments and orna men- textensions — (Grille Replacement Kit)	2.5	_____
	If necessary to replace grill structure assembly — Add	1.5	_____
GRILLE — 1951-52-53 (EXCEPT JET)			
15-52	GRILLE ORNAMENT — Remove and Install	.3	_____
15-53	UPPER LOUVER — RIGHT OR LEFT — Remove and Install4	_____
15-54	CENTER LOUVER AND BAFFLE — Remove and Install	.9	_____
15-55	LOWER LOUVER AND BAFFLE — Remove and Install	.7	_____
15-56	STRUT — OUTER — RIGHT OR LEFT — Remove and Install5	_____
15-57	STRUT — INNER — RIGHT OR LEFT — Remove and Install7	_____
15-58	PARKING LAMP ORNAMENT — Remove and Install	.6	_____
15-59	GRILLE — Rebuild — Includes replacing all louvers, baffles, struts and both parking lamp ornaments	3.7	_____
15-60	FRONT FENDER TIE PANEL — Remove and Install	1.3	_____
GRILLE — 1948, 49 AND 50			
15-61	GRILLE LOUVER (UPPER) AND FENDER TIE PANEL COMPLETE ASSEMBLY. All "A" Series Models	.6	_____
15-62	GRILLE LOUVER — UPPER — RIGHT OR LEFT — Remove and Install. All "A" Series Models	.7	_____
15-63	GRILLE LOUVER — CENTER OR LOWER — RIGHT OR LEFT — Remove and Install — With Grille assembly removed. All "A" Series Models	.7	_____
15-64	GRILLE — LOWER SPLASH APRON — With Grille Assembly or Bumper Removed — Remove and Install. All "A" Series Models	.3	_____
15-65	FENDER TIE PANEL AND HOOD LOCK LOWER SUPPORT — Remove and Install. Models 480, 490 and 500	.6	_____

OPERATION	DESCRIPTION	TIME	PRICE
15-66	RADIATOR GRILLE CENTER BAR — UPPER OR LOWER — Remove and Install. All 480-490 Models	.3	_____
15-67	GRILLE BAFFLE OR MOULDING — CENTER OR LOWER — RIGHT OR LEFT — Remove and Install. All 480-490 Models — One Six	.2 .5	_____ _____
15-68	GRILLE TO RADIATOR DEFLECTOR AND BAFFLE SUPPORT — Remove and Install. All 500 and "A" Series Models	1.1	_____
15-69	GRILLE COMPLETE ASSEMBLY — Remove and Install — Includes removing and installing fender tie panel, hood crest, parking lights, and disassembling and replacing any louver, baffle, lower splash apron or struts. All "A" Series Models	3.5	_____
15-70	GRILLE STRUT CAP — Remove and Install. All "A" Series Models — One Two With Grille Removed — Two	.3 .5 .2	_____ _____ _____
15-71	GRILLE STRUT ASSEMBLY — Remove and Install — With Grille Removed. All "A" Series Models	.2	_____
15-72	GRILLE STRUT CAP — Remove and Install. All 500 Series Models	.2	_____
15-73	GRILLE STRUT ASSEMBLY — Remove and Install. All 500 Series Models — One Side Both Sides Grille Strut Moulding (One Only)	.7 1.1 .2	_____ _____ _____
15-74	GRILLE FRONT SPLASH GUARD AND MOULDING — Remove and Install. All 480 and 490 Models	.4	_____
15-75	GRILLE FRONT SPLASH GUARD, CENTER STRUTS AND MOULDING — Remove and Install. All 500 Series	.9	_____
15-76	GRILLE LOUVERS — LOWER — RIGHT OR LEFT — Remove and Install. Models 501, 502, 503, 504	.6	_____
15-77	GRILLE MOULDING — LOWER — Remove and Install. Model 500 Only	.3	_____
15-78	GRILLE MOULDING — UPPER OR INTERMEDIATE — RIGHT OR LEFT — Remove and Install. All 500 Series Models	4	_____
15-79	GRILLE BAFFLE — UPPER, INTERMEDIATE OR LOWER — Remove and Install. All 500 Series Models	.6	_____
15-80	GRILLE ORNAMENT — Remove and Install. All Models	.7	_____

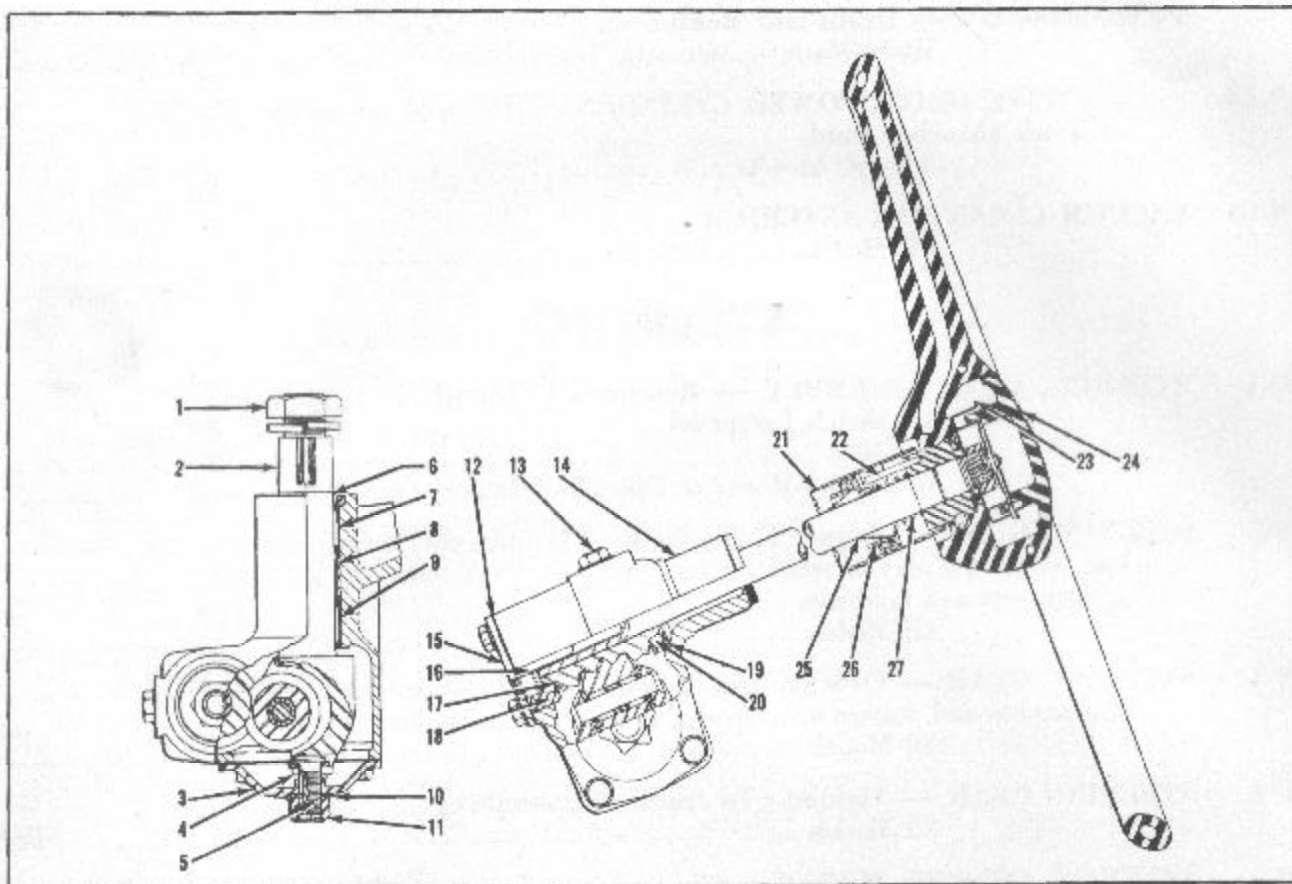
OPERATION	DESCRIPTION	TIME	PRICE
BUMPERS			
16-1	FRONT BUMPER ASSEMBLY — Remove and Install. All Models	.6	_____
16-2	FRONT BUMPER IMPACT BAR — Remove and Install. All Models	1.0	_____
16-3	FRONT OR REAR BUMPER TO FRAME BRACKET — Remove and Install. All Models	.6	_____
16-4	FRONT OR REAR BUMPER GUARD — Remove and Install—One — Right or Left. All Models	.2	_____
16-5	FRONT BUMPER LICENSE GUARD — LOWER — Remove and Install. All Models	.2	_____
16-6	FRONT BUMPER LICENSE GUARD — UPPER — Remove and Install. All Models	.3	_____
16-7	REAR BUMPER ASSEMBLY — Remove and Install. All Models	1.0	_____
16-8	REAR BUMPER INPACT BAR — Remove and Install. All Models — Wasp and Hornet All Models — Except Wasp and Hornet	1.5 .9	_____ _____
16-9	REAR BUMPER EXTENSION — Remove and Install — Right or Left. All Models — Wasp and Hornet	.4	_____
16-10	REAR BUMPER LICENSE GUARD — Remove and Install. Wasp and Hornet	.3	_____
16-11	REAR BUMPER GUARD AND LICENSE LIGHT — Remove and Install — One. 500 Model Commodores	.6	_____
16-12	REAR BUMPER STONE GUARD — Remove and Install. All Models	.9	_____
1613	REAR LICENSE PLATE BRACKET ASSEMBLY — Remove and Install. All Models	.2	_____

OPERATION	DESCRIPTION	TIME	PRICE
REAR SUSPENSION			
17-1	REAR SPRING — Remove and Install. All Models — One Spring Two Springs	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	_____ _____
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	_____
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 Springs	4.1	_____
17-11	REAR SHOCK ABSORBERS AND/OR RUBBER BUSHINGS — Remove and Install. All Models — One Two	.5 .9	_____ _____
17-12	REAR STABILIZER AND/OR RUBBER BUSHINGS—Remove and Install. All Models	.8	_____

OPERATION	DESCRIPTION	TIME	PRICE
FUEL SYSTEM			
18-1	CARBURETOR ASSEMBLY — Remove and Install. All Models	.4	_____
18-2	CARBURETOR ASSEMBLY — Overhaul — When removed from engine. All Models	1.5	_____
18-3	CARBURETOR ASSEMBLY — Check with Vacuum Gauge. All Models	.3	_____
18-4	CARBURETOR FLOAT OR NEEDLE Valve — Remove and Install — Includes adjusting float level, remove and install carburetor. All Models	.6	_____
18-5	CARBURETOR AUTOMATIC CHOKE — Remove and Install — Includes cleaning and overhaul. All Models	.7	_____
18-6	CARBURETOR AIR CLEANER — Remove, Clean and Install. All Models — With Oil Bath Refill Oil Wetted	.4 .2	_____ _____
18-7	CARBURETOR IDLE PORT PLUGS AND METERING RODS — Install. All Models	.5	_____
18-8	CARBURETOR TO EXHAUST MANIFOLD HEAT TUBE — Remove and Install. All Models	.3	_____
18-9	STANDARD FUEL PUMP AND /OR GASKET — Remove and Install. All Models — 6 Cyl. 8 Cyl.	.6 1.4	_____ _____
18-10	STANDARD FUEL PUMP — Overhaul — When removed from car. All Models	.8	_____
18-11	COMBINATION FUEL PUMP AND/OR GASKET — Remove and Install. All Models — 6 Cyl. 8 Cyl.	.7 1.5	_____ _____
18-12	COMBINATION FUEL PUMP — Overhaul — When removed from car. All Models	1.0	_____
18-13	FUEL PUMP SEDIMENT BOWL AND SCREEN — Remove, Clean and Install. All Models	.4	_____
18-14	FUEL PUMP FLEXIBLE HOSE — Remove and Install. All Models	.4	_____
18-15	GAS LINE, FUEL PUMP TO TANK — Remove and Install. All Models	.7	_____ _____

OPERATION	DESCRIPTION	TIME	PRICE
18-16	GAS LINE, FUEL PUMP TO CARBURETOR — Remove and Install. All Models	.2	_____
	GAS GAUGE — DASH UNIT — See Instrument Group under Body Section.		
18-17	GASOLINE TANK GAUGE — Remove and Install. All Models	.6	_____
18-18	GASOLINE TANK — Remove, Clean and Install. All Models	1.8	_____
18-19	TWIN CARBURETOR KIT INSTALLATION. All Models	6.5	_____
LUBRICATION AND INSPECTION			
19-1	LUBRICATION — Complete. All Models	.7	_____
19-2	PRE-DELIVERY INSPECTION AND ADJUSTMENTS. All 6 Cylinder Models	4.8	_____
19-3	1,000-MILE INSPECTION AND ADJUSTMENT. All 6 Cylinder Models	2.0	_____
19-4	2,000-MILE INSPECTION AND ADJUSTMENT. All 6 Cylinder Models	4.0	_____
19-5	CLUTCH — Drain, Flush and Refill. All Models	.4	_____
19-6	DIFFERENTIAL — Drain, Flush and Refill. All Models	.4	_____
19-7	FRONT WHEEL BEARINGS — Remove, Clean, Repack, Install and Adjust. All Models — One Side	.6	_____
	Both Sides	1.0	_____
	Install New Oil Seals — Add	.2	_____
19-8	REAR WHEEL BEARINGS — Remove, Clean, Repack, Install and Adjust. All Models — 1st Type — Both Sides	1.7	_____
	2nd Type — Both Sides	2.5	_____
	Install Inner and Cap Oil Seals — Add	.4	_____
19-9	REAR SPRINGS WITH COVERS — Lubricate. All Models — One Spring	.3	
	Two Springs	.5	
19-10	STEERING GEAR — Lubricate. All Models	.3	
19-11	TRANSMISSION — Drain, Flush and Refill. Standard Transmission	.3	_____
	Overdrive Transmission	.4	

OPERATION	DESCRIPTION	TIME	PRICE
19-12	TRANSMISSION — Drain and Refill. Hydra-Matic or Automatic Transmission	.4	_____
19-13	VACUOTIVE DRIVE POWER CYLINDER — Fill with one ounce of shock absorber fluid. 480-490 Models	.3	_____
19-14	VACUUM CLEAN CAR INTERIOR. All Models	.2	_____
STEERING			
20-1	STEERING GEAR ASSEMBLY — Remove and Install. All Models Except Jet Jet Only With Drive-Master or Directional Indicator — Add. .	3.9 3.0 .3	_____ _____ _____
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 — Overhaul on Bench — When removed, includes disassemble and reassembly, renew any necessary parts and adjust All Models	1.2	_____
20-4	STEERING GEAR — Tighten (To frame side member). All Models	.3	_____
20-5	STEERING COLUMN SUPPORT BRACKET — Remove and Install. All Models — Upper Half Lower Half	.2 .6	_____ _____
20-6	STEERING JACKET TUBE AND BEARING ASSEMBLY — Remove and Install. All Models With Directional Signal, Hydra-Matic or Automatic — Add, Each	1.2 .3	_____ _____
20-7	STEERING JACKET TUBE BEARING — Remove and Install. All Models	.8	_____
20-8	STEERING GEAR SECTOR SHAFT — Adjust End Play. All Models	.6	_____
20-9	STEERING WHEEL — Remove and Install. All Models	.6	_____
20-10	STEERING WHEEL — Tighten Only. All Models	.3	_____
20-11	STEERING WHEEL HORN RING OR HORN BUTTON—Remove and Install. All Models	.3	_____
20-12	STEERING PITMAN ARM AND/OR OIL SEAL — Remove and Install. All Models With Drive-Master	1.0 2.0	_____ _____



STEERING GEAR

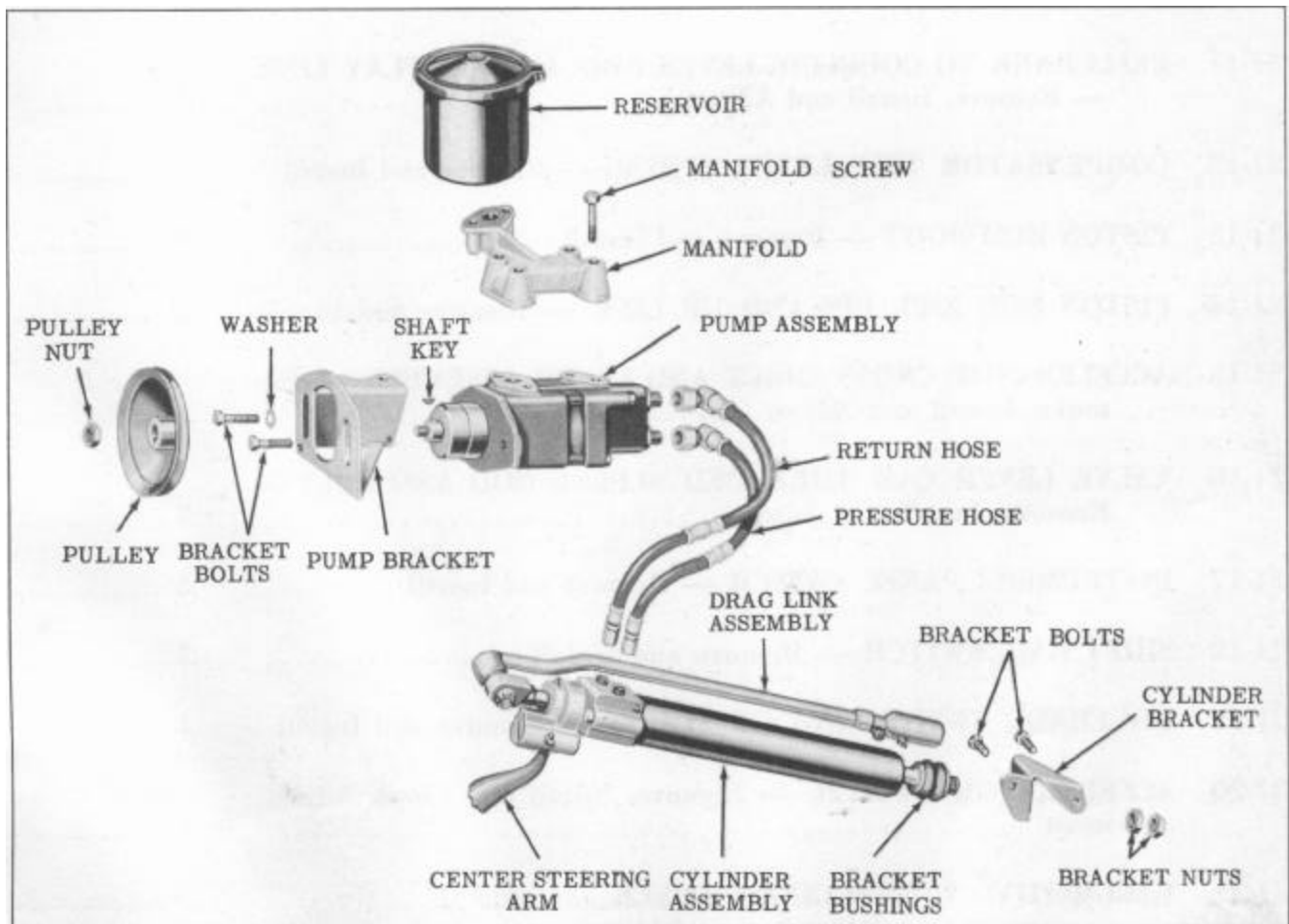
- | | | |
|---------------------------------|----------------------------------|--|
| 1. Gear shaft nut | 10. Adjusting screw lock plate | 19. Worm shaft upper bearing cup |
| 2. Gear shaft | 11. Adjusting screw lock nut | 20. Worm shaft upper bearing |
| 3. Gear shaft cover | 12. Worm cover shims |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

POWER STEERING

NOTE: Draining and/or Refilling Time Included in All Operations Where This Is Necessary.

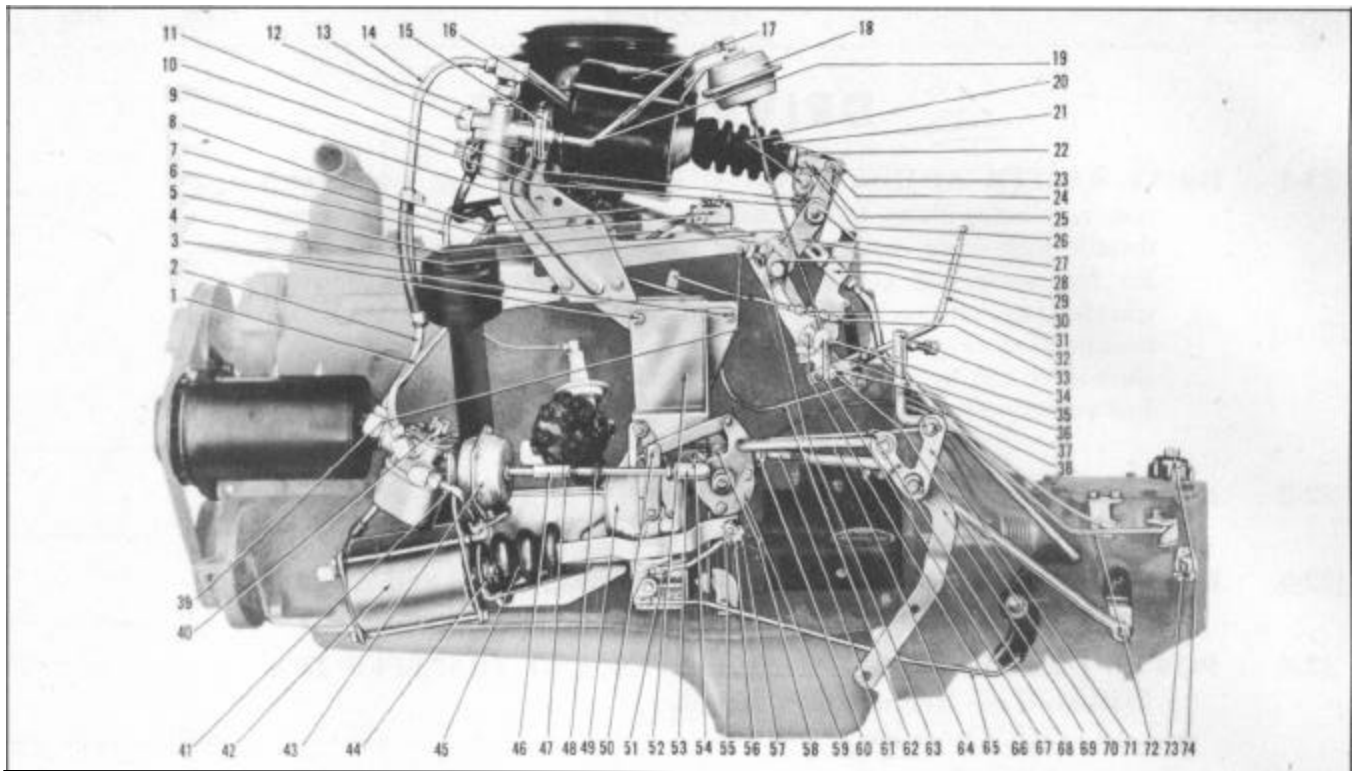
20-13	POWER CYLINDER AND DRAG LINK ASSEMBLY — Remove and Install. All Models	1.9	_____
20-14	POWER CYLINDER — Overhaul When Removed.	1.5	_____
20-15	All Models	1.0	_____
	RESERVOIR AND/OR MANIFOLD—Remove and Install. All Models		

OPERATION	DESCRIPTION	TIME	PRICE
20-16	POWER CYLINDER HOSE — Remove and Install. All Models — One Both	.4 .5	_____ _____
20-17	PUMP — Remove and Install. All Models	1.7	_____
20-18	PUMP — Overhaul When Removed. All Models	.6	_____
20-19	PUMP PULLEY AND/OR DRIVE BELT — Remove and Install. All Models	.3	_____
20-20	PUMP BELT — ADJUST. All Models	.2	_____
20-21	DRAW LINK ASSEMBLY — Remove and Install—Includes steering check and any necessary corrections. All Models	1.2	_____
20-22	CHECK OIL PRESSURE. All Models	.4	_____
20-23	TIGHTEN ALL CONNECTIONS. All Models	.5	_____



OPERATION	DESCRIPTION	TIME	PRICE
VACUMOTIVE DRIVE			
21-1	VACUMOTIVE DRIVE — Install on cars not so equipped	3.8	_____
21-2	VACUMOTIVE DRIVE — Adjust and Lubricate	.6	_____
21-3	VACUMOTIVE POWER CYLINDER — Remove and Install—Includes adjusting	1.8	_____
21-4	VACUMOTIVE POWER CYLINDER — Overhaul — Includes removing and installing and adjusting	2.6	_____
21-5	MOUNTING BRACKET — Remove and Install	.8	_____
21-6	SOLENOID VALVE AND/OR GASKET — Remove and Install	.3	_____
21-7	BELLCRANK — Remove and Install	1.0	_____
21-8	VALVE LEVER OR COMPENSATOR LEVER — Remove or Install	.8	_____
21-9	VALVE LEVER CAM — Remove or Install	.2	_____
21-10	VALVE LEVER CAM PIVOT — Remove and Install	.4	_____
21-11	BELLCRANK TO COUPLING LEVER ROD AND/OR PLAY LINK — Remove, Install and Adjust	1.2	_____
21-12	COMPENSATOR TRIP LEVER SPRING — Remove and Install	.7	_____
21-13	PISTON ROD BOOT — Remove and Install	.9	_____
21-14	PISTON ROD END, PIN AND/OR LINK — Remove and Install	.3	_____
21-15	ACCELERATOR CROSS SHAFT AND LEVER ASSEMBLY — Remove, Install and Adjust	.8	_____
21-16	VALVE LEVER CAM THREADED SLEEVE ROD ASSEMBLY — Remove, Install and Adjust	.3	_____
21-17	INSTRUMENT PANEL SWITCH — Remove and Install	.3	_____
21-18	SHIFT RAIL SWITCH — Remove and Install	.3	_____
21-19	GOVERNOR SWITCH AND/OR PINION — Remove and Install.	.4	_____
21-20	ACCELERATOR SWITCH — Remove, Install and Check Adjustment	.4	_____
21-21	VACUMOTIVE WIRE HARNESS CHECK	.5	_____
	With Overdrive — Add	.2	_____

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	_____
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	_____



DRIVE-MASTER

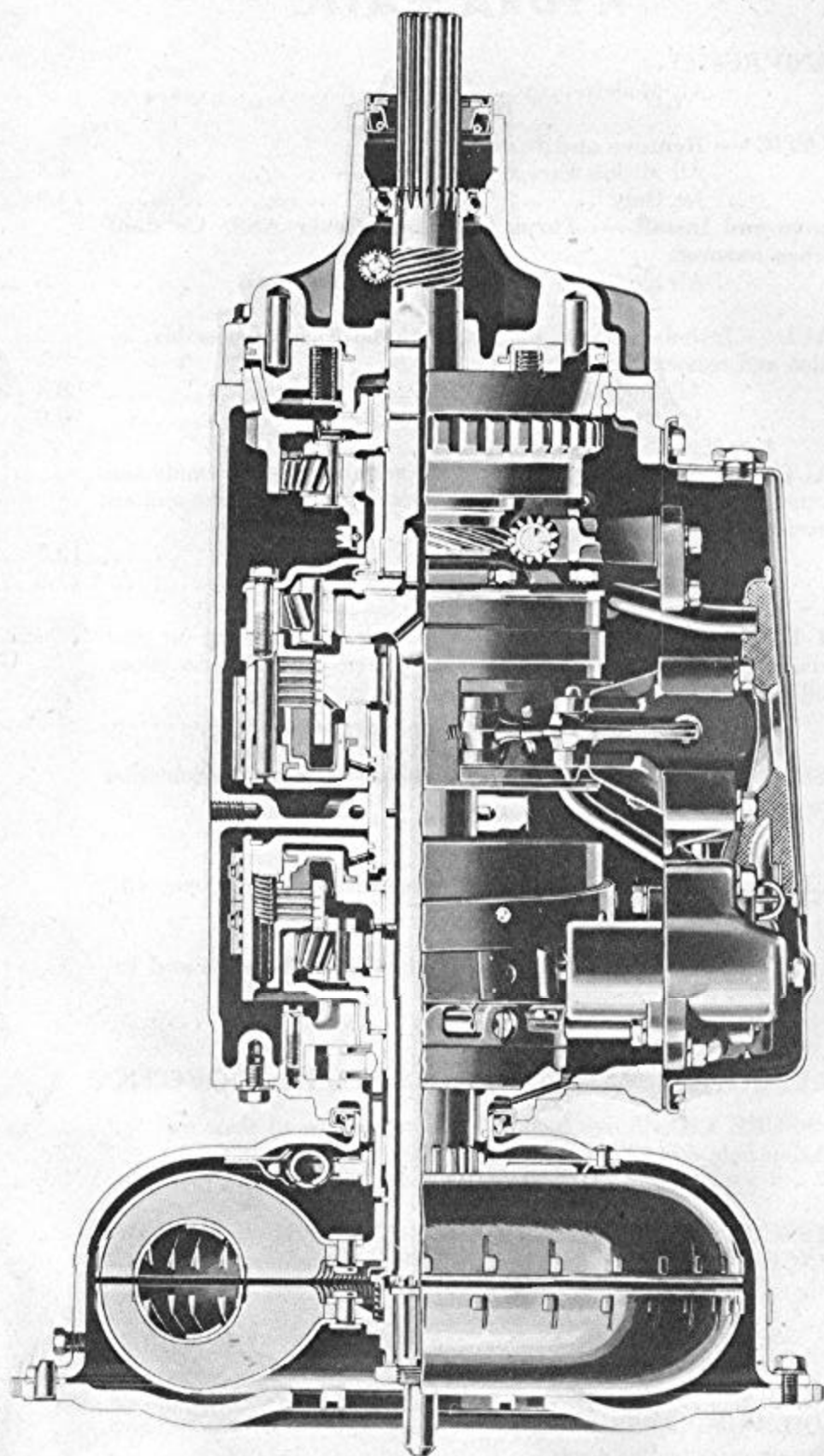
1. Power unit air intake pipe assembly
2. Power unit vacuum pipe assembly
3. Power unit mounting bracket studs
4. Clutch unit bellcrank bracket assembly
5. Accelerator switch to cross shaft rod
6. Power unit to air cleaner pipe assembly
7. Accelerator switch
8. Clutch power cylinder tension spring
9. Clutch power unit mounting bracket
10. Clutch unit compensator trip lever
11. Clutch unit compensator lever spring
12. Clutch unit solenoid valve assembly
13. Throttle lock solenoid valve assembly
14. Solenoid to power shift pipe assembly
15. Clutch power unit solenoid gasket
16. Vacuum pipe assembly
17. Clutch power unit cylinder assembly
18. Throttle lock diaphragm cylinder assembly
19. Throttle lock solenoid tube assembly
20. Clutch unit compensator lever shaft
21. Clutch power unit piston rod guard
22. Clutch power unit piston rod assembly
23. Clutch unit piston rod pivot bolt
24. Clutch unit piston valve link pin
25. Clutch unit piston valve link
26. Clutch unit piston valve, rod assembly
27. Clutch power unit valve lever bushing
28. Clutch unit bellcrank and compensator assembly
29. Valve lever cam
30. Bellcrank to clutch coupling lever rod
31. Accelerator pedal to bellcrank rod assembly
32. Threaded sleeve rod swivel
33. Threaded sleeve rod assembly
34. Control lever to bellcrank rod ball joint
35. Accelerator pedal link bellcrank stop
36. Accelerator pedal link bellcrank bracket
37. Throttle lock diaphragm rod check nut
38. Bellcrank rod and ball joint assembly
39. Valve lever cam adjusting screw nut
40. Transfer diaphragm solenoids
41. Solenoids to power cylinder tube assembly
42. Power cylinder assembly
43. Transfer diaphragm assembly
44. Power cylinder mounting stud
45. Power cylinder piston guard
46. Transfer diaphragm and rod assembly
47. Transfer rod lock nut
48. Transfer diaphragm engaging rod assembly
49. Transmission control switch assembly
50. Selector switch lever
51. Neutral and limit switch rod assembly
52. Power unit mounting bracket assembly
53. Transfer rod ball joint
54. Transfer key
55. Neutral and limit switch rod lock nut
56. Neutral and limit switch trunnion block
57. Neutral and limit switch rod lock nut
58. Shift shaft transfer key, hub assembly
59. Shift shaft (hand shift) lever assembly
60. Shift rod to power shift lever pin
61. Transmission shift rod assembly
62. Accelerator cross shaft operating rod
63. Valve lever cam adjusting screw
64. Bellcrank to shift shaft lever rod
65. Off-On switch operating rod
66. Accelerator link bellcrank shaft
67. Throttle lock diaphragm rod swivel
68. Cross-over switch rod clip
69. Hand shift bellcrank support
70. Throttle lock cable lock nut
71. Hand shift bellcrank
72. Cross-over switch rod
73. Shift rail switch
74. Governor switch

OPERATION	DESCRIPTION	TIME	PRICE
22-16	SHIFT SHAFT HAND SHIFT LEVER — Remove and Install. All Models	.7	_____
	If necessary to replace bushing — Add	.2	_____
22-17	SHIFT SHAFT POWER SHIFT LEVER — Remove and Install. All Models	.7	_____
	If necessary to replace bushing — Add	.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	_____
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	_____

OPERATION	DESCRIPTION	TIME	PRICE
22-32	DRIVE-MASTER WIRE HARNESS CHECK.		
	All Models	.9	_____
	With Overdrive	1.2	_____
22-33	DRIVE-MASTER WIRE HARNESS — Remove and Install	.8	_____
	With Drive-Master and Overdrive —		
	All 480 and 490 Models	1.8	_____
	All 500 and "A" Series Models	2.5	_____

NOTES

OPERATION	DESCRIPTION	TIME	PRICE
HYDRA-MATIC			
23-1	DRAIN AND REFILL. All Models	.7	_____
23-2	HYDRA-MATIC — Remove and Install. All Models Except Jet	4.3	_____
	Jet Only	4.9	_____
	Remove and Install — Torus Members, Cover And / Or Seal — When removed.		
	All Models — Add	.5	_____
23-3	OVERHAUL — Includes remove and install transmission, disassembly, inspection and reassembly — by units. All Models Except Jet	8.3	_____
	Jet Only	8.8	_____
234	OVERHAUL — Includes remove and install transmission, disassembly and inspection of each individual unit. Includes thorough cleaning and all replacements and/or adjustments. All Models Except Jet	12.3	_____
	Jet Only	12.8	_____
23-5	INSPECT HYDRA-MATIC --- Includes removing and installing oil pan, inspecting front and rear drums, rear pump drive gear. Includes cleaning oil screen, oil pan and refilling. All Models	1.5	_____
23-6	FLYWHEEL HOUSING — Remove and Install — When transmission is removed. All Models	.7	_____
23-7	FLYWHEEL — Remove and Install — When transmission is removed All Models	.5	_____
23-8	MAINSHAFT PILOT BUSHING (In Flywheel) — Remove and Install — When transmission is removed. All Models	.7	_____
23-9	REGULATOR VALVE, OIL PUMPS AND GOVERNOR OIL PRESSURE CHECK — Includes remove and install floor mat and inspection hole cover. All Models	.6	_____
23-10	OIL PRESSURE REGULATOR VALVE BODY SPRING AND/OR PLUNGER — Remove and Install — Includes remove and install floor board. All Models Except Jet	1.5	_____
	Jet Only — Remove and Install Mat and Access Hole Cover	.8	_____
23-11	FRONT OIL PUMP ASSEMBLY — Remove and Install — Includes making necessary adjustments. All Models	5.9	_____

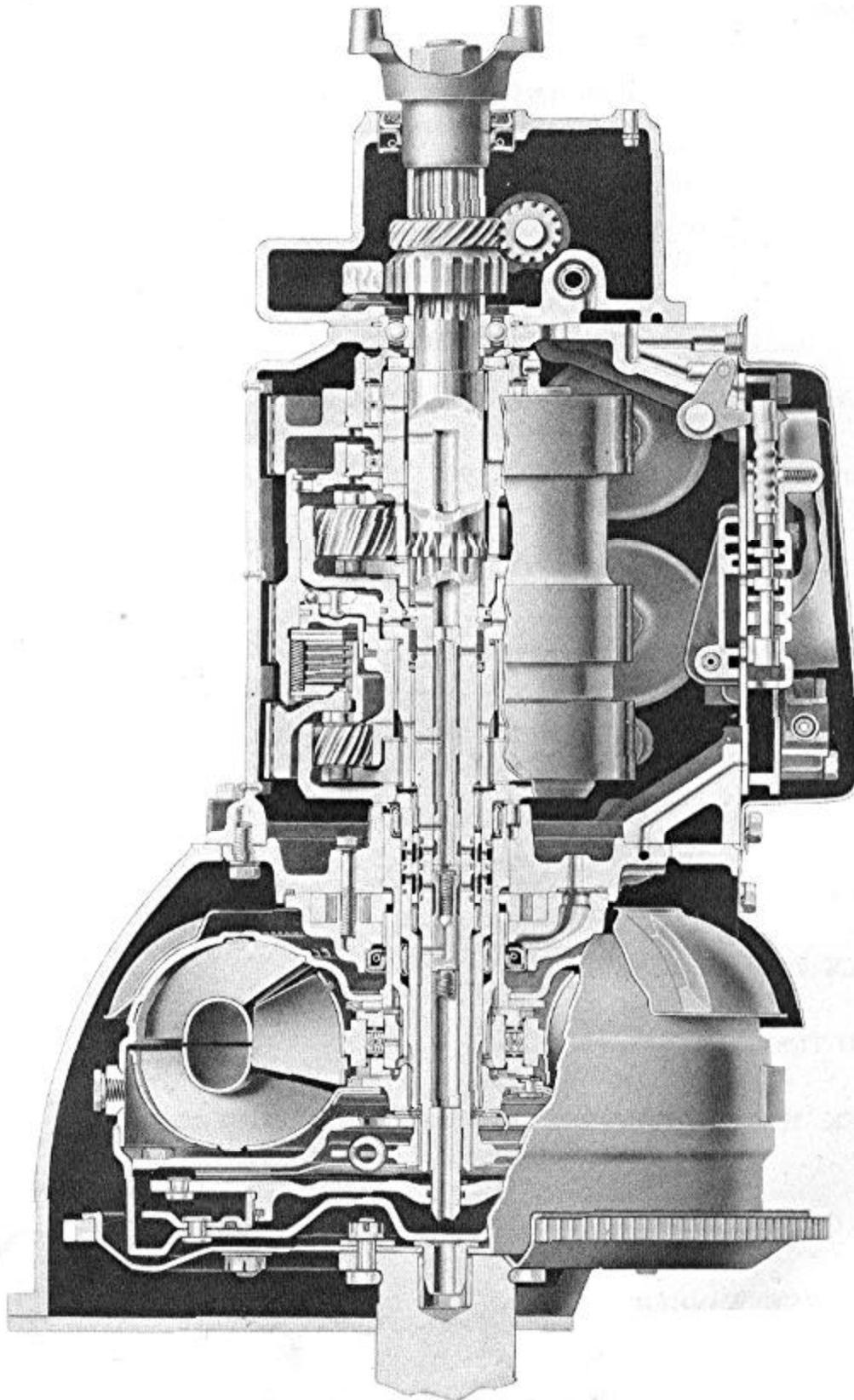


HYDRA-MATIC TRANSMISSION

OPERATION	DESCRIPTION	TIME	PRICE
23-12	FRONT OIL PUMP ASSEMBLY — Overhaul — Includes remove and install transmission and necessary adjustments. All Models	6.4	_____
23-13	REAR OIL PUMP AND GOVERNOR ASSEMBLY — Remove and Install — Includes making necessary adjustments. All Models	2.0	_____
23-14	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 runout and adjust reverse anchor All Models	3.1	_____
23-15	TRANSMISSION OIL PAN AND/OR GASKET — Remove and Install. All Models	.7	_____
REGULATOR VALVE, OIL			
23-16	SIDE COVER AND/OR GASKET — Remove and Install. All Models	.7	_____
23-17	FRONT PUMP COVER OIL SEAL AND/OR OIL RINGS — Replace — Includes remove and install transmission. All Models Except Jet Jet Only	5.4 6.7	_____ _____
23-18	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	8.3	_____
23-19	GOVERNOR — Overhaul — Includes remove and install side cover, valve body and governor, replace necessary parts and check governor runout. All Models	2.6	_____
23-20	REAR OIL SEAL — Remove and Install. All Models	.9	_____
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	1.8	_____
23-22	CONTROL VALVE ASSEMBLY — Overhaul — Includes check oil pressure, adjust control linkage and neutral safety switch. All Models	2.6	_____
23-23	CONTROL VALVE — INSIDE THROTTLE VALVE LEVER ASSEMBLY — Remove and Install — Includes remove and install control valve assembly, adjusting manual and throttle control levers. All Models	2.2	_____

OPERATION	DESCRIPTION	TIME	PRICE
23-24	CLUTCH PLATE ASSEMBLIES — Remove and Install — Includes removal, disassembly, assembly and installing transmission, and making necessary adjustments. All Models Except Jet Jet Only	9.1 9.6	
23-25	INTERMEDIATE SHAFT — Remove and Install — Includes remove, disassemble, assemble and install transmission and make necessary adjustments. Does not include disassembly of any units. All Models Except Jet Jet Only	8.8 9.3	
23-26	FRONT PLANETARY UNIT DRIVE GEAR — Remove and Install — Includes remove and install transmission and servo units and adjusting servos. All Models Except Jet Jet Only	8.5 9.0	
23-27	REVERSE. GEAR ANCHOR BRACKET AND/OR BELLCRANK — Remove and Install — Includes checking backlash. All Models	2.5	
23-28	REVERSE UNIT ASSEMBLY — Overhaul — Includes remove and install side cover and oil pan, rear pump and governor assembly. All Models	5.3	
23-29	PARKING BRAKE BRACKET ASSEMBLY — Remove and Inspect — Includes remove and install valve body and adjusting servo bands. All Models	2.8	
23-30	SPEEDOMETER DRIVE GEAR — (Integral with mainshaft) — Remove and Install. All Models	5.5	
SERVOS			
23-31	SERVO — FRONT OR REAR — Remove and Install — Includes remove and install bottom oil pan and adjustment of both servos. All Models	1.7	
23-32	SERVOS — FRONT OR REAR — Overhaul — Includes remove, install, cleaning oil pan and install new gasket and adjust both servos All Models	2.0	
23-33	SERVOS (BOTH) — Overhaul — Includes remove, install and adjust, cleaning bottom oil pan and install new gasket. All Models	2.5	
23-34	SERVO BANDS Replace One Both Includes remove and install transmission and units necessary to enable band replacement and adjustment of band. All Models Except Jet Jet Only	8.1 8.6	

OPERATION	DESCRIPTION	TIME	PRICE
23-35	REMOTE CONTROL SHIFT LEVER — Remove and Install. All Models	.3	_____
23-36	REMOTE CONTROL SHIFT LEVER AND HOUSING — Remove and Install Includes remove and install steering wheel and setting quadrant with selector switch. All Models	2.3	_____
23-37	QUADRANT INDICATOR PIN — Remove and Install. All Models	.7	_____
ADJUSTMENTS			
23-38	ENGINE IDLE SPEED ADJUSTMENT (490 to 510 R.P.M.). All Models	.1	_____
23-39	THROTTLE LINKAGE ADJUSTMENT. Lever at transmission — All Models Lever at engine — All Models	.4 .1	_____ _____
23-40	SHIFTER ROD ADJUSTMENT. All Models	.2	_____
23-41	NEUTRAL LIMIT SWITCH ADJUSTMENT. All Models	.1	_____
23-42	EXTERNAL BAND ADJUSTMENT (WITH GAUGE). All Models	.6	_____
23-43	INTERNAL BAND ADJUSTMENT. All Models	1.3	_____
23-44	CHECK OIL LEVEL AND BAND ADJUSTING SCREWS. All Models	.2	_____
23-45	CHECK FOR OIL LEAKS. All Models	.2	_____
23-46	ROAD TEST. All Models	.6	_____
23-47	CHECK MANUAL CONTROL AND THROTTLE CONTROL ADJUSTMENTS. All Models	.2	_____
23-48	SERVOS — ADJUST FRONT AND REAR. All Models	.4	_____
23-49	SELECTIVE WASHER — Remove and Install — Includes remove and install transmission, reverse assembly, and checking endplay. All Models	6.3	_____
23-50	VALVE — MAIN LINE EXHAUST — Remove and Install. All Models	1.9	_____



AUTOMATIC TRANSMISSION

OPERATION	DESCRIPTION	TIME	PRICE
AUTOMATIC TRANSMISSION			
24-1	OIL PRESSURE TEST — Complete	1.0	_____
24-2	TRANSMISSION ASSEMBLY — Remove and Install — Includes drain and refill	4.0	_____
24-3	CONVERTER HOUSING — Remove and Install — Transmission removed	.7	_____
24-4	CONVERTER — Remove and Install — Transmission removed	1.2	_____
24-5	MAINSHAFT ASSEMBLY — Remove and Install — Transmission removed	1.7	_____
24-6	MAINSHAFT ASSEMBLY — Remove, Clean, Disassembly and Assemble — Includes replacement of all or any parts of mainshaft assembly	2.9	_____
24-7	TRANSMISSION — Overhaul — When removed — Includes thorough cleaning, disassembly and inspection of all units, replacing any necessary parts and making all adjustments .	2.6	_____
24-8	TRANSMISSION CASE — Replace — When removed	3.3	_____
24-9	EXTENSION CASE — Remove and Install	1.5	_____
24-10	EXTENSION CASE — Overhaul — When removed	.9	_____
24-11	VALVE BLOCK — Remove and Install	1.0	_____
24-12	VALVE BLOCK — Overhaul — When removed	.7	_____
24-13	RELIEF VALVE — FRONT AND REAR PUMP — Remove and Install	.8	_____
24-14	PUMP ASSEMBLY — REAR — Remove and Install — Includes extension case remove and install	2.0	_____
24-15	PUMP ASSEMBLY — Overhaul — When removed	.4	_____
24-16	SERVO — LOW AND FORWARD — Remove and Install or Install Gaskets and Seal (Remove Front Muffler)	1.4	_____
24-17	SERVO — REVERSE — Remove and Install or Renew Gasket and Seal	.4	_____
24-18	SPEEDOMETER GEAR AND/OR HOUSING — Remove and Install	.6	_____
24-19	OIL — DRAIN AND REFILL	.7	_____
24-20	OIL SCREEN — Remove and Install or Clean	.6	_____
24-21	SELECTOR CONTROL SHAFT AND OUTER LEVER, INNER LEVER AND/OR OIL SEAL — Remove and Install	.7	_____

OPERATION	DESCRIPTION	TIME	PRICE
24-22	FLOOR MAT—FRONT— Cut hole in mat and install for inspection cover	.5	_____
24-23	FRONT PUMP AND/OR COLLECTOR RING — Overhaul or Replace — Transmission removed	.5	_____
24-24	BRAKE BANDS Remove Install —Transmission removed— Mainshaft out — 1, 2 or All 3 Bands	.3	_____
24-25	BRAKE BANDS — ADJUST.		
	Transmission removed	.3	_____
	Transmission in car	.7	_____
24-26	ADJUSTING SCREW AND LOCK NUT — Replace — One	.5	_____
24-27	LINKAGE COMPLETE — ADJUST	.3	_____
24-28	ROAD TEST	.6	_____

NOTES

[illegible]

CONVERSION TABLE

Hout	\$ 2.75	\$ 3.00	\$ 3.25	\$ 3.50	\$ 3.75	\$ 4.00	\$ 4.25	\$ 4.50	\$ 4.75	\$ 5.00
.1	.30	.30	.35	.35	.40	.40	.45	.45	.50	.50
.2	.55	.60	.65	.70	.75	.80	.85	.90	.95	1.00
.3	.85	.90	1.00	1.05	1.15	1.20	1.30	1.35	1.45	1.50
.4	1.10	1.20	1.30	1.40	1.50	1.60	1.70	1.80	1.90	2.00
.5	1.40	1.50	1.65	1.75	1.90	2.00	2.15	2.25	2.40	2.50
.6	1.65	1.80	1.95	2.10	2.25	2.40	2.55	2.70	2.85	3.00
.7	1.95	2.10	2.30	2.45	2.65	2.80	3.00	3.15	3.35	3.50
.8	2.20	2.40	2.60	2.80	3.00	3.20	3.40	3.60	3.80	4.00
.9	2.50	2.70	2.95	3.15	3.40	3.60	3.85	4.05	4.30	4.50
1.0	2.75	3.00	3.25	3.50	3.75	4.00	4.25	4.50	4.75	5.00
1.1	3.05	3.30	3.60	3.85	4.15	4.40	4.70	4.95	5.25	5.50
1.2	3.30	3.60	3.90	4.20	4.50	4.80	5.10	5.40	5.70	6.00
1.3	3.60	3.90	4.25	4.55	4.90	5.20	5.55	5.85	6.20	6.50
1.4	3.85	4.20	4.55	4.90	5.25	5.60	5.95	6.30	6.65	7.00
1.5	4.15	4.50	4.90	5.25	5.65	6.00	6.40	6.75	7.15	7.50
1.6	4.40	4.80	5.20	5.60	6.00	6.40	6.80	7.20	7.60	8.00
1.7	4.70	5.10	5.55	5.95	6.40	6.80	7.25	7.65	8.10	8.50
1.8	4.95	5.40	5.85	6.30	6.75	7.20	7.65	8.10	8.55	9.00
1.9	5.25	5.70	6.20	6.65	7.15	7.60	8.10	8.55	9.05	9.50
2.0	5.50	6.00	6.50	7.00	7.50	8.00	8.50	9.00	9.50	10.00
2.1	5.80	6.30	6.85	7.35	7.90	8.40	8.95	9.45	10.00	10.50
2.2	6.05	6.60	7.15	7.70	8.25	8.80	9.35	9.90	10.45	11.00
2.3	6.35	6.90	7.50	8.05	8.65	9.20	9.80	10.35	10.95	11.50
2.4	6.60	7.20	7.80	8.40	9.00	9.60	10.20	10.80	11.40	12.00
2.5	6.90	7.50	8.15	8.75	9.40	10.00	10.65	11.25	11.90	12.50
2.6	7.15	7.80	8.45	9.10	9.75	10.40	11.05	11.70	12.35	13.00
2.7	7.45	8.10	8.80	9.45	10.15	10.80	11.50	12.15	12.85	13.50
2.8	7.70	8.40	9.10	9.80	10.50	11.20	11.90	12.60	13.30	14.00
2.9	8.00	8.70	9.45	10.15	10.90	11.60	12.35	13.05	13.80	14.50
3.0	8.25	9.00	9.75	10.50	11.25	12.00	12.75	13.50	14.25	15.00
3.1	8.55	9.30	10.10	10.85	11.65	12.40	13.20	13.95	14.75	15.50
3.2	8.80	9.60	10.40	11.20	12.00	12.80	13.60	14.40	15.20	16.00
3.3	9.10	9.90	10.75	11.55	12.40	13.20	14.05	14.85	15.70	16.50
3.4	9.35	10.20	11.05	11.90	12.75	13.60	14.45	15.30	16.15	17.00
3.5	9.65	10.50	11.40	12.25	13.15	14.00	14.90	15.75	16.65	17.50
3.6	9.90	10.80	11.70	12.60	13.50	14.40	15.30	16.20	17.10	18.00
3.7	10.20	11.10	12.05	12.95	13.90	14.80	15.75	16.65	17.60	18.50
3.8	10.45	11.40	12.35	13.30	14.25	15.20	16.15	17.10	18.05	19.00
3.9	10.75	11.70	12.70	13.65	14.65	15.60	16.60	17.55	18.55	19.50
4.0	11.00	12.00	13.00	14.00	15.00	16.00	17.00	18.00	19.00	20.00
4.1	11.30	12.30	13.35	14.35	15.40	16.40	17.45	18.45	19.50	20.50
4.2	11.55	12.60	13.65	14.70	15.75	16.80	17.85	18.90	19.95	21.00
4.3	11.85	12.90	14.00	15.05	16.15	17.20	18.30	19.35	20.45	21.50
4.4	12.10	13.20	14.30	15.40	16.50	17.60	18.70	19.80	20.90	22.00
4.5	12.40	13.50	14.65	15.75	16.90	18.00	19.15	20.25	21.40	22.50
4.6	12.65	13.80	14.95	16.10	17.25	18.40	19.55	20.70	21.85	23.00
4.7	12.95	14.10	15.30	16.45	17.65	18.80	20.00	21.15	22.35	23.50
4.8	13.20	14.40	15.60	16.80	18.00	19.20	20.40	21.60	22.80	24.00
4.9	13.50	14.70	15.95	17.15	18.40	19.60	20.85	22.05	23.30	24.50

CONVERSION TABLE - Continued

Hout	\$ 2.75	\$ 3.00	\$ 3.25	\$ 3.50	\$ 3.75	\$ 4.00	\$ 4.25	\$ 4.50	\$ 4.75	\$ 5.00
5.0	13.75	15.00	16.25	17.50	18.75	20.00	21.25	22.50	23.75	25.00
5.1	14.05	15.30	16.60	17.85	19.15	20.40	21.70	22.95	24.25	25.50
5.2	14.30	15.60	16.90	18.20	19.50	20.80	22.10	23.40	24.70	26.00
5.3	14.60	15.90	17.25	18.55	19.90	21.20	22.55	23.85	25.20	26.50
5.4	14.85	16.20	17.55	18.90	20.25	21.60	22.95	24.30	25.65	27.00
5.5	15.15	16.50	17.90	19.25	20.65	22.00	23.40	24.75	26.15	27.50
5.6	15.40	16.80	18.20	19.60	21.00	22.40	23.80	25.20	26.60	28.00
5.7	15.70	17.10	18.55	19.95	21.40	22.80	24.25	25.65	27.10	28.50
5.8	15.95	17.40	18.85	20.30	21.75	23.20	24.65	26.10	27.55	29.00
5.9	16.25	17.70	19.20	20.65	22.15	23.60	25.10	26.55	28.05	29.50
6.0	16.50	18.00	19.50	21.00	22.50	24.00	25.50	27.00	28.50	30.00
6.1	16.80	18.30	19.85	21.35	22.90	24.40	25.95	27.45	29.00	30.50
6.2	17.05	18.60	20.15	21.70	23.25	24.80	26.35	27.90	29.45	31.00
6.3	17.35	18.90	20.50	22.05	23.65	25.20	26.80	28.35	29.95	31.50
6.4	17.60	19.20	20.80	22.40	24.00	25.60	27.20	28.80	30.40	32.00
6.5	17.90	19.50	21.15	22.75	24.40	26.00	27.65	29.25	30.90	32.50
6.6	18.15	19.80	21.45	23.10	24.75	26.40	28.05	29.70	31.35	33.00
6.7	18.45	20.10	21.80	23.45	25.15	26.80	28.50	30.15	31.85	33.50
6.8	18.70	20.40	22.10	23.80	25.50	27.20	28.90	30.60	32.30	34.00
6.9	19.00	20.70	22.45	24.15	25.90	27.60	29.35	31.05	32.80	34.50
7.0	19.25	21.00	22.75	24.50	26.25	28.00	29.75	31.50	33.25	35.00
7.1	19.55	21.30	23.10	24.85	26.65	28.40	30.20	31.95	33.75	35.50
7.2	19.80	21.60	23.40	25.20	27.00	28.80	30.60	32.40	34.20	36.00
7.3	20.10	21.90	23.75	25.55	27.40	29.20	31.05	32.85	34.70	36.50
7.4	20.35	22.20	24.05	25.90	27.75	29.60	31.45	33.30	35.15	37.00
7.5	20.65	22.50	24.40	26.25	28.15	30.00	31.90	33.75	35.65	37.50
7.6	20.90	22.80	24.70	26.60	28.50	30.40	32.30	34.20	36.10	38.00
7.7	21.20	23.10	25.05	26.95	28.90	30.80	32.75	34.65	36.60	38.50
7.8	21.45	23.40	25.35	27.30	29.25	31.20	33.15	35.10	37.05	39.00
7.9	21.75	23.70	25.70	27.65	29.65	31.60	33.60	35.55	37.50	39.50
8.0	22.00	24.00	26.00	28.00	30.00	32.00	34.00	36.00	38.00	40.00
8.1	22.30	24.30	26.35	28.35	30.40	32.40	34.45	36.45	38.50	40.50
8.2	22.55	24.60	26.65	28.70	30.75	32.80	34.85	36.90	38.95	41.00
8.3	22.85	24.90	27.00	29.05	31.15	33.20	35.30	37.35	39.45	41.50
8.4	23.10	25.20	27.30	29.40	31.50	33.60	35.70	37.80	39.90	42.00
8.5	23.40	25.50	27.65	29.75	31.90	34.00	36.15	38.25	40.40	42.50
8.6	23.65	25.80	27.95	30.10	32.25	34.40	36.55	38.70	40.85	43.00
8.7	23.95	26.10	28.30	30.45	32.65	34.80	37.00	39.15	41.35	43.50
8.8	24.20	26.40	28.60	30.80	33.00	35.20	37.40	39.60	41.80	44.00
8.9	24.50	26.70	28.95	31.15	33.40	35.60	37.85	40.05	42.30	44.50
9.0	24.75	27.00	29.25	31.50	33.75	36.00	38.25	40.50	42.75	45.00
9.1	25.05	27.30	29.60	31.85	34.15	36.40	38.70	40.95	43.25	45.50
9.2	25.30	27.60	29.90	32.20	34.50	36.80	39.10	41.40	43.70	46.00
9.3	25.60	27.90	30.25	32.55	34.90	37.20	39.55	41.85	44.20	46.50
9.4	25.85	28.20	30.55	32.90	35.25	37.60	39.95	42.30	44.65	47.00
9.5	26.15	28.50	30.90	33.25	35.65	38.00	40.40	42.75	45.15	47.50
9.6	26.40	28.80	31.20	33.60	36.00	38.40	40.80	43.20	45.60	48.00
9.7	26.70	29.10	31.55	33.95	36.40	38.80	41.25	43.65	46.10	48.50
9.8	26.95	29.40	31.85	34.30	36.75	39.20	41.65	44.10	46.55	49.00
9.9	27.25	29.70	32.20	34.65	37.15	39.60	42.10	44.55	47.05	49.50
10.0	27.50	30.00	32.50	35.00	37.50	40.00	42.50	45.00	47.50	50.00

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
_____	_____	_____	_____	_____

Our procedure in performing this operation and tool suggestions are as follows:

Service Manager _____

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
_____	_____	_____	_____	_____

Our procedure in performing this operation and tool suggestions are as follows:

Service Manager _____

This image shows a single sheet of white paper with horizontal blue or grey ruling lines. The lines are evenly spaced and run across the width of the page. There are no margins, text, or other markings on the paper.

This image shows a single sheet of white paper with horizontal blue or grey ruling lines. The lines are evenly spaced and run across the width of the page. There is no handwriting or printed text on the paper.

