

# *HUDSON*



## **FLAT RATE MANUAL**

**480 SERIES CARS**

**Hudson Motor Car Company**  
**DETROIT 14, MICHIGAN**

## INTRODUCTION

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

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

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

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

---

## INSTRUCTIONS

In the "time required" column following the description of operations, there is listed the additional time required to perform further work at that stage of disassembly.

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

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

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

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

To expediate pricing and quoting, a labor conversion table is shown at the rear of the book and is computed at rates of \$1.50 to \$3.00 per hour labor charge.

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

The time established for the operations applies only to standard production model cars. Therefore, where accessories or special equipment interfere with the performance of these operations, additional time allowances will have to be made, provided, the operations are not included under accessories.

## MODEL DESIGNATION

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

Hudson Super Six	Model 481
Hudson Commodore Six	Model 482
Hudson Super Eight	Model 483
Hudson Commodore Eight	Model 484

## GROUP INDEX

Group	Page	Group	Page
1	1	13	30
2	3	14	33
3	5	15	34
4	5	16	37
5	8	17	37
6	9	18	37
7	12	19	38
8	14	20	39
9	15	21	40
10	24	22	41
11	28	23	42
12	29		

## ALPHABETICAL INDEX

14	ACCESSORIES	33	Master Cylinder	6
	Back-Up Light	33	Wheel Cylinders	6
	Battery Filler	33		
	Cigarette Lighter	33	16 BUMPERS	37
	Direction Indicator	33	Bumper Guard	37
	Fog Lights	33	Impact Bar	37
	Gas Tank Cap (Electric)	33	License Plate Guard	37
	Oil Filters	33		
	Outside Rear View Mirror	33	5 CLUTCH	8
	Radio	33	Drain and Refill	8
	Seat Covers	34	Overhaul	9
2	Spot Light	34	Pedal Adjustment	9
	Weather Control Unit	34	Throw-Out Bearing	9
	Windshield Washer	34		
			11 COOLING	28
	AXLE - REAR ASSEMBLY	3	Flush	28
	Axle Shafts	4	Hoses	29
	Bearings and Oil Seals	4	Radiator	29
	Carrier and Gear Set	3	Thermostat	29
10	Drive Gear & Pinion	4	Water Jacket	28
			Water Pump and Fan	29
	BODY AND HARDWARE	24		
	Body Trim	27	23 DRIVE-MASTER	42
	Cowl Vent	25	Adjustment	42
	Doors	24	Diaphragm	42
	Instrument Panel and Instruments	28	Power Unit	42
	Locker Box and Lock	28	Shafts and Levers	43
4	Rear Compartment	27	Solenoid	42
	Seats	26	Switches	43
	Switches	28		
	Weatherstrip	25	13 ELECTRICAL	30
	Window and Regulator	26	Battery	30
	Windshield	26	Coil	31
			Distributor	31
	BRAKES	5	Generator	30
	Adjustment	5	Horn	31
	Bleed Lines	6	Ignition Switch	31
	Brake Cables and Linkage	7	Lights	32
	Brake Shoes	6	Spark Plugs	32
	Hand Brake	8	Starter	32
	Hoses and Tubes	7		

## ALPHABETICAL INDEX—Continued

Group		Page	Group		Page
9	ENGINE - ASSEMBLY	15	18	SPRINGS - FRONT AND REAR	37
	Bearings	16		Coil Springs	37
	Camshaft, Crankshaft and Flywheel	17		Mounting Clips	38
	Connecting Rods, Pistons and Rings	19		Shackles	38
	Cylinder Block and Crankcase	18		Spring Leaf	38
	Cylinder Head	21	17	SHOCK ABSORBERS & STABILIZERS	37
	Engine Combination Operations	23		Bushings	37
	Engine Mountings	16		Front and Rear Shock Absorbers	37
	Engine Support Plate	16		Front and Rear Stabilizers	37
	Engine Tune-Up	23	21	STEERING GEAR ASSEMBLY	40
	Manifolds	18		Adjustment	40
	Oiling System	19		Housing	40
	Timing Gear or Chain	17		Jacket Tube and Bearing	40
	Valves and Tappets	21		Overhaul	40
12	EXHAUST SYSTEM	29		Sector Shaft	40
	Damper Valve	29		Steering Wheel	41
	Front and Rear Pipes	30		Worm and Tube	41
	Manifold	29	1	SUSPENSION - FRONT	1
	Muffler and Tail Pipe	30		Alignment - Caster & Camber	1
19	FUEL SYSTEM	38		Coil Springs & Shock Absorbers	2
	Carburetor	38		Front Hubs and Bearings	3
	Fuel Pump	39		Front Stabilizer Bar	3
	Gasoline Gauge	39		Lower Support Arm	1
	Gasoline Tank	39		Overhaul	1
20	LUBRICATION - STANDARD	39		Steering Spindle	1
	Clutch	40		Tie Rods	1
	1,000 Mile	39	6	TRANSMISSION & REMOTE CONTROL	9
	2,000 Mile	40		Countershaft	10
	5,000 Mile	40		Gears	10
	Pre-Delivery	39		Mainshaft	9
	Rear Springs	40		Overhaul	9
	Steering Gear	40		Remote Control	13
	Transmission	40		Shift Rails	11
	Wheels	40		Shift Selectors	11
7	OVERDRIVE	12	22	VACUOTIVE DRIVE	41
	Bearings	13		Adjustment	41
	Control Shaft	14		Piston Rod Boot	42
	Overhaul	12		Overhaul	41
	Shift Rail	13		Solenoid	41
	Solenoid	13		Switches	42
	Switch and Wiring	14		Valve Lever Cam	42
8	PROPELLER SHAFTS	14	3	WHEELS AND TIRES	5
	Center Bearing	14		Alignment	5
	Center Bearing Support	15		Bearings	5
	Front and Rear Shafts	14		Front Hub and Brake Drums	5
	Universal Joints	14		Rear Hub and Brake Drums	5
15	SHEET METAL	34		Tires	5
	Fenders	34			
	Hood	34			
	Radiator Grille	35			
	Rocker Panels and Mouldings	36			

OPERATION	DESCRIPTION	PRICE
<b>FRONT SUSPENSION</b>		
1-1	CASTER, CAMBER AND TOE-IN - Check.	All Models .5 .....
1-2	CASTER, CAMBER AND TOE-IN - Adjust.	All Models 1.3 .....
1-3	TOE-IN - Adjust (only).	All Models .6 .....
<b>TIE RODS</b>		
1-4	TIE ROD ASSEMBLY - Remove and Install (one side only). Includes adjust toe-in.	All Models 1.0 .....
1-5	TIE ROD ASSEMBLY - Remove and Install (both sides). Includes adjust toe-in.	All Models 1.4 .....
1-6	TIE ROD CLAMP - Remove and install.	All Models - one side .3 .....
		both sides .5 .....
1-7	TIE ROD END (OUTER) - Remove and Install. Includes adjusting toe-in.	All Models - one side .9 .....
		both sides 1.2 .....
<b>STEERING SPINDLE</b>		
1-8	STEERING SPINDLE PIVOT PIN - Remove and Install bushings. Includes adjusting caster, camber, and toe-in.	All Models - one side 24 .....
		both sides 35 .....
1-9	STEERING SPINDLE SUPPORT - Remove and Install. Includes adjusting caster, camber, and toe-in.	All Models - one side 30 .....
		both sides 47 .....
1-10	FRONT SUSPENSION OVERHAUL (No brake work) - Adjust caster, camber, and toe-in. Includes complete rebushing and replacement parts necessary.	All Models - both sides 65 .....
<b>LOWER SUPPORT ARM</b>		
1-11	LOWER SUPPORT ARM PIVOT INNER AND OUTER BUSHINGS - Remove and Install. Includes checking caster, camber and toe-in.	All Models - one side 1.0 .....
		both sides 1.5 .....
1-12	LOWER SUPPORT ARM (OUTER) PIVOT BUSHING - Remove and Install. Includes checking caster, camber, and toe-in.	All Models - one side 1.1 .....
		both sides 1.7 .....
1-13	LOWER SUPPORT ARM AND STEERING SPINDLE SUPPORT PIVOT - Remove and Install. Includes checking caster, camber, and toe-in.	All Models - one side 1.5 .....
		both side 1.8 .....

OPERATION	DESCRIPTION	PRICE
<b>FRONT SUSPENSION—Continued</b>		
<b>LOWER SUPPORT ARM—Continued</b>		
1-14	<b>LOWER SUPPORT ARM - Remove and Install.</b> Includes adjusting caster, camber, and toe-in.	
	All Models - one side	2.7 .....
	both sides	4.1 .....
<b>UPPER SUPPORT ARM</b>		
1-15	<b>ECCENTRIC BUSHING - Remove and Install.</b> Includes adjusting caster, camber, and toe-in	
	All Models - one side	1.9 .....
	both sides	2.4 .....
1-16	<b>UPPER SUPPORT ARM PIVOT ASSEMBLY - Remove and Install.</b> Includes adjusting caster, camber, and toe-in.	
	All Models - one side	2.7 .....
	both sides	4.1 .....
1-17	<b>CENTER STEERING ARM - Tighten</b> bracket to #2 crossmember.	
	All Models	.2 .....
1-18	<b>CENTER STEERING ARM - Remove and Install.</b>	All Models
		1.0 .....
1-19	<b>CENTER STEERING ARM BEARING - Remove and Install.</b>	
	All Models	1.2 .....
1-20	<b>STEERING SPINDLE - Remove and Install.</b> Includes adjusting caster, camber, and toe-in.	
	All Models - one side	2.7 .....
	both sides	4.1 .....
1-21	<b>STEERING ARM - RIGHT OR LEFT HAND - Remove and Install.</b> Adjust toe-in.	
	All Models	1.0 .....
1-22	<b>STEERING ARM -</b>	All Models
		.2 .....
<b>COIL SPRINGS AND SHOCK ABSORBERS</b>		
1-23	<b>COIL SPRING - Remove and Install.</b>	
	All Models - one side	1.0 .....
	both sides	1.5 .....
1-24	<b>COIL SPRING BUMPERS - Remove and Install.</b>	
	All Models - one side	.3 .....
	both sides	.5 .....
1-25	<b>FRONT SHOCK ABSORBER - Remove and Install.</b>	
	All Models - one side	.5 .....
	both sides	.9 .....
1-26	<b>FRONT SHOCK ABSORBER ANCHOR PLATE - Remove and Install.</b>	
	All Models - one side	.2 .....
	both sides	.4 .....

OPERATION	DESCRIPTION	PRICE
<b>FRONT SUSPENSION—Continued</b>		
<b>FRONT STABILIZER BAR</b>		
1-27	STABILIZER BAR - Remove and Install. All Models	.7 .....
1-28	STABILIZER MOUNTING BRACKET - Remove and Install. All Models	.7 .....
1-29	STABILIZER CONNECTOR BUSHINGS - Remove and Install. All Models - one side	.3 .....
	both sides	.5 .....
<b>FRONT HUB AND BEARINGS</b>		
1-30	FRONT WHEEL BEARINGS - Clean and Adjust or Replace. All Models - one side	.6 .....
	both sides	1.1 .....
1-31	FRONT WHEEL BEARINGS - Adjust only. All Models - both wheels	.4 .....
1-32	HUB AND BRAKE DRUM ASSEMBLY - Remove and Install. Includes cleaning and adjusting wheel bearings. All Models - one wheel	.6 .....
1-33	DRAG LINK ASSEMBLY - Remove and Install. All Models	.8 .....
1-34	DRAG LINK - Adjust. All Models	.5 .....
1-35	DRAG LINK BEARING AND/OR SPRING - Remove and Install. (one end). All Models	.4 .....
1-36	DRAG LINK DUST COVER - Remove and Install. All Models	.3 .....
<b>REAR AXLE</b>		
2-1	AXLE ASSEMBLY - Remove and install complete unit. Includes bleeding lines. All Models	3.7 .....
2-2	AXLE HOUSING - Remove and Install. Remove axle complete, disassemble, replace housing, build up complete unit and install. Includes bleeding lines and adjusting brakes. All Models	6.5 .....
<b>DIFFERENTIAL—CARRIER AND GEAR SET</b>		
2-3	DIFFERENTIAL CARRIER AND GEAR SET ASSEMBLY OR CARRIER HOUSING GASKET - Remove and Install. All Models	2.2 .....
2-4	DIFFERENTIAL CARRIER AND GEAR SET ASSEMBLY - Overhaul. Includes removing and installing complete carrier assembly and completely disassembling and replacing all the necessary parts and adjusting the drive gear and pinion mesh. All Models	4.7 .....



OPERATION	DESCRIPTION	PRICE
<b>REAR AXLE—Continued</b>		
<b>DIFFERENTIAL—CARRIER AND GEAR SET—Continued</b>		
2-5	<b>DIFFERENTIAL BEARINGS - Remove and Install</b> both bearings. Includes removing and installing carrier. All Models	3.0 .....
2-6	<b>DRIVE PINION BEARINGS - Remove and Install</b> both bearings. Includes removing and installing carrier and adjusting drive gear and pinion mesh. All Models	3.5 .....
2-7	<b>DRIVE PINION BEARING CUPS - Remove and Install</b> both cups. Includes removing and installing carrier and adjusting drive gear and pinion mesh. All Models	3.8 .....
2-8	<b>DRIVE GEAR AND PINION - Remove and Install</b> both. Includes removing and installing carrier and adjusting drive gear and pinion mesh. All Models	4.2 .....
2-9	<b>DRIVE GEAR AND PINION. Adjust.</b> Remove carrier, adjust gear and pinion mesh and install carrier to axle. All Models	3.7 .....
2-10	<b>DIFFERENTIAL CARRIER TO ASSEMBLY - Tighten to axle Housing.</b> All Models	.6 .....
2-11	<b>DRIVE PINION OIL SEAL - Remove and Install.</b> All Models	1.1 .....
2-12	<b>DRIVE PINION COMPANION FLANGE - Remove and Install.</b> All Models	.6 .....
<b>AXLE SHAFTS—BEARINGS AND OIL SEALS</b>		
2-13	<b>AXLE SHAFT - Remove and Install One.</b> Includes removing and replacing axle shaft, installing and repacking bearing. All Models	1.1 .....
2-14	<b>AXLE SHAFT - Adjust end play.</b> All Models - one side both sides	.6 .....
2-15	<b>AXLE SHAFT THRUST BUTTON - Remove and Install</b> one when shaft is removed from car. All Models	.4 .....
2-16	<b>AXLE SHAFT - INNER OIL SEAL - Remove and Install.</b> Includes repacking bearing, clean oil off drums. All Models - one side both sides	1.2 .....
2-17	<b>AXLE SHAFT - OUTER OIL SEAL - Remove and Install.</b> Includes cleaning brakes and drums. All Models - one side both sides	.7 .....
2-18	<b>REAR WHEEL BEARINGS - Remove and Install.</b> Includes repacking bearings. All Models - one side both sides	1.0 .....
		1.7 .....

OPERATION	DESCRIPTION	PRICE
<b>WHEELS AND TIRES</b>		
3-1	<b>WHEEL AND TIRE - Remove and Install.</b> Does not include removing and replacing tire. All Models - one wheel four wheels	.2 ..... .7 .....
3-2	<b>WHEEL - Remove and Install.</b> Includes removing and replacing tire. All Models - one wheel.	.5 .....
3-3	<b>FRONT WHEELS - Align.</b> Includes correcting toe-in, caster, camber, and toe-out. All Models	1.3 .....
3-4	<b>FRONT WHEEL BEARINGS - Adjust only.</b> All Models - Both wheels	.4 .....
3-5	<b>FRONT WHEEL BEARINGS - Remove and Install</b> bearing cones inner and outer, repack and adjust. All Models - one wheel both wheels	.6 ..... 1.1 .....
3-6	<b>FRONT WHEEL BEARING CUPS - Remove and Install</b> both with drum removed. All Models - one wheel both wheels	.2 ..... .3 .....
3-7	<b>FRONT WHEEL BEARING GREASE RETAINER - Remove and Install.</b> All Models - one wheel both wheels	.4 ..... .7 .....
3-8	<b>FRONT HUB AND BRAKE DRUM ASSEMBLY - Remove and Install.</b> Includes repack bearings and adjust. Does not include brake adjustment. All Models - one two	.6 ..... 1.1 .....
3-9	<b>REAR HUB AND BRAKE DRUM ASSEMBLY - Remove and Install.</b> Does not include brake adjustment. All Models - one two	.4 ..... .7 .....
3-10	<b>REAR HUB KEY - Remove and Install</b> one rear hub key only. All Models	.4 .....
3-11	<b>WHEELS - BALANCE - Includes remove and install wheels.</b> Does not include removing tires. All Models - Two - Statically Two - Statically and dynamically	1.0 ..... 1.4 .....

## BRAKES

4.1	<b>BRAKES - MINOR ADJUSTMENT - Remove wheels,</b> adjust shoes, adjust brake cables, check anchor pin nuts for tightness, adjust brake pedal and check brake fluid. All Models	1.6 .....
4.2	<b>BRAKES - MAJOR ADJUSTMENT - Remove drums,</b> check linings for wear and loose rivets, clean brake shoes and backing plates, grease brake cables, adjust anchor pins and adjusting screws. Tighten spring mounting clips and refill master cylinder. All Models	3.1 .....

OPERATION	DESCRIPTION	PRICE
<b>BRAKES—Continued</b>		
4-3	<b>RAKES - Bleed lines.</b> All Models	.7 .....
4-4	<b>BRAKES - Flush system.</b> Flush entire system with alcohol and refill master cylinder with new Hudson Brake Fluid, check for leaks. All Models	1.2 .....
4-5	<b>BRAKE SHOES - Remove and Install.</b> Includes removing drums and old shoes, clean backing plates, add lubriplate to shoe contact points, install new or relined shoes and adjust brakes. All Models - one wheel four wheels	.9 .....
4-6	<b>BRAKE SHOES - Reline.</b> Add to Operation 4-5. If necessary to bleed lines - All Models - each wheel All Models Add	.3 .....
4-7	<b>BRAKE SHOES - Lubricate.</b> Includes removing drums and applying lubriplate between shoes and backing plates. All Models - four wheels	.5 .....
4-8	<b>BRAKE BACKING PLATE - Remove and Install.</b> Includes removing and installing necessary parts, adjusting brakes and bleeding lines. All Models - one front one rear	1.6 .....
4-9	<b>BRAKE DRUMS - Remove and Install.</b> Includes packing bearing and adjust. All Models - one rear one front	.4 .....
4-10	<b>BRAKE DRUM - Reface</b> on machine when wheel is removed All Models - one two four	.4 .....
<b>WHEEL CYLINDER</b>		
4-11	<b>WHEEL CYLINDER - Remove and Install.</b> Includes bleeding lines. All Models - one front or rear two front or rear all four wheels	1.3 .....
4-12	<b>WHEEL CYLINDER - Overhaul one.</b> Includes remove and install. Replace all necessary parts, bleed lines All Models - Front Rear	1.6 .....
4-13	<b>WHEEL CYLINDER BLEEDER VALVE - Remove and Install.</b> All Models	1.7 .....
<b>MASTER CYLINDER</b>		
4-14	<b>MASTER CYLINDER - Remove and Install.</b> Includes bleeding line. All Models	.2 .....
		1.5 .....

OPERATION	DESCRIPTION	PRICE
<b>BRAKES—Continued</b>		
<b>MASTER CYLINDER—Continued</b>		
4-15	MASTER CYLINDER - Overhaul - Add to Operation 4-14. All Models	.6 .....
4-16	MASTER CYLINDER OUTLET - FITTING OR GASKET - Remove and Install. Includes bleeding lines. All Models	1.0 .....
4-17	MASTER CYLINDER FILLER CAP OR GASKET - Remove and Install. All Models	.2 .....
<b>HOSE AND TUBES</b>		
4-18	BRAKE HOSE - Remove and Install. Includes bleeding lines. All Models - one front one rear	.9 ..... .8 .....
4-19	BRAKE TUBES - Remove and Install all. Includes bleeding lines. All Models	1.8 .....
4-20	BRAKE TUBE - REAR AXLE TEE TO RIGHT REAR CYLINDER. Remove and Install. Includes bleeding lines. All Models	.9 .....
4-21	BRAKE TUBE - REAR AXLE TEE TO 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 R.H. FRONT WHEEL. Remove and Install. Includes bleeding lines. All Models	1.0 .....
4-24	BRAKE TUBE - FRAME TEE TO L.H. FRONT WHEEL - Remove and Install. Includes bleeding lines. All Models	1.0 .....
4-25	FRAME TEE - Remove and Install. Includes bleeding lines. All Models	.9 .....
4-26	REAR AXLE TEE - Remove and Install. Includes bleeding lines. All Models	.9 .....
<b>BRAKE CABLES AND LINKAGE</b>		
4-27	BRAKE CABLE AND CONDUIT ASSEMBLY - Remove and Install. Includes lubricating cables. All Models - one two	.9 ..... 1.5 .....
4-28	BRAKE CABLE - Free up both rear, remove and clean, free up and lubricate. All Models	1.5 .....
4-29	BRAKE CONTROL LEVER OR SUPPORT BRACKET - Remove and Install. All Models	.5 .....

OPERATION	DESCRIPTION	PRICE
<b>BRAKES—Continued</b>		
<b>BRAKE CABLES AND LINKAGE—Continued</b>		
4-30	BRAKE FOLLOW UP PUSH ROD - Remove and Install. All Models	.4 .....
4-31	BRAKE PULL BACK SPRING - Replace. All Models	.2 .....
4-32	BRAKE PEDAL - Remove and Install. All Models	2.0 .....
4-33	BRAKE PEDAL MASTER CYLINDER PUSH ROD - Remove and Install. All Models	.5 .....
4-34	BRAKE CROSS SHAFT TO MASTER CYLINDER BRACE OR BRAKE CONTROL HAND BRAKE CABLE LEVER - Remove and Install All Models	.6 .....
<b>HAND BRAKE</b>		
4-35	HAND BRAKE CABLE AND CONDUIT OR HAND BRAKE LEVER MOUNTING BRACKET - Remove and Install. All Models	.9 .....
4-36	HAND BRAKE CABLE - Adjust. All Models	.3 .....
4-37	HAND BRAKE LEVER - Remove and Install. All Models	.4 .....
4-38	HAND BRAKE RATCHET LOCK SPRINGS - Remove and Install. All Models	.2 .....
<b>CLUTCH</b>		
5-1	CLUTCH - Drain and refill. All Models Without Drive-Master. With Drive-Master	.2 .....
		.3 .....
5-2	CLUTCH - Wash Out and Refill. All Models Without Drive-Master With Drive-Master	.4 .....
		.5 .....
5-3	CLUTCH ASSEMBLY - Remove and Install. Includes replacing the clutch cover gasket or driving plate. All Models Standard Transmission With Drive-Master With Overdrive With Drive-Master and Overdrive	4.6 .....
		5.2 .....
		5.4 .....
		5.6 .....
	Inspection and adjustment, add to Operation 5-3	.5 .....
5-4	CLUTCH PILOT BEARING - Remove and Install. Add to Operation 5-3. All Models	.3 .....

OPERATION	DESCRIPTION	PRICE
<b>CLUTCH—Continued</b>		
5-5	<b>CLUTCH ASSEMBLY - Overhaul.</b> Includes removing and installing the clutch assembly, replacing pressure plate and/or retainers, fingers, engaging springs, clutch cover, and all adjustments.	
	All Models Standard Transmission	5.7 .....
	With Drive-Master	6.3 .....
	With Overdrive	6.5 .....
	With Drive-Master and Overdrive	6.7 .....
5-6	<b>CLUTCH ASSEMBLY - Overhaul - Clutch removed from car.</b> Includes replacing pressure plate and/or retainers, fingers, engaging springs, clutch cover and adjust.	
	All Models	1.1 .....
	<b>CLUTCH PEDAL - Adjust clutch pedal.</b>	All Models
5-1		.3 .....
5-8	<b>CLUTCH HOUSING - Remove and Install.</b> Includes removing and installing transmission.	
	All Models Standard Transmission	4.0 .....
	With Drive-Master	4.6 .....
	With Overdrive	4.8 .....
	With Drive-Master and Overdrive	5.0 .....
5-9	<b>CLUTCH - THROWOUT COLLAR AND/OR THROWOUT BEARING OR OIL SEAL OR THROWOUT YOKE. Remove and Install.</b> Includes removing and installing transmission. Add to Operation 5-8.	.3 .....
	All Models	
<b>TRANSMISSION</b>		
6-1	<b>TRANSMISSION ASSEMBLY - Remove and Install.</b>	
	All Models Standard Transmission	3.7 .....
	With Drive-Master	4.3 .....
	With Overdrive	4.5 .....
	With Drive-Master and Overdrive	4.7 .....
6-2	<b>TRANSMISSION ASSEMBLY - Overhaul and/or replace transmission case.</b> Includes removing and installing, completely disassembling transmission, renewing any necessary parts, and reassembling transmission complete.	
	All Models Standard Transmission	6.2 .....
	With Drive-Master	6.8 .....
	With Overdrive	7.2 .....
	With Drive-Master and Overdrive	7.4 .....
6-3	<b>MAIN SHAFT - Remove and Install - mainshaft</b> or any gear on mainshaft, including synchronizer assembly and main shaft rear bearing. Includes removing and installing transmission.	
	All Models Standard Transmission	5.9 .....
	With Drive-Master	6.5 .....
	With Overdrive	6.9 .....
	With Drive-Master and Overdrive	7.4 .....

OPERATION	DESCRIPTION	PRICE
<b>TRANSMISSION—Continued</b>		
6-4	<b>MAIN SHAFT REAR BEARING - Remove and Install.</b> Not necessary to remove transmission to remove this bearing on cars without Overdrive.	
	All Models Standard Transmission	1.2 .....
	With Drive-Master	1.4 .....
	With Drive-Master and Overdrive	7.3 .....
6-5	<b>TRANSMISSION - COMPANION FLANGE - Remove and Install.</b> (Transmission in car).	All Models .8 .....
6-6	<b>TRANSMISSION MAINSHAFT OIL SEAL - Remove and Install.</b>	
	All Models - Transmission in car	1.1 .....
	Transmission removed from car	.4 .....
6-7	<b>TRANSMISSION - MAIN DRIVE GEAR - Remove and Install.</b> Includes removing and installing transmission, replacing any or all parts including needle roller or main drive gear bearing.	
	All Models Standard Transmission	6.0 .....
	With Drive-Master	6.6 .....
	With Overdrive	7.0 .....
	With Drive-Master and Overdrive	7.2 .....
6-8	<b>TRANSMISSION - MAIN DRIVE GEAR BEARING RETAINER AND OIL SEAL - Remove and Install.</b> Includes removing and installing transmission.	
	All Models Standard Transmission	4.2 .....
	With Drive-Master	4.8 .....
	With Overdrive	5.0 .....
	With Drive-Master and Overdrive	5.2 .....
<b>COUNTERSHAFT</b>		
6-9	<b>COUNTERSHAFT GEAR CLUSTER AND/OR COUNTERSHAFT - Remove and Install.</b> Includes removing and installing transmission, replacing countershaft and/or thrust washers.	
	All Models Standard Transmission	6.1 .....
	With Drive-Master	6.7 .....
	With Overdrive	7.1 .....
	With Drive-Master and Overdrive	7.3 .....
6-10	<b>COUNTERSHAFT GEAR CLUSTER BUSHINGS - Remove and Install</b> and Line Ream. Includes removing and installing transmission.	
	All Models Standard Transmission	6.6 .....
	With Drive-Master	7.2 .....
	With Overdrive	7.6 .....
	With Drive-Master and Overdrive	7.8 .....
	With gear removed	.6 .....

OPERATION	DESCRIPTION	PRICE
<b>TRANSMISSION—Continued</b>		
6-11	COUNTERSHAFT THRUST WASHER DOWEL PIN - <b>Replace</b> . Includes removing and installing transmission.	
	All Models Standard Transmission	6.3 .....
	With Drive-Master	6.9 .....
	With Overdrive	7.3 .....
	With Drive-Master and Overdrive	7.5 .....
6-12	REVERSE IDLER GEAR AND/OR SHAFT - <b>Remove and Install</b> . Includes removing and installing transmission.	
	All Models Standard Transmission	6.2 .....
	With Drive-Master	6.8 .....
	With Overdrive	7.2 .....
	With Drive-Master and Overdrive	7.4 .....
6-13	REVERSE IDLER GEAR BUSHING - <b>Remove, Install</b> and Ream. Includes removing and installing transmission.	
	All Models Standard Transmission	6.4 .....
	With Drive-Master	7.0 .....
	With Overdrive	7.4 .....
	With Drive-Master and Overdrive	7.6 .....
	With gear removed	.4 .....
6-14	LOW AND REVERSE SHIFT RAIL, SHIFT RAIL FORK - <b>Remove and Install</b> . Not necessary to remove transmission.	
	All Models Standard Transmission	2.9 .....
	With Drive-Master	3.1 .....
	Includes remove and install transmission.	
	With Overdrive	6.0 .....
6-15	HIGH AND INTERMEDIATE SHIFT RAIL, SHIFT FORK, LOCK BALL AND SPRING. <b>Remove and Install</b> all. Includes removing and installing transmission.	
	All Models Standard Transmission	4.1 .....
	With Drive-Master	4.7 .....
	With Overdrive	4.9 .....
	With Drive-Master and Overdrive	5.1 .....
6-16	TRANSMISSION SHIFT SELECTOR LEVER AND SHAFT AND/OR SHIFT SHAFT AND/OR SHIFT SHAFT LEVER INNER - <b>Remove and Install</b> . Not necessary to remove transmission.	
	All Models Standard Transmission	3.3 .....
	With Drive-Master	3.5 .....
	With Overdrive	3.5 .....
	With Drive-Master and Overdrive	3.6 .....
6-7	TRANSMISSION COVER AND/OR GASKET - <b>Remove and Install</b> .	
	All Models	2.5 .....



OPERATION	DESCRIPTION	PRICE
<b>TRANSMISSION—Continued</b>		
<b>REMOTE CONTROL</b>		
6-18	REMOTE CONTROL LEVER, TUBE AND STEERING GEAR JACKET TUBE ASSEMBLY - Remove and Install. All Models Without Direction Indicator	2.2 .....
6-19	REMOTE CONTROL LEVER, TUBE AND ROD ASSEMBLY - Remove and Install. All Models Without Direction Indicator	1.7 .....
6-20	REMOTE CONTROL GEAR SHIFT LEVER - Remove and Install. All Models	.4 .....
6-21	REMOTE CONTROL LEVER TUBE AND FULCRUM BRACKET ASSEMBLY - Remove and Install. All Models Without Direction Indicator	1.9 .....
6-22	REMOTE CONTROL TUBE UPPER BRACKET - Remove and Install. All Models Without Direction Indicator	.7 .....
6-23	REMOTE CONTROL TUBE BRACKET LOWER - Remove and Install. All Models	2.3 .....
6-24	REMOTE CONTROL PUSH ROD - Remove and Install. All Models	1.4 .....
6-25	REMOTE CONTROL WIRE, CASING AND BRACKET ASSEMBLY - Remove and Install. All Models Without Drive-Master With Drive-Master	.8 .....
6-26	REMOTE CONTROL BELL CRANK AND BUSHING ASSEMBLY - Remove and Install. All Models	.6 .....
6-27	REMOTE CONTROL BELL CRANK TO TRANSMISSION ROD AND GROMMET ASSEMBLY - Remove and Install. All Models	.2 .....
<b>OVERDRIVE</b>		
7-1	TRANSMISSION AND OVERDRIVE ASSEMBLY - Remove and Install. All Models With Drive-Master Add	4.5 .....
7-2	TRANSMISSION AND OVERDRIVE - Overhaul - Includes removing and installing transmission and Overdrive from and to car. Removing and replacing transmission and Overdrive mainshaft and or any gears on mainshaft. All Models With Drive-Master Add If necessary to replace countershaft gear Add	7.0 .....
7-3	OVERDRIVE ASSEMBLY - Overhaul - Includes complete disassembly and replacement of any parts in Overdrive unit. Does not include removing and replacing transmission mainshaft or Overdrive adapter All Models - Transmission in car Transmission removed	3.3 .....
		1.3 .....

OPERATION	DESCRIPTION	PRICE
<b>OVERDRIVE—Continued</b>		
7-4	<b>OVERDRIVE ASSEMBLY - Remove and Install.</b> Includes removing and replacing transmission, removing and replacing Overdrive unit. All Models With Drive-Master                      Add	5.6 ..... .2 .....
7-5	<b>OVERDRIVE REAR BEARING - Remove and Install.</b> All Models - Transmission in car	2.2 .....
7-6	<b>OVERDRIVE REAR OIL SEAL - Remove and Install.</b> All Models - Transmission in car	1.4 .....
7-7	<b>OVERDRIVE MAIN SHAFT SPEEDOMETER DRIVE GEAR- Remove and Install.</b> All Models - Transmission in car Transmission removed	2.1 ..... .7 .....
7-8	<b>OVERDRIVE SHIFT RAIL AND/OR FORK - Remove and Install.</b> All Models - Transmission in car Transmission removed	2.2 ..... .8 .....
7-9	<b>OVERDRIVE SOLENOID - Remove and Install.</b> All Models - Transmission in car	.4 .....
7-10	<b>SOLENOID GEAR PAWL - Remove and Install.</b> All Models - Transmission in car Transmission removed	3.4 ..... 1.2 .....
7-11	<b>OVERDRIVE THROTTLE SWITCH - Remove and Install.</b> Includes adjustment. All Models	.3 .....
7-12	<b>OVERDRIVE GOVERNOR SWITCH - Remove and Install.</b> All Models	.4 .....
7-13	<b>OVERDRIVE SOLENOID WIRING HARNESS ASSEMBLY - Remove and Install.</b> All Models	.6 .....
7-14	<b>OVERDRIVE CONTROL WIRE ASSEMBLY - Remove, Install, and Adjust.</b> All Models	.6 .....
7-15	<b>OVERDRIVE SPEEDOMETER PINION OR SLEEVE - Remove and Install.</b> All Models	.5 .....
7-16	<b>OVERDRIVE ADAPTER TO TRANSMISSION GASKET - Remove and Replace.</b> Includes removing and installing transmission with Over-drive. All Models With Drive-Master                      Add	5.4 ..... .2 .....
7-17	<b>OVERDRIVE ADAPTER TO OVERDRIVE HOUSING GASKET - Remove and Install.</b> All Models	2.1 .....
7-18	<b>TRANSMISSION MAIN SHAFT AND/OR MAIN SHAFT REAR BEARING - Remove and Install.</b> Includes removing and replacing transmission with Overdrive. All Models With Drive-Master                      Add	6.2 ..... .2 .....

OPERATION	DESCRIPTION	PRICE
<b>OVERDRIVE—Continued</b>		
7-19	OVERDRIVE RELAY - Remove and Install. All Models	.4 .....
7-20	OVERDRIVE SHIFT RAIL SWITCH - Remove and Install. All Models	
7-21	OVERDRIVE HOUSING ADAPTER - Remove and Install - Includes removing and replacing transmission with Overdrive. All Models	.3 .....
	With Drive-Master Add	6.3 ..... .2
7-22	OVERDRIVE STATIONARY GEAR AND/OR BALK RING - Remove and Install. Includes removing and replacing transmission with Overdrive. All Models	..... 3.4 .....
7-23	OVERDRIVE CONTROL SHAFT - Remove and Install. All Models - Transmission in car	2.3 .....
7-24	INTERLOCK PLUNGER - Remove and Install. Includes removing and installing Overdrive unit. All Models	5.6 .....
	With Drive-Master Add	.2 .....
<b>PROPELLER SHAFTS</b>		
8-1	PROPELLER SHAFT AND THREE UNIVERSAL JOINTS ASSEMBLY - Remove and Install. All Models	1.7 .....
8-2	PROPELLER FRONT OR REAR UNIVERSAL JOINT ASSEMBLY - Remove and Install. All Models	1.0 .....
8-3	UNIVERSAL JOINTS (THREE) - Overhaul, remove, replace necessary parts and Install. All Models	2.4 .....
8-4	PROPELLER SHAFT REAR SLEEVE YOKE - Remove and Install. All Models	.8 .....
8-5	PROPELLER SHAFT "U" BOLTS - FRONT OR REAR - Remove and Install. All Models	.6 .....
8-6	PROPELLER SHAFT "U" BOLTS - Tighten. All Models	.5 .....
8-7	PROPELLER SHAFT TRANSMISSION OR AXLE CARRIER COMPANION FLANGE - Remove and Install. All Models	.6 .....
8-8	PROPELLER SHAFT COMPANION FLANGE (REAR END OF FRONT SHAFT) - Remove and Install. All Models	.8 .....
8-9	PROPELLER SHAFT CENTER BEARING AND HOUSING ASSEMBLY - Remove and Install. All Models	1.0 .....
8-10	PROPELLER SHAFT CENTER BEARING - Remove and Install. All Models	1.2 .....

OPERATION	DESCRIPTION	PRICE
<b>PROPELLER SHAFTS—Continued</b>		
8-11	PROPELLER SHAFT CENTER BEARING SUPPORT CUSHION FRONT - Remove and Install. All Models	.3 .....
8-12	PROPELLER SHAFT CENTER BEARING SUPPORT - Remove and Install. All Models	.5 .....
8-13	PROPELLER SHAFT CENTER BEARING SUPPORT CUSHION REAR - Remove and Install. All Models	.7 .....
<b>ENGINE</b>		
9-1	ENGINE AND TRANSMISSION ASSEMBLY - Remove and Install. All Models - 6 cylinder 8 cylinder With Drive-Master Add With Overdrive Add With Drive-Master and Overdrive Add	6.2 ..... 6.7 ..... .8 ..... .7 ..... 1.3 .....
9-2	ENGINE ASSEMBLY - Remove and Install. Includes removing engine with transmission attached. Remove and install transmission, clutch, fuel system and electrical equipment from and to engine, no repair. All Models - 6 cylinder 8 cylinder With Drive-Master Add With Overdrive Add With Drive-Master and Overdrive Add	8.3 ..... 8.8 ..... 1.8 ..... .7 ..... 2.4 .....
9-3	SKELETON ENGINE - Remove and Install. Includes removing engine from car. Removing all parts from old engine and reassembling parts to new engine. Does not include reconditioning electrical, fuel equipment or engine tune-up. All Models - 6 cylinder 8 cylinder With Drive-Master Add With Overdrive Add With Drive-Master and Overdrive Add	15.8 ..... 16.4 ..... 1.8 ..... .7 ..... 2.4 .....
9-4	CYLINDER AND PISTONS ASSEMBLY - Remove, Build Up and Install. Includes removal of engine, removing all parts from old engine, cleaning all parts, refacing old and/or new valves and valve seats, aligning rods and pistons, assembly of parts to engine, reinstall and paint engine. Does not include reconditioning electrical or fuel equipment or engine tune -up. All Models - 6 cylinder 8 cylinder With Drive-Master Add With Overdrive Add With Drive-Master and Overdrive Add	21.2 ..... 23.1 ..... 1.8 ..... .7 ..... 2.4 .....



OPERATION	DESCRIPTION	PRICE
-----------	-------------	-------

### ENGINE—Continued

#### BEARINGS

9-14	MAIN BEARINGS - Remove and Install All, with engine removed from car. Use factory reamed bearings available from Factory Parts Department.	All Models - 6 cylinder	2.2 .....
		8 cylinder	2.6 .....
9-15	MAIN BEARINGS - Remove and Install All. Includes line ream. Engine removed from car and crankshaft removed.	All Models - 8 cylinder	3.9 .....
9-16	MAIN BEARING - CENTER UPPER AND LOWER -Replace with engine in car. Includes removing and installing oil pan.	All Models - 6 cylinder	2.0 .....
		8 cylinder	3.5 .....
		With Drive-Master	Add .2 .....
9-17	MAIN BEARING -REAR - Oil Leak Correction with engine in car. Remove oil pan, remove main bearing cap, clean out oil return, repack cap, renew oil pan gasket if necessary.	All Models - 6 cylinder	2.3 .....
		8 cylinder	3.6 .....
		With Drive-Master	Add .2 .....

#### CAMSHAFT, CRANKSHAFT, AND FLYWHEEL

9-18	CAMSHAFT - Remove and Install. Includes removing and installing cylinder head, check timing, . and adjust tappets.	All Models - 6 cylinder	9.2 .....
		8 cylinder	9.9 .....
		With Drive-Master	Add .8 .....
9-19	CRANKSHAFT - Remove and Install. Includes remove and replace engine.	All Models - 6 cylinder	10.9 .....
		8 cylinder	11.8 .....
		With Drive-Master	Add .8 .....
		With Overdrive	Add .7 .....
		With Drive-Master & Overdrive	Add 1.3 .....
9-20	CRANKSHAFT - VIBRATION DAMPENER - Remove and Install.	All Models	1.2 .....
9-21	FLYWHEEL ASSEMBLY - Remove and Install or Tighten.	All Models Standard Transmission	5.0 .....
		With Drive-Master	5.8 .....
		With Overdrive	5.7 .....
		With Drive-Master & Overdrive	6.3 .....
9-22	FLYWHEEL RING GEAR - Remove and Install when flywheel is off.	All Models	.6 .....
9-23	TIMING GEAR COVER, GASKET, OR OIL SEAL AND SPACER - Remove and Install.	All Models	2.3 .....

OPERATION	DESCRIPTION	PRICE
-----------	-------------	-------

### ENGINE—Continued

#### CAMSHAFT, CRANKSHAFT, AND FLYWHEEL—Continued

9-24	TIMING GEARS AND/OR TIMING CHAIN - Remove and Install. Includes checking timing.	All Models - 6 cylinder	3.1 .....
		8 cylinder	2.9 .....
9-25	CAMSHAFT GEAR - Remove and Install or Tighten.	All Models - 6 cylinder.	2.7 .....
		8 cylinder	2.5 .....
9-26	CRANKSHAFT GEAR - Remove and Install.	All Models - 6 cylinder	3.1 .....
		8 cylinder	2.6 .....

#### CYLINDER AND CRANKCASE

9-27	CYLINDER - Hone All Cylinders when head is off and pistons out.	All Models - 6 cylinder	4.7 .....
		8 cylinder	5.9 .....
9-28	CYLINDER - Rebore All Cylinders when head is off and pistons out. Includes removing and replacing studs or cap screws.	All Models - 6 cylinder	5.5 .....
		8 cylinder	7.2 .....
9-29	CYLINDER - Hone One Cylinder only when head is off and piston is out. All Models		1.0 .....
		Each additional cylinder	Add .7 .....
9-30	CYLINDER HEAD STUD - Remove and Replace All. Cylinder head removed. All Models - 8 cylinder		1.0 .....
9-31	CYLINDER HEAD STUD - Remove and Replace One Broken Stud. Cylinder head removed. All Models - 8 cylinder		.4 .....

#### MANIFOLDS

9-32	EXHAUST MANIFOLD AND/OR EXHAUST MANIFOLD GASKETS - Remove and Install.	All Models - 6 cylinder	2.2 .....
		8 cylinder	1.9 .....
9-33	EXHAUST MANIFOLD AUTOMATIC CHOKE HEAT TUBE - Remove and Install. All Models		.3 .....
9-34	INTAKE MANIFOLD AND/OR INTAKE MANIFOLD GASKETS - Remove and Install.	All Models - 6 cylinder	2.2 .....
		8 cylinder	2.5 .....
9-35	INTAKE MANIFOLD TO CARBURETOR GASKET - Remove and Install. All Models		.4

OPERATION	DESCRIPTION	PRICE
-----------	-------------	-------

### ENGINE—Continued

#### OILING SYSTEM

9-36	OIL CHECK VALVE - Remove and Install.	All Models - 6 cylinder	.2 .....
		8 cylinder	.4 .....
		With Drive-Master - 6 cylinder	1.1 .....
9-37	OIL CHECK VALVE INDICATOR PRESSURE PIN ASSEMBLY - Remove and Install.	All Models - 8 cylinder	.2 .....
9-38	OIL INDICATOR SENDER - Remove and Install.	All Models - 6 cylinder	.2 .....
9-39	OIL PAN ASSEMBLY - Remove, Clean and Install. Includes removing and replacing pan and baffle gaskets.	All Models - 6 cylinder	1.6 .....
		8 cylinder	2.5 .....
		With Drive-Master Add	.2 .....
9-40	OIL PUMP ASSEMBLY - Remove and Install. Includes checking timing on 6 cylinder motor.	All Models - 6 cylinder	.6 .....
		8 cylinder	.8 .....
		With Drive-Master - 6 cylinder	.7 .....
9-41	OIL PUMP SUCTION PIPE - Remove and Install.	All Models - 8 cylinder.	.2 .....
9-42	OIL PUMP TO OIL CHECK VALVE PIPE - Remove and Install.	All Models - 8 cylinder.	.3 .....
9-43	OIL LEAK - Check and Tighten all oil connections, oil pan screws and check for external oil leaks with engine running.	All Models - 6 cylinder	.5 .....
		8 cylinder	.6 .....
9-44	OIL INDICATOR LIGHT - Check. Inspect check valve contact. Make necessary repairs to check valve, light or wiring.	All Models - 6 cylinder	.3 .....
		8 cylinder	.6 .....
9-45	OIL INDICATOR LIGHT - Remove and Install lens or bulb.	All Models	.2 .....
9-40	OIL FILTER - Remove and Install. Includes removing and replacing all flexible oil lines.	All Models - 6 cylinder	.7 .....
		8 cylinder	1.3 .....
9-47	OIL FILTER CARTRIDGE - Remove and Install.	All Models	.2 .....

#### CONNECTING RODS AND PISTONS

9-48	CONNECTING RODS - Align All. Includes removing and replacing head and oil pan, replacing gaskets, removing ridge from cylinder walls, removing rods and pistons from engine, removing and replacing rings on piston, aligning rods with pistons on aligning fixture and installing rods in engine.	All Models - 6 cylinder	7.1 .....
		8 cylinder	8.4 .....
		With Drive-Master Add	.8 .....



OPERATION	DESCRIPTION	PRICE
<b>ENGINE—Continued</b>		
<b>CONNECTING RODS AND PISTONS—Continued</b>		
9-49	<b>CONNECTING RODS - Align All.</b> When removed from engine. Includes removing and replacing rings on piston.	
	All Models - 6 cylinder	1.6 .....
	8 cylinder	2.0 .....
9-50	<b>CONNECTING RODS - Remove and Install</b> All new rods using old pistons. To Operation #9-47, add	1.0 .....
9-51	<b>CONNECTING ROD - Remove and Install</b> One rod only. Includes removing oil pan and cylinder head, removing ridge from cylinder walls, removing rod and piston, remove and replace piston rings, align rod with piston on fixture.	
	All Models - 6 cylinder	4.6 .....
	8 cylinder	5.6 .....
	With Drive-Master Add	.8 .....
	Each additional rod Add	.5 .....
9-52	<b>PISTON - Remove and Replace</b> One piston when oil pan and cylinder head are removed. Includes removing ridge from cylinder wall, fitting rings and piston to cylinder.	
	All Models	.8 .....
9-53	<b>PISTONS AND RINGS - Remove and Install All.</b> Includes removing and replacing oil pan and cylinder head, removing ridge from cylinder walls and carbon from cylinder head, fitting new rings and pistons to cylinders and aligning rods.	
	All Models - 6 cylinder	8.3 .....
	8 cylinder	10.2 .....
	With Drive-Master Add	.8 .....
	If necessary to hone all cylinders - 6 cylinder - Add	4.7 .....
	8 cylinder - Add	5.9 .....
9-54	<b>PISTONS AND RINGS - Remove and Install</b> One. Includes removing and replacing oil pan and cylinder head, removing ridge from cylinder wall, fitting pistons, rings and pins, align rod.	
	All Models - 6 cylinder	4.8 .....
	8 cylinder	5.8 .....
	With Drive-Master Add	.8 .....
	Each additional piston Add	.7 .....
	If necessary to hone one cylinder Add	1.0 .....
	Each additional cylinder Add	.7 .....
9-55	<b>PISTON PINS - Remove and Install</b> All pins and connecting rod bushings and align connecting rods, using old pistons and standard pins. Includes removing ridge from cylinder walls and carbon from ring grooves; remove and install rings; remove, install, and align connecting rods; remove and replace cylinder head and oil pan.	
	All Models - 6 cylinder	9.2 .....
	8 cylinder	11.1 .....
	With Drive-Master Add	.8 .....

OPERATION	DESCRIPTION	PRICE
-----------	-------------	-------

### ENGINE—Continued

#### CONNECTING RODS AND PISTONS—Continued

9-56	<b>PISTON PIN - Standard or Oversize - Remove and Install</b> One pin and bushing; remove and replace cylinder head and oil pan; remove ridge from cylinder wall; remove and replace piston rings; align rod; and install rod and piston in engine.	All Models - 6 cylinder	5.0 .....
		8 cylinder	6.0 .....
		With Drive-Master	Add .8 .....
		Each additional pin	Add .8 .....
9-57	<b>PISTON PIN - Standard or Oversize - Remove, Fit and Install</b> (Bench work). Renew and ream bushing, fit pin and align rod. Connecting rod and piston removed from engine.	All Models - each pin	.4 .....
9-58	<b>PISTON RINGS - Remove and Install</b> All on old pistons. Includes removing old rings, cleaning carbon from piston, fitting rings to piston and installing rings. Remove and replace cylinder head and oil pan, remove ridge from cylinder walls, (align rod) installing pistons and rods to engine.	All Models - 6 cylinder	7.3 .....
		8 cylinder	9.2 .....
		With Drive-Master	Add .8 .....
9-59	<b>PISTON RINGS - Remove and Install on one piston.</b> Includes removing old rings, cleaning carbon from piston, fitting rings to piston and installing new rings. Remove and replace cylinder head and oil pan, remove ridge from cylinder wall, align rod and install piston and rod to engine.	All Models - 6 cylinder	4.5 .....
		8 cylinder	5.5 .....
		With Drive-Master	Add .8 .....
		Each additional piston	Add .6 .....
9-60	<b>PISTON RINGS - Fit and Install.</b> (Bench work).	All Models - one piston	.2 .....

#### CYLINDER HEAD

9-61	<b>COMPRESSION Test - All cylinders.</b>	All Models - 6 cylinder	.8 .....
		8 cylinder	.9 .....
9-62	<b>CYLINDER HEAD AND/OR GASKET - Remove and Install.</b> Includes removing carbon, removing and replacing plugs.	All Models - 6 cylinder	1.8 .....
		8 cylinder	2.3 .....
		With Drive-Master	Add .8 .....
9-63	<b>CYLINDER HEAD - Tighten All</b> stud nuts or bolts.	All Models - 6 cylinder	.3 .....
		8 cylinder	.4 .....

#### VALVES AND TAPPETS

9-64	<b>TAPPETS - Adjust all.</b>	All Models - 6 cylinder	1.2 .....
		8 cylinder	1.9 .....

OPERATION	DESCRIPTION	PRICE
<b>ENGINE—Continued</b>		
<b>VALVES AND TAPPETS</b>		
9-65	<b>TAPPET ASSEMBLY - Remove and Install.</b> All Complete tappet and guide assemblies. Includes removing and installing cylinder head and adjusting tappets. All Models - 8 cylinder only	4.8 .....
9-66	<b>TAPPET ASSEMBLY - Remove and Install.</b> Includes remove and install cylinder head and oil pan, remove and install camshaft, and adjust tappets. All Models - 6 cylinder With Drive-Master Add	9.8 ..... .8 .....
9-67	<b>TAPPET ASSEMBLY - Remove and Install One.</b> Not necessary to remove cylinder head. All Models - 8 cylinder	1.1 .....
9-68	<b>TAPPET ASSEMBLY - Remove and Install One.</b> Includes remove and install cylinder head, oil pan, camshaft and adjust tappets. All Models - 6 cylinder With Drive-Master Add	9.4 ..... .8 .....
9-69	<b>TAPPET COVER - Remove and Install One.</b> All Models - Front - 6 cylinder 8 cylinder Rear - 6 cylinder 8 cylinder When replacing gasket on one cover Add	.3 ..... .3 ..... .4 ..... .5 ..... .1 .....
9-70	<b>VALVES - Grind valves, clean carbon, tune engine.</b> Includes removing and installing cylinder head, clean carbon, refacing valves and seats and adjusting tappets. All Models - 6 cylinder 8 cylinder With Drive-Master Add	7.6 ..... 8.3 ..... .8 .....
9-71	<b>VALVES - Remove and Install One valve.</b> Includes refacing valve and valve seat and checking tappet adjustment. All Models - 6 cylinder 8 cylinder With Drive-Master Add	3.0 ..... 2.8 ..... .8 .....
9-72	<b>VALVE GUIDES - Remove and Install</b> All when valves are out. All Models - 6 cylinder 8 cylinder Install one guide when valves are out	1.6 ..... 1.8 ..... .3 .....
9-73	<b>VALVE SPRING - Remove and Install All.</b> Includes removing and replacing cylinder head. All Models - 6 cylinder 8 cylinder With Drive-Master Add	4.2 ..... 3.8 ..... .8 .....
9-74	<b>VALVE SPRING - Remove and Install One spring.</b> Valve covers removed. All Models - 8 cylinder Each additional spring - 8 cylinder Add	.8 ..... .2 .....

OPERATION	DESCRIPTION	PRICE
<b>ENGINE—Continued</b>		
<b>VALVES AND TAPPETS—Continued</b>		
9-75	<b>VALVE SPRING - Remove and Install One spring.</b> Includes removing and installing cylinder head All Models - 6 cylinder With Drive-Master - 6 cylinder Each additional spring - 6 cylinder Add	<b>2.6 .....</b> <b>3.4 .....</b> <b>.3 .....</b>
<b>ENGINE COMBINATION OPERATION #1</b>		
9-76	<b>MINOR ENGINE TUNE-UP - Clean and regap spark plugs.</b> Clean and adjust distributor, points. Check flywheel timing. Adjust carburetor idle. Check ignition wiring. Clean fuel pump and carburetor strainer. Clean air cleaner. All Models With Drive-Master	<b>1.5 .....</b> <b>1.7 .....</b>
<b>ENGINE COMBINATION OPERATION #2</b>		
9-77	<b>MAJOR ENGINE TUNE-UP</b> Clean and regap spark plugs, replace if necessary. Check engine compression. Adjust distributor points. Check cap for cracks and condenser capacity (replace if necessary). Adjust tappets. Check engine timing at flywheel. Check, clean, and refill battery. Check coil capacity. Clean fuel pump sediment bowl and screen, check vacuum. Remove, clean, install, and adjust carburetor. Includes metering rod, float level, fast idle, anti-percolator, and climatic control. Lubricate throttle linkage. Check ignition wiring and battery connections, check battery gravity. Check generator charging rate and fan belt adjustment. Check fuel and oil line connections for leaks. Check torque on cylinder head and intake and exhaust manifold nuts. Clean air cleaner. All Models - 6 cylinder 8 cylinder With Drive-Master Add	<b>3.0 .....</b> <b>3.9 .....</b>
<b>ENGINE COMBINATION OPERATION #3</b>		
9-78	<b>GRIND VALVES AND TUNE ENGINE - Includes removing and replacing cylinder head, cleaning carbon, removing valves, refacing valves and seats and Operation #1, Item 9-76. Engine Tune-Up.</b> All Models - 6 cylinder 8 cylinder With Drive-Master Add	<b>7.6 .....</b> <b>8.3 .....</b> <b>.8 .....</b>

OPERATION	DESCRIPTION	PRICE
-----------	-------------	-------

**ENGINE—Continued**  
**ENGINE COMBINATION OPERATION #4**

9-79	<b>VALVES AND/OR VALVE SPRINGS, AND TAPPETS</b> - Includes removing and replacing cylinder head, cleaning carbon, removing valves, refacing valves and seats. Remove and install tappet assemblies and Engine Tune-Up Operation #1, Item 9-76.	
	All Models - 6 cylinder - includes removing and replacing camshaft	12.3 .....
	8 cylinder	8.8 .....
	With Drive-Master	.8 .....

**ENGINE COMBINATION OPERATION #5**

9-80	<b>VALVES AND/OR VALVE SPRINGS, PISTON RINGS, BEARINGS</b> - Remove and replace. Includes remove and replace cylinder head, oil pan, connecting rod and main bearings, align rods with piston. Clean carbon, reface valves and seats, remove and install piston rings, remove ridge from cylinder walls and tune engine Operation #1, Item 9-76.	
	All Models - 6 cylinder	14.2 .....
	8 cylinder	15.3 .....
	With Drive-Master      Add	.8 .....
	If necessary to hone all cylinders, add - 6 cylinder	4.7 .....
	8 cylinder	5.9 .....

**ENGINE COMBINATION OPERATION #6**

9-81	<b>VALVES AND/OR VALVE SPRINGS, PISTONS, PISTON RINGS, PINS, BEARINGS</b> - Includes remove and replace cylinder head, remove carbon, reface valves, and seats, remove and replace oil pan, connecting rod, main bearings, and piston pins, ream connecting rod bushings to fit pins, fit piston rings, remove ridge from cylinder walls and carbon from pistons, or fit new pistons, align rods, tune engine Operation #1, Item 9-76.	
	All Models - 6 cylinder	16.3 .....
	8 cylinder	17.6 .....
	With Drive-Master      Add	.8 .....
	If necessary to hone all cylinders, add - 6 cylinder	5.9 .....
	8 cylinder	5.9 .....

**BODY AND HARDWARE**

10-1	<b>DOOR ASSEMBLY - COMPLETE - Remove and Install. Front or rear.</b>	
	All Models	1.7 .....
10-2	<b>DOOR ASSEMBLY - SKELETON - Remove and Install. Front or rear. Does not include painting.</b>	
	All Models	2.5 .....
10-3	<b>DOOR FRONT WINDOW REGULATOR MECHANISM - Remove and Install.</b>	
	All Models	1.6 .....

OPERATION	DESCRIPTION	PRICE
<b>BODY AND HARDWARE—Continued</b>		
10-4	DOOR REAR WINDOW REGULATOR MECHANISM - Remove and Install. All Models	1.3 .....
10-5	DOOR VENTILATOR WING ASSEMBLY (CRANK TYPE) - Remove and Install. All Models	1.5 .....
10-6	DOOR VENTILATOR WING ASSEMBLY (FRICTION TYPE) - Remove and Install. All Models	1.2 .....
10-7	DOOR VENTILATOR WING REGULATOR HANDLE - Remove and Install. All Models	.2 .....
10-8	DOOR ARM REST - Remove and Install. All Models	.2 .....
10-9	DOOR HANDLE (INSIDE) - Remove and Install. All Models	.2 .....
10-10	DOOR LOCK MECHANISM - Remove and Install. All Models - Front Rear	1.7 .....
		1.2 .....
10-11	10-11 DOOR LOCK CYLINDER - FRONT - Remove and Install. All Models	.2 .....
10-12	DOOR CHECK - Remove and Install. All Models	1.3 .....
10-13	DOOR LOCK STRIKER PLATE - Remove, Install, Adjust. All Models	.3 .....
10-14	DOOR HINGE AND/OR HINGE PIN - UPPER AND LOWER FRONT AND LOWER REAR - Remove and Install. All Models	.6 .....
10-15	DOOR HINGE AND/OR HINGE PIN - UPPER REAR - Remove and Install. All Models	2.0 .....
10-16	DOOR OPENING WEATHERSTRIP - LOWER FRONT OR REAR - Remove and Install. All Models	.5 .....
10-17	DOOR WINDOW GARNISH MOULDING - FRONT OR REAR - Remove and Install. All Models	.3 .....
10-18	COWL VENTILATOR ASSEMBLY - Remove and Install. All Models	.6 .....
10-19	DOOR OPENING UPPER WEATHERSTRIP RIGHT AND LEFT HAND - Remove and Install. All Models	.4 .....
10-20	DOOR FRONT OPENING WEATHERSTRIP RIGHT HAND - Remove and Install. All Models	.3 .....
10-21	DOOR FRONT OPENING WEATHERSTRIP LEFT HAND - Remove and Install. All Models	.3 .....
10-22	REAR DOOR FRONT WEATHERSTRIP RIGHT AND LEFT HAND - Remove and Install. All Models	.4 .....

OPERATION	DESCRIPTION	PRICE
<b>BODY AND HARDWARE—Continued</b>		
10-23	REAR DOOR REAR WEATHERSTRIP RIGHT AND LEFT HAND - Remove and Install. All Models	.3 .....
10-24	DEFROSTER AIR STOP BLOCKS - Install. All Models	.5 .....
10-25	DOOR FRONT INSIDE PANEL LINER - RIGHT AND LEFT HAND - Remove and Install. All Models	.8 .....
10-26	REAR DOOR INSIDE PANEL LINER (REAR) - RIGHT OR LEFT - Install. All Models	.6 .....
<b>SEATS</b>		
10-27	SEAT ASSEMBLY AND TRACK - FRONT - Remove and Install. All Models	.8
10-28	SEAT ASSEMBLY (REAR) - 3 SECTIONS - Remove and Install. Commodore Series. All Models	.5
10-29	FRONT SEAT BACK - ROBE HANGER - Remove and Install. Commodore Series. All Models	.6
<b>WINDSHIELD</b>		
10-30	WINDSHIELD GLASS - Remove and Install. All Models Radio Equipped - One Side Both Sides All Models without Radio - One Side Both Sides	1.7 3.1 1.5 2.9
10-31	WINDSHIELD - Reseal to eliminate water leaks All Models	.5
10-32	WINDSHIELD GARNISH MOULDING - RIGHT OR LEFT HAND - Remove and Install. All Models	.3
10-33	WINDSHIELD WIPER ARMS - Adjust travel. All Models	.3
10-34	WINDSHIELD WIPER CONTROL ASSEMBLY - Remove and Install. All Models	.3
10-35	WINDSHIELD WIPER CABLE - Replace broken or frayed cable. All Models - One Cable	.6
<b>WINDOWS AND REGULATORS</b>		
10-36	DOOR GLASS - Remove and Install. All Models - Front Rear	1.8 1.3
10-37	QUARTER WINDOW GLASS (REAR) - Remove and Install One. All Models	.6

OPERATION	DESCRIPTION	PRICE
-----------	-------------	-------

**BODY AND HARDWARE**  
**WINDOWS AND REGULATORS—Continued**

10-38	REAR WINDOW GLASS AND/OR WEATHERSTRIP - Remove and Install. All Models	1.5 .....
10-39	WINDOW REGULATOR HANDLE AND/OR ESCUTCHEON PLATE. Remove and Install. All Models	.2 .....
10-40	REGULATOR ASSEMBLIES - (FREE UP) - Remove garnish moulding and pocket trim panels and oil mechanism. All Models	.5 .....
10-41	DOOR GLASS RUN - Remove and Install.	All Models - Rear Door 1.3 ..... Front Door 1.8 .....

**BODY TRIM**

10-42	DOOR WINDLACE - Remove and Install. All Models	1.5 .....
10-43	FRONT FLOOR MAT - Remove and Install. All Models	.2 .....
10-44	REAR FLOOR CARPET OR REAR COMPARTMENT MAT - Remove and Install. All Models	.4 .....
10-45	COWL KICK PANEL - Remove and Install. All Models	.4 .....
10-46	DOOR TRIM PANEL - FRONT OR REAR - Remove and Install. All Models	.8 .....
10-47	DOOR TRIM PANEL CHROME MOULDING - Remove and Install (any door). All Models	.3 .....
10-48	DOOR PILLAR POST TRIM - Remove and Install. All Models	.4 .....
10-49	HEADLINING - Remove and Install. All Models	7.5 .....
10-50	SUN VISOR - Remove and Install One. All Models	.2 .....

**REAR COMPARTMENT**

10-51	REAR COMPARTMENT DOOR - Remove and Install. All Models	1.0 .....
10-52	REAR COMPARTMENT BODY WEATHERSTRIP - Remove and Install. All Models	.4 .....
10-53	REAR COMPARTMENT DOOR NAME PLATE - Remove and Install. All Models	.3 .....
10-54	REAR COMPARTMENT DOOR LOCK ASSEMBLY - Remove and Install. All Models	.5 .....
10-55	REAR COMPARTMENT DOOR LOCK HANDLE AND/OR CYLINDER - Remove and Install. All Models	.3 .....



OPERATION	DESCRIPTION	PRICE
<b>BODY AND HARDWARE</b>		
<b>REAR COMPARTMENT—Continued</b>		
10-56	REAR COMPARTMENT DOOR LATCH AND HINGE - Remove and Install One All Models	.3 .....
10-57	REAR COMPARTMENT DOOR HINGE - Remove and Install. All Models	.5 .....
<b>INSTRUMENT PANELS AND INSTRUMENTS</b>		
10-58	INSTRUMENT PANEL (CENTER SECTION) - Remove and Install. All Models	.7 .....
10-59	INSTRUMENT PANEL (LEFT) - Remove and Replace. All Models	.3 .....
10-60	LOCKER BOX DOOR - Remove and Replace. All Models	.3 .....
10-61	LOCKER BOX - Remove and Install. All Models	.5 .....
10-62	LOCKER BOX LOCK AND LOCK CYLINDER - Remove and Replace. All Models	.3 .....
10-63	RHEOSTAT SWITCH - Remove and Replace. Commodore Models only	.2 .....
10-64	STARTER MOTOR SWITCH - Remove and Replace. All Models	.2 .....
10-65	HEADLIGHT SWITCH AND/OR CIRCUIT BREAKER - Remove and Install. All Models	.3 .....
10-66	SPEEDOMETER - Remove and Install. All Models	.5 .....
10-67	SPEEDOMETER LENS - Remove and Install. All Models	.6 .....
10-68	SPEEDOMETER CABLE OR CABLE HOUSING - Remove and Install. All Models	.6 .....
10-69	CLOCK - Remove and Install. All Models	.6 .....
10-70	WINDSHIELD WIPER CONTROL ASSEMBLY - Remove and Install. All Models	.3 .....
10-71	REMOVE AND REPLACE ANY INSTRUMENT PANEL LIGHT BULB. All Models	.2 .....
10-72	REMOVE AND REPLACE FUEL OR TEMPERATURE GAUGE. All Models	.7 .....
<b>COOLING</b>		
11-1	COOLING SYSTEM - Flush and refill. All Models	.5 .....
11-2	WATER JACKET COVER OR COVER GASKET - Remove and Install. All Models - 8 cylinder	1.4 .....

OPERATION	DESCRIPTION	PRICE
<b>COOLING—Continued</b>		
11-3	CYLINDER WATER JACKET PLUG - Remove and Install.	
	All Models - 6 cylinder	1.0 .....
	Front Plug	.5 .....
	Center Plug	.4 .....
	Rear Plug	.3 .....
11-4	RADIATOR CORE ASSEMBLY - Remove and Install.	All Models .8 .....
11-5	RADIATOR DRAIN COCK - Remove and Install.	All Models .3 .....
11-6	RADIATOR INLET HOSE - Remove and Install top hose only.	
	All Models	.2 .....
11-7	RADIATOR OUTLET HOSE - Remove and Install lower hose.	
	All Models	.3 .....
11-8	RADIATOR HOSE - WATER PUMP TO WATER JACKET - Remove and Install.	
	All Models	.2 .....
11-9	RADIATOR BY-PASS HOSE - Remove and Install.	All Models - 8 cylinder .4 .....
11-10	RADIATOR HOSE (ALL) - Remove and Install.	All Models .7 .....
11-11	THERMOSTAT, THERMOSTAT HOUSING OR HOUSING GASKET - Remove and Install.	
	All Models	.7 .....
<b>WATER PUMP AND FAN</b>		
11-12	WATER PUMP ASSEMBLY - Remove and Install.	All Models 1.0 .....
11-13	WATER PUMP - Overhaul - Remove pump, disassemble, replace worn parts, reassemble and install pump.	
	All Models	1.7 .....
11-14	FAN BLADES - Remove and Install.	All Models .2 .....
11-15	FAN BELT - Remove, Install And Adjust.	All Models .3 .....
11-16	FAN BELT - Adjust only.	All Models .2 .....
<b>EXHAUST SYSTEM</b>		
12-1	EXHAUST MANIFOLD AND/OR GASKETS - Remove and Install.	
	All Models - 8 cylinder	1.9 .....
	6 cylinder	2.2 .....
12-2	INTAKE MANIFOLD AND/OR GASKETS - Remove and Install.	
	All Models - 8 cylinder	2.5 .....
	6 cylinder	2.2 .....
12-3	EXHAUST HEAT CONTROL DAMPER VALVE ASSEMBLY - Remove and Install.	
	All Models - 8 cylinder	.3 .....
	6 cylinder	2.0 .....

OPERATION	DESCRIPTION	PRICE
-----------	-------------	-------

### EXHAUST SYSTEM—Continued

12-4	EXHAUST PIPE FLANGE AND/OR GASKET - Remove and Install.	All Models - 8 cylinder	.9 .....
12-5	EXHAUST PIPE FLANGE GASKET - Remove and Install.	All Models - 6 cylinder	.8 .....
12-6	EXHAUST PIPE (FRONT) - Remove and Install.	All Models - 8 cylinder 6 cylinder	2.0 ..... 1.2 .....
12-7	EXHAUST PIPE (REAR) - Remove and Install.	All Models	.8 .....
12-8	EXHAUST PIPE FRONT CLAMP - Remove and Install.	All Models	.5 .....
12-9	EXHAUST MUFFLER - Remove and Install.	All Models	.7 .....
12-10	MUFFLER CLAMP SUPPORT BRACKET ASSEMBLY (FRONT) - Remove and Install.	All Models	.5 .....
12-11	MUFFLER CLAMP (REAR) - Remove and Install.	All Models	.3 .....

### ELECTRICAL

13-1	BATTERY - Remove and Install.	All Models	.2 .....
13-2	BATTERY COVER - Remove and Install.	All Models	.2 .....
13-3	BATTERY DRIP TRAY - Remove and Install.	All Models	.2 .....
13-4	BATTERY - FRAME TO BATTERY SUPPORT - Remove and Install.	All Models	.6 .....
13-5	BATTERY CABLE - Remove and Install battery to starter cable.	All Models	.2 .....
13-6	BATTERY GROUND STRAP - Remove and Install battery to battery support.	All Models	.2 .....
13-7	BATTERY CABLE AND GROUND STRAP - Remove and Install both.	All Models	.4 .....
13-8	BATTERY TERMINALS - Clean. Disconnect at battery, clean terminal, coat with vaseline and install	All Models	.4 .....

### GENERATOR

13-9	GENERATOR - Remove and Install.	All Models	.4 .....
13-10	GENERATOR - Check charging rate.	All Models	.3 .....

OPERATION	DESCRIPTION	PRICE
-----------	-------------	-------

**ELECTRICAL—Continued**  
**GENERATOR—Continued**

13-11	<b>GENERATOR - Overhaul</b> - Remove, clean and repair. Replace any new parts necessary and test. Install generator and adjust charging rate. (Does not include turning commutator or under-cutting mica on old armature).	All Models	1.6 .....
13-12	<b>GENERATOR COMMUTATOR</b> - Clean commutator and brushes and adjust charging rate.	All Models	.6 .....
13-13	<b>GENERATOR BRACKET - Remove and Install</b> bracket only.	All Models	.5 .....
13-14	<b>GENERATOR VOLTAGE REGULATOR - Remove and Install.</b>	All Models	.4 .....

**HORN**

13-15	<b>HORN ASSEMBLY - Remove and Install.</b>	All Models - One Two	.3 .....
			.5 .....
13-16	<b>HORN ASSEMBLY - Adjust</b> - Clean contacts and adjust without removing horn from car.	All Models	.4 .....
13-17	<b>HORN RING - Remove and Install.</b>	All Models	.2 .....
13-18	<b>HORN BUTTON WIRE - Remove and Install.</b>	All Models	.3 .....
13-19	<b>HORN RELAY - Remove and Install.</b>	All Models	.2 .....

**IGNITION**

13-20	<b>COIL - Remove and Install.</b>	All Models	.2 .....
13-21	<b>IGNITION SWITCH ASSEMBLY AND/OR LOCK - Remove and Install.</b>	All Models	.5 .....
13-22	<b>DISTRIBUTOR ASSEMBLY - Remove and Install.</b> Includes check flywheel timing.	All Models	.4 .....
		With Drive-Master	.5 .....
13-23	<b>DISTRIBUTOR ASSEMBLY - Clean or Replace and Adjust</b> contact points. Set timing with flywheel marks.	All Models	.6 .....
		With Drive-Master	.7 .....
13-24	<b>DISTRIBUTOR OCTANE SELECTOR - Remove and Install.</b>	All Models	.4 .....
		With Distributor removed	.2 .....
13-25	<b>DISTRIBUTOR CAP - Remove and Install.</b>	All Models	.3 .....
13-26	<b>DISTRIBUTOR CONDENSER - Remove and Install.</b>	All Models - 8 cylinder	.3 .....
		6 cylinder	.3 .....
		With Drive-Master - 6 cylinder	.4 .....

OPERATION	DESCRIPTION	PRICE
-----------	-------------	-------

**ELECTRICAL—Continued**

**IGNITION—Continued**

13-27	SPARK PLUGS - Remove and Install One.	All Models	.2 .....
13-28	SPARK PLUGS - Remove and Install All.	All Models - 6 cylinder 8 cylinder	.3 ..... .4 .....
13-29	SPARK PLUGS - Remove, clean, adjust gap, and Install.	All Models - 6 cylinder 8 cylinder	.4 ..... .5 .....
13-30	SPARK PLUG WIRES - Remove and Install All high tension wires.	All Models - 6 cylinder 8 cylinder	.4 ..... .5 .....

**LIGHTS**

13-31	DOME LIGHT - Remove and Install lens or bulb.	All Models	.2 .....
13-32	INSTRUMENT BULB OR OIL INDICATOR OR GENERATOR SIGNAL LIGHT BULB - Remove and Install.	All Models	.2 .....
13-33	HEADLAMPS - Adjust	All Models	.4 .....
13-34	HEADLAMP ASSEMBLY - Remove and Install One and adjust both.	All Models	.8 .....
13-35	HEADLAMP SEALED BEAM UNIT OR HEADLAMP DIMMER SWITCH OR FENDER LAMPS - Remove and Install One.	All Models	.3 .....
13-36	FENDER LAMP BULB OR LENS OR STOP AND TAIL LAMP - Remove and Install One.	All Models	.3 .....
13-37	STOP AND TAIL LAMP LENS OR CREST - Remove and Install One.	All Models	.4 .....
13-38	LICENSE PLATE LAMP LENS OR BULB - Remove and Install.	All Models	.2 .....
13-39	STOP LIGHT SWITCH - Remove and Install. If necessary to bleed lines	All Models	.3 ..... Add .5 .....
13-40	LIGHT CONTROL SWITCH AND/OR CIRCUIT BREAKER - Remove and Install.	All Models	.5 .....
13-41	LIGHT CONTROL SWITCH BUTTON - Remove and Install.	All Models	.2 .....

**STARTER**

13-42	STARTER BUTTON SWITCH - Remove and Install.	All Models	.2 .....
-------	---	------------	----------

OPERATION	DESCRIPTION	PRICE
-----------	-------------	-------

**ELECTRICAL—Continued**

**STARTER—Continued**

13-43	STARTER ASSEMBLY - Remove and Install.	All Models	.5 .....
		With Drive-Master	1.9 .....
13-44	STARTER BENDIX DRIVE - Remove and Install with starter removed from car.	All Models	.3 .....
13-45	STARTER ASSEMBLY - Overhaul - Remove, clean, replace any parts necessary and install on car.	All Models	1.9 .....
		With Drive-Master	3.3 .....
13-46	STARTER SOLENOID - Remove and Install.	All Models	.4 .....
		With Drive-Master	.5 .....

**ACCESSORIES**

14-1	BACK-UP LIGHT - Install.	All Models - One	.7 .....
		Two	1.0 .....
14-2	BATTERY FILLER (AUTOMATIC) - Install.	All Models	.5 .....
14-3	CIGARETTE LIGHTER - Install.	All Models	.7 .....
14-4	CIGARETTE LIGHTER ELEMENT - Remove and Install.	All Models	.2 .....
14-5	CLOCKS - Remove and Install.	All Models	.6 .....
14-6	DIRECTION INDICATOR - Install.	All Models	4.2 .....
14-7	FOG LIGHTS (TWO) - Install.	All Models	1.0 .....
14-8	GAS TANK LOCKING CAP (ELECTRIC) - Install.	All Models	.5 .....
14-9	OIL FILTER - Install.	All Models - 6 cylinder	.5 .....
		8 cylinder	1.3 .....
		With Drive-Master - 6 cylinder	1.5 .....
14-10	OUTSIDE REAR VIEW MIRROR - Install.	All Models	.5 .....
14-11	RADIO ANTENNA - Install.	All Models	.9 .....
14-12	RADIO ANTENNA - Remove and Install.	All Models	.4 .....
14-13	RADIO ASSEMBLY - Install.	All Models	1.4 .....
14-14	RADIO DIAL LIGHT BULB - Replace.	All Models	1.0 .....
14-15	RADIO RECEIVER - Remove and Install.	All Models	1.0 .....
14-16	RADIO SPEAKER ASSEMBLY - Install.	All Models	.3 .....

OPERATION	DESCRIPTION	PRICE
-----------	-------------	-------

### ACCESSORIES—Continued

14-17	7 SEAT COVERS - Install. Commodore Series - Broughams, Coupes Sedans Super Series - Broughams, Coupes Sedans	2.2 ..... 2.0 ..... 1.8 ..... 1.6 .....
14-18	SPOT LIGHT - Install. All Models	1.0 .....
14-19	WEATHER CONTROL UNIT - Install. All Models	2.3 .....
14-20	WINDSHIELD WASHER - Install. All Models	1.0 .....

### SHEET METAL

#### FENDERS

15-1	FRONT FENDER - Remove and Install Right or Left. All Models	3.3 .....
15-2	FRONT FENDER - NAME PLATE - Remove and Install Right or Left. All Models	.2 .....
15-3	FRONT FENDER - ORNAMENT - Remove and Install. All Models	.3 .....
15-4	FRONT FENDER - LOWER MOULDING Right or Left. Remove and Install. Includes removing and replacing moulding retainers. All Models	.3 .....
15-5	FRONT FENDER - SIDE DUST SHIELD ASSEMBLY Right or Left. Remove and Install. All Models	.7 .....
15-6	FRONT FENDER - SIDE DUST SHIELD EXTENSION Right or Left. Remove and Install. All Models	.4 .....
15-7	FRONT FENDER - STONE GUARD - Remove and Install. Right or Left. All Models	.6 .....
15-8	REAR FENDER - Remove and Install. Right or Left; All Models	2.3 .....
15-9	REAR FENDER - MOULDING Right or Left. Remove and Install. Includes removing retainers and screws. All Models	.4 .....
5-10	REAR FENDER - GAS FILLER DOOR ASSEMBLY - Remove and Install. Includes removing door and hinge. All Models	.2 .....
15-11	REAR FENDER - FILLER DOOR SPRING (Both). Remove and Install. All Models	.2 .....
15-12	REAR FENDER - GAS FILLER GROMMET - Remove and Install. All Models	.2 .....

#### HOOD

15-13	HOOD - Remove and Install. All Models	.4 .....
15-14	HOOD-LOCK UPPER - Remove and Install. All Models	.2 .....

OPERATION	DESCRIPTION	PRICE
-----------	-------------	-------

**SHEET METAL—Continued**

**HOOD—Continued**

15-15	HOOD-LOCK LOWER - Remove and Install.	All Models	.2
15-16	HOOD - WIRE AND KNOB ASSEMBLY - Remove and Install.	All Models	.2
15-17	HOOD-PROP - Remove and Install right or left.	All Models	.2
15-18	HOOD-PROP SPRING - Remove and Install right or left.	All Models	.3
15-19	HOOD - CREST ASSEMBLY - Remove and Install.	All Models	.4
15-20	HOOD - CREST LENS - Remove and Install.	All Models	.5
15-21	HOOD - CREST SOCKET AND WIRE - Remove and Install.	All Models	.2
15-22	HOOD - LOUVER, RIGHT OR LEFT - Remove and Install.	All Models	.2
15-23	HOOD - ORNAMENT - Remove and Install.	All Models	.2
15-24	HOOD - FRONT BUMPERS - Remove and Install.	All Models - one three	.1 .2
15-25	HOOD - HINGE ASSEMBLY - Right or Left - Remove and Install.	All Models	.9
15-26	HOOD - HINGE RETURN SPRING - Right or Left - Remove and Install.	All Models	.9

**RADIATOR GRILLE**

15-27	FENDER TIE PANEL AND HOOD LOCK LOWER SUPPORT PANEL - Remove and Install.	All Models	.6
15-28	RADIATOR GRILLE CENTER BAR - UPPER - Remove and Install.	All Models	.3
15-29	RADIATOR GRILLE BAFFLE - UPPER Right or Left - Remove and Install.	All Models	.2
15-30	RADIATOR GRILLE BAFFLE - CENTER - LOWER Right or Left - Remove and Install.	All Models	.2
15-31	RADIATOR GRILLE BAFFLE MOULDING - UPPER CENTER - LOWER Right or Left - Remove and Install.	All Models - one six	.2 .5
15-32	RADIATOR GRILLE SIDE SUPPORT PANEL - Right or Left Hand - Remove and Install.	All Models	1.1



OPERATION	DESCRIPTION	PRICE
-----------	-------------	-------

**SHEET METAL—Continued**  
**RADIATOR GRILLE—Continued**

15-33	RADIATOR FRONT SPLASH GUARD AND MOULDING -Remove and Install. All Models	.9
15-34	RADIATOR GRILLE FRONT SPLASH APRON GUARD MOULDING - Remove and Install. All Models	.4
15-35	FRONT SPLASH APRON - Right or Left Hand. Remove and Install. All Models	1.1

**ROCKER PANELS AND MOULDINGS**

15-36	ROCKER PANEL FRONT - Right or Left Hand - Remove and Install. All Models	.7
15-37	ROCKER PANEL REAR - Right or Left Hand - Remove and Install. All Models	.3
15-38	ROCKER PANEL EXTENSION - Front or Rear - Right or Left Hand - Remove and Install. All Models	.3
15-39	DOOR SCUFF PLATE - Front or Rear - Right or Left Hand - Remove and Install. All Models	.2
15-40	ROCKER PANEL EXTENSION MOULDING - Front or Rear - Right or Left Hand - Remove and Install. All Models	.2
15-41	ROCKER PANEL FRONT - UPPER MOULDING - Right or Left Hand. Remove and Install. All Models	1.0
15-42	ROCKER PANEL FRONT - LOWER MOULDING - Right or Left Hand. Remove and Install. All Models	.4
15-43	REAR ROCKER PANEL - UPPER MOULDING - Right or Left Hand. Remove and Install. All Models	.2
15-44	REAR ROCKER PANEL - LOWER MOULDING - Right or Left Hand. Remove and Install. All Models	.2
15-45	REAR FENDER LOWER MOULDING - Right or Left Hand. Remove and Install. Includes removing retainers and screws. All Models	.4
15-46	FRONT FENDER LOWER MOULDING - Right or Left. Remove and Install. All Models	.3
15-47	REAR WHEEL COVER AND ROD ASSEMBLY - Right or Left. Remove and Install. All Models	.1
15-48	REAR WHEEL COVER UPPER MOULDING - Right or Left. Remove and Install. All Models	.4
15-49	REAR WHEEL COVER LOWER MOULDING - Right or Left. Remove and Install. All Models	.3

OPERATION	DESCRIPTION	PRICE
-----------	-------------	-------

### BUMPERS

16-1	FRONT BUMPER ASSEMBLY - Remove and Install	All Models	.8
16-2	FRONT BUMPER IMPACT BAR - Remove and Install	All Models	.6
16-3	FRONT BUMPER TO FRAME BRACKET - Remove and Install	All Models	.6
16-4	FRONT BUMPER LICENSE PLATE GUARD - Remove and Install	All Models	.2
16-5	REAR BUMPER ASSEMBLY - Remove and Install	All Models	.6
16-6	REAR BUMPER BAR WINGS - Remove and Install (One)	All Models	.3
16-7	REAR BUMPER STONE GUARD - Remove and Install	All Models	.3

### SHOCK ABSORBERS AND STABILIZERS

17-1	FRONT SHOCK ABSORBERS - Remove and Install.	All Models - One Both	.4 .7
17-2	REAR SHOCK ABSORBERS - Remove and Install.	All Models - One Both	.5 .9
17-3	SHOCK ABSORBER RUBBER BUSHINGS - Remove and Install absorber.	in one shock All Models - One front One Rear	.4 .5
17-4	FRONT STABILIZER BAR - Remove and Install.	All Models	.7
17-5	STABILIZER - MOUNTING BRACKET - Remove and Install.	All Models - One side Both sides	.3 .5
17-6	STABILIZER CONNECTOR AND BUSHINGS - Remove and Install.	All Models - One side Both sides	.3 .5
17-7	REAR STABILIZER - Remove and Install.	All Models	.8
17-8	REAR STABILIZER BUSHINGS - Remove and Install.	All Models	.8

### SPRINGS

18-1	FRONT COIL SPRING - Remove and Install.	All Models - One Two	1.0 1.8
18-2	REAR SPRING - Remove and Install.	All Models - One Two	1.2 2.1

OPERATION	DESCRIPTION	PRICE
-----------	-------------	-------

### SPRINGS—Continued

18-3	REAR SPRING COVER (Metal) - Remove and Install on spring complete. All Models - One Spring Both Springs	2.0 3.6
18-4	REAR SPRING LEAF - Remove and Install one or more leaves. Includes removing spring from car. All Models - One Spring Both Springs.	2.2 3.8
18-5	REAR SPRING SHACKLE OR BUSHING - Remove and Install "U" bolt shackle and threaded bushing. All Models - One Both	.4 .8
18-6	REAR SPRING FRONT BUSHING OR PIN - Remove and Install. All Models - One Both	.4 .8
18-7	REAR SPRING MOUNTING CLIPS - Remove and Install. All Models - One Spring Both Springs.	.6 1.1
18-8	REAR SPRING MOUNTING CLIPS (Tighten all "U" bolts). All Models	.2

### SPRING COMBINATION JOBS

18-9	SPRING SHACKLE BUSHINGS AND SPRING CLIPS - Tighten Both. All Models	.6
18-10	REMOVE BOTH SPRINGS, Install New Shackle Bushings, Shackle "U" Bolts, Lubricate. All Models	3.5
18-11	REAR SPRING REMOVAL AND LUBRICATION - Includes Remove and Install spring covers and springs, cleaning springs, spread leaves, and lubricate. All Models-Two Springs	4.1

### FUEL SYSTEM

19-1	CARBURETOR ASSEMBLY - Remove and Install, Disassembly and assembly, clean and overhaul, replace necessary parts, adjust and test. All Models	2.4
19-2	CARBURETOR ASSEMBLY - Overhaul Complete, carburetor removed from engine. All Models	2.0
19-3	CARBURETOR ASSEMBLY - Remove and Install. All Models	.4
19-4	CARBURETOR ASSEMBLY - Adjust with vacuum gauge. All Models	.3
19-5	CARBURETOR FLOAT OR NEEDLE VALVE - Remove and Install, adjust float level. All Models	.5

OPERATION	DESCRIPTION	PRICE
-----------	-------------	-------

### FUEL SYSTEM—Continued

19-6	CARBURETOR AUTOMATIC CHOKE - Remove and Install, clean and overhaul. All Models	.7
19-7	CARBURETOR AIR CLEANER - Remove, Install and Refill. All Models - Oil Bath Dry	.4 .2
19-8	CARBURETOR TO EXHAUST MANIFOLD HEAT TUBE - Remove and Install. All Models - 8 cylinder	.3

### FUEL PUMP

19-9	FUEL PUMP ASSEMBLY AND/OR GASKET - Remove and Install. All Models	1.4
19-10	COMBINATION FUEL AND VACUUM PUMP ASSEMBLY - Remove, Overhaul, Clean and replace any necessary parts, assemble. All Models	2.0
19-11	FUEL PUMP FILTER BOWL AND SCREEN - Remove, Clean and Install. All Models	.4
19-12	FUEL PUMP FLEXIBLE HOSE - Remove and Replace. All Models	.4
19-13	GASOLINE LINES BLOW OUT AND Inspect for Leaks. All Models	.6
19-14	GASOLINE STEEL LINE FROM FUEL PUMP FLEXIBLE HOSE TO GASOLINE TANK. Remove and Install. All Models	.7
19-15	GASOLINE LINE FUEL PUMP TO CARBURETOR - Remove and Install. All Models	.2
19-16	GASOLINE GAUGE DASH UNIT - Remove and Install. All Models	.7
19-17	GASOLINE TANK GAUGE - Remove and Install. All Models	.6
19-18	GASOLINE TANK - Remove, Clean and Install. All Models	1.8

### LUBRICATION

20-1	LUBRICATION - Complete. All Models	.9
20-2	NEW CAR PRE-DELIVERY AND INSPECTION. All Models - 6 cylinder 8 cylinder With Drive-Master adjustment Add	5.2 5.5 .9
20-3	NEW CAR 1,000 MILE. Includes inspection and adjustment. All Models With Drive-Master adjustment Add	2.4 .9

OPERATION	DESCRIPTION	PRICE
-----------	-------------	-------

### LUBRICATION—Continued

20-4	<b>NEW CAR 2,000 MILE.</b> Includes inspection and adjustment.	
	All Models - 6 cylinder	4.8
	8 cylinder	5.1
	With Drive-Master adjustment Add	.9
20-5	<b>NEW CAR 5,000 MILE.</b> Includes inspection and adjustment.	
	All Models - 6 cylinder	4.1
	8 cylinder	4.8
	With Drive-Master adjustment Add	.9
20-6	<b>CLUTCH - Drain, Flush and Refill.</b>	All Models .4
20-7	<b>DIFFERENTIAL - Drain, Flush and Refill.</b>	All Models .4
20-8	<b>FRONT WHEELS - Clean Bearings, Repack, Replace and Adjust.</b>	All Models .7
20-9	<b>REAR SPRINGS - Lubricate.</b>	All Models - One spring .3 Both Springs .5
20-10	<b>STEERING GEAR - Lubricate.</b>	All Models .3
20-11	<b>TRANSMISSION - Drain, Wash and Refill.</b>	All Models .4
20-12	<b>VACUMOTIVE DRIVE POWER CYLINDER - Fill one ounce shock absorber fluid.</b>	All Models .3

### STEERING GEAR

21-1	<b>STEERING GEAR ASSEMBLY - Remove and Install</b> complete gear assembly.	
	All Models	3.9
	With Drive-Master	4.2
21-2	<b>STEERING GEAR - Adjust</b> throughout. Disconnect drag link, adjust end play of sector shaft. Lubricate gear, adjust front wheel toe-in, set gear on high spot in straight ahead position.	
	All Models	1.6
21-3	<b>STEERING GEAR HOUSING - Remove and Install.</b> Add to Operation 21-1.	
	All Models	.7
21-4	<b>STEERING GEAR HOUSING - Tighten</b> to frame.	All Models .3
21-5	<b>STEERING GEAR - Overhaul.</b> Disassembly, renew all parts necessary and adjust.	
	Add to Operation #21-1. All Models	1.2
21-6	<b>STEERING COLUMN SUPPORT BRACKET - Remove and Install.</b>	
	All Models - Lower Half	.2
	Upper Half	.6
21-7	<b>STEERING JACKET TUBE AND BEARING ASSEMBLY - Remove and Install.</b>	
	All Models	1.2

OPERATION	DESCRIPTION	PRICE
-----------	-------------	-------

### STEERING GEAR—Continued

21-8	STEERING JACKET TUBE BEARING ASSEMBLY - Remove and Install All Models	.8
21-9	STEERING GEAR SECTOR SHAFT - Remove and Install. All Models With Drive-Master (includes adjustment)	1.3 2.7
21-10	STEERING GEAR SECTOR SHAFT OIL SEAL - Remove and Install. All Models With Drive-Master (includes adjustment)	1.5 2.9
21-11	STEERING GEAR SECTOR SHAFT - Adjust end play. All Models	.6
21-12	STEERING GEAR WORM AND TUBE ASSEMBLY - Remove and Install. Includes removing and installing steering gear and adjustment. All Models With Drive-Master With Steering gear removed	5.1 5.4 1.2
21-13	STEERING WHEEL - Remove and Install. All Models	.5
21-14	STEERING WHEEL - Tighten wheel on column only. All Models	.3
21-15	STEERING WHEEL HORN BUTTON RING - Remove and Install All Models	.2

### VACUMOTIVE DRIVE

22-1	VACUMOTIVE DRIVE - Install on cars not equipped. All Models	3.8
22-2	VACUMOTIVE DRIVE - Adjust and lubricate. All Models	.6
22-3	POWER CYLINDER ASSEMBLY - Remove and Install. Includes adjusting. All Models	1.8
22-4	POWER CYLINDER - Overhaul- Includes removing, installing and adjusting. All Models	2.6
22-5	MOUNTING BRACKET - Remove and Install. All Models	.8
22-6	SOLENOID AND/OR GASKET - Remove and Install. All Models	.3
22-7	BELL CRANK - Remove and Install. All Models	.7
22-8	VALVE LEVER OR COMPENSATOR LEVER - Remove and Install. All Models	.5
22-9	VALVE LEVER CAM - Remove and Install. All Models	.2
22-10	VALVE LEVER CAM PIVOT - Remove and Install. All	.4

OPERATION	DESCRIPTION	PRICE
<b>VACUMOTIVE DRIVE—Continued</b>		
22-11	BELL CRANK TO COUPLING LEVER ROD AND/OR PLAY LINK - Remove, Install and adjust. All Models	.9
22-12	COMPENSATOR TRIP LEVER SPRING - Remove and Install. All Models	.4
22-13	PISTON ROD BOOT - Remove and Install. All Models	.6
22-14	PISTON ROD END AND PIN AND/OR LINK - Remove and Install. All Models	.3
22-15	ACCELERATOR CROSS SHAFT AND LEVER ASSEMBLY - Remove, Install and adjust. All Models	.8
22-16	VALVE LEVER CAM THREADED SLEEVE ROD ASSEMBLY - Remove, Install and adjust. All Models	.3
22-17	INSTRUMENT PANEL SWITCH - Remove and Install. All Models	.3
22-18	SHIFT RAIL SWITCH - Remove and Install. All Models	.3
22-19	GOVERNOR SWITCH AND/OR PINION - Remove and Install. All Models	.4
22-20	ACCELERATOR SWITCH - Remove, Install and check adjustment. All Models	.4

### DRIVE-MASTER

23-1	DRIVE-MASTER ADJUSTMENT - Includes adjusting: 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 anchor 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
23-2	DRIVE-MASTER CHECK-UP with test lamp and test harness. All Models	1.5
23-3	POWER UNIT ASSEMBLY COMPLETE WITH SOLENOID VALVE UNIT - Remove, Install and Adjust. All Models	1.0
23-4	POWER UNIT SOLENOID VALVES AND TRANSFER DIAPHRAGM - Remove and Install. All Models	1.3
23-5	TRANSFER DIAPHRAGM - Replace	.7

OPERATION	DESCRIPTION	PRICE
<b>DRIVE-MASTER—Continued</b>		
23-6	POWER UNIT MOUNTING BRACKET - Remove and Install. Includes removing and replacing all units attached to bracket, connecting rods and linkage and adjustment after assembly. All Models	2.6
23-7	POWER UNIT TRANSFER DIAPHRAGM ENGAGING ROD AND/OR ROD END AND SLEEVE. Includes adjustment. Remove and Install. All Models	.3
23-8	TRANSFER DIAPHRAGM ENGAGING ROD RUBBER BOOT - Remove and Install. All Models	.4
23-9	POWER UNIT SHIFT STRAP - Remove and Install. All Models If necessary to replace bushing Add	.5 .1
23-10	POWER UNIT CYLINDER BOOT - Remove and Install. All Models	.6
23-11	VACUUM LINE OR ELBOW - Remove and Install One. All Models	.3
23-12	SHIFT SHAFT - Remove and Install. All Models	.5
23-13	SHIFT SHAFT TRANSFER KEY AND/OR PIN - Remove and Install. All Models	.4
23-14	SHIFT SHAFT TRANSFER KEY HUB AND/OR BUSHING - Remove and Install. All Models	.7
23-15	SHIFT SHAFT POWER LEVER STOP AND LOCK SCREW - Remove and Install. All Models	.4
23-16	SHIFT SHAFT (HAND SHIFT) LEVER - Remove and Install. All Models If necessary to replace bushing Add	.6 .2
23-17	SHIFT SHAFT (POWER SHIFT) LEVER - Remove and Install. All Models If necessary to replace bushing Add	.7 .2
23-18	SHIFT SHAFT LEVER DETENT BALL AND/OR SPRING - Remove and Install. All Models	1.0
23-19	DRIVE-MASTER TO REMOTE CONTROL TUBE BELLCRANK ROD ASSEMBLY AND/OR BALL JOINT - Remove and Install. All Models	.2
23-20	DRIVE-MASTER-SWITCH ASSEMBLY - Remove, Install and Adjust. All Models	1.8
23-21	SHIFT SWITCH OPERATING STRAP - Remove and Install. All Models	.2
23-22	SELECTOR SWITCH OPERATING ROD OR TRANSFER SWITCH OPERATING ROD - Remove and Install. All Models	.3



---

OPERATION	DESCRIPTION	PRICE
<b>DRIVE-MASTER—Continued</b>		
23-23	NEUTRAL AND LIMIT SWITCH ROD ASSEMBLY - Remove and Install and Adjust. All Models	.4
23-24	CLUTCH SWITCH OPERATING ROD OR DRIVE-MASTER TRANSMISSION SHIFT ROD - Remove and Install. All Models	.3
23-25	THROTTLE LOCK DIAPHRAGM CYLINDER - Remove and Install. All Models	.3
23-26	THROTTLE LOCK DIAPHRAGM - Remove and Install. All Models	.4
23-27	THROTTLE LOCK SOLENOID - Remove and Install. All Models	.2
23-28	SHIFT RAIL SWITCH OR ACCELERATOR SWITCH OR GOVERNOR SWITCH AND/OR PINION - Remove and Install. All Models	.4
23-29	INSTRUMENT PANEL SWITCH - Remove and Install. All Models	.3

---

---

**CONVERSION TABLE**
**HOURLY RATE**

TIME	HOURLY RATE						
	\$ 1.50	\$ 1.75	\$ 2.00	\$ 2.25	\$ 2.50	\$ 2.75	\$ 3.00
.							
.1	.15	.18	.20	.23	.25	.28	.30
.2	.30	.35	.40	.45	.50	.55	.60
.3	.45	.53	.60	.68	.75	.75	.90
.4	.60	.70	.80	.90	1.00	1.10	1.20
.5	.75	.88	1.00	1.13	1.25	1.38	1.50
.6	.90	1.05	1.20	1.35	1.50	1.65	1.80
.7	1.05	1.23	1.40	1.58	1.75	1.93	2.10
.8	1.20	1.40	1.60	1.80	2.00	2.20	2.40
.9	1.35	1.58	1.80	2.03	2.25	2.48	2.70
1.0	1.50	1.75	2.00	2.25	2.50	2.75	3.00
1.1	1.65	1.93	2.20	2.48	2.75	3.03	3.30
1.2	1.80	2.10	2.40	2.70	3.00	3.30	3.60
1.3	1.95	2.28	2.60	2.93	3.25	3.58	3.90
1.4	2.10	2.45	2.80	3.15	3.50	3.85	4.20
1.5	2.25	2.63	3.00	3.38	3.75	4.13	4.50
1.6	2.40	2.80	3.20	3.60	4.00	4.40	4.80
1.7	2.55	2.98	3.40	3.83	4.25	4.68	5.10
1.8	2.70	3.15	3.60	4.05	4.50	4.95	5.40
1.9	2.85	3.33	3.80	4.28	4.75	5.23	5.70
2.0	3.00	3.50	4.00	4.50	5.00	5.50	6.00
2.1	3.15	3.68	4.20	4.73	5.25	5.78	6.30
2.2	3.30	3.85	4.40	4.95	5.50	6.05	6.60
2.3	3.45	4.03	4.60	5.18	5.75	6.23	6.90
2.4	3.60	4.20	4.80	5.40	6.00	6.60	7.20
2.5	3.75	4.38	5.00	5.63	6.25	6.88	7.50
2.6	3.90	4.55	5.20	5.85	6.50	7.15	7.80
2.7	4.05	4.73	5.40	6.08	6.75	7.43	8.10
2.8	4.20	4.90	5.60	6.30	7.00	7.70	8.40
2.9	4.35	5.08	5.80	6.53	7.25	7.98	8.70
3.0	4.50	5.25	6.00	6.75	7.50	8.25	9.00
3.1	4.65	5.43	6.20	6.98	7.75	8.53	9.30
3.2	4.80	5.60	6.40	7.20	8.00	8.80	9.60
3.3	4.95	5.78	6.60	7.43	8.25	9.08	9.90
3.4	5.10	5.95	6.80	7.65	8.50	9.35	10.20
3.5	5.25	6.13	7.00	7.88	8.75	9.63	10.50
3.6	5.40	6.30	7.20	8.10	9.00	9.90	10.80
3.7	5.55	6.48	7.40	8.33	9.25	10.18	11.10
3.8	5.70	6.65	7.60	8.55	9.50	10.45	11.40
3.9	5.85	6.83	7.80	8.78	9.75	10.73	11.70
4.0	6.00	7.00	8.00	9.00	10.00	11.00	12.00
4.1	6.15	7.18	8.20	9.23	10.25	11.28	12.30
4.2	6.30	7.35	8.40	9.45	10.50	11.55	12.60
4.3	6.45	7.53	8.60	9.68	10.75	11.83	12.90
4.4	6.60	7.70	8.80	9.90	11.00	12.10	13.20
4.5	6.75	7.88	9.00	10.13	11.25	12.33	13.50
4.6	6.90	8.05	9.20	10.35	11.50	12.65	13.80
4.7	7.05	8.23	9.40	10.58	11.75	12.93	14.10
4.8	7.20	8.40	9.60	10.80	12.00	13.20	14.40
4.9	7.35	8.58	9.80	11.03	12.25	13.48	14.70

---

## CONVERSION TABLE—Continued

## HOURLY RATE

TIME	HOURLY RATE						
.	\$ 1.50	\$ 1.75	\$ 2.00	\$ 2.25	\$ 2.50	\$ 2.75	\$ 3.00
5.0	7.50	8.75	10.00	11.25	12.50	13.75	15.00
5.1	7.65	8.93	10.20	11.48	12.75	14.03	15.30
5.2	7.80	9.10	10.40	11.70	13.00	14.30	15.60
5.3	7.95	9.28	10.60	11.93	13.25	14.58	15.90
5.4	8.10	9.45	10.80	12.15	13.50	14.85	16.20
5.5	8.25	9.63	11.00	12.38	13.75	15.13	16.50
5.6	8.40	9.80	11.20	12.60	14.00	15.40	16.80
5.7	8.55	9.98	11.40	12.83	14.25	15.68	17.10
5.8	8.70	10.15	11.60	13.05	14.50	15.95	17.40
5.9	8.85	10.33	11.80	13.28	14.75	16.23	17.70
6.0	9.00	10.50	12.00	13.50	15.00	16.50	18.00
6.1	9.15	10.68	12.20	13.73	15.25	16.78	18.30
6.2	9.30	10.85	12.40	13.95	15.50	17.05	18.60
6.3	9.45	11.03	12.60	14.18	15.75	17.33	18.90
6.4	9.60	11.20	12.80	14.40	16.00	17.60	19.20
6.5	9.75	11.38	13.00	14.63	16.25	17.88	19.50
6.6	9.90	11.55	13.20	14.85	16.50	18.15	19.80
6.7	10.05	11.73	13.40	15.08	16.75	18.43	20.10
6.8	10.20	11.90	13.60	15.30	17.00	18.70	20.40
6.9	10.35	12.08	13.80	15.53	17.25	18.98	20.70
7.0	10.50	12.25	14.00	15.75	17.50	19.25	21.00
7.1	10.65	12.43	14.20	15.98	17.75	19.53	21.30
7.2	10.80	12.60	14.40	16.20	18.00	19.80	21.60
7.3	10.95	12.78	14.60	16.44	18.25	20.08	21.90
7.4	11.10	12.95	14.80	16.65	18.50	20.35	22.20
7.5	11.25	13.13	15.00	16.88	18.75	20.63	22.50
7.6	11.40	13.30	15.20	17.10	19.00	20.90	22.80
7.7	11.55	13.48	15.40	17.33	19.25	21.18	23.10
7.8	11.70	13.65	15.60	17.55	19.50	21.45	23.40
7.9	11.85	13.83	15.80	17.78	19.75	21.73	23.70
8.0	12.00	14.00	16.00	18.00	20.00	22.00	24.00
8.1	12.15	14.18	16.20	18.23	20.25	22.28	24.30
8.2	12.30	14.35	16.40	18.45	20.50	22.55	24.60
8.3	12.45	14.53	16.60	18.68	20.75	22.83	24.90
8.4	12.60	14.70	16.80	18.90	21.00	23.10	25.20
8.5	12.75	14.88	17.00	19.13	21.25	23.38	25.50
8.6	12.90	15.05	17.20	19.35	21.50	23.65	25.80
8.7	13.05	15.23	17.40	19.58	21.75	23.93	26.10
8.8	13.20	15.40	17.60	19.80	22.00	24.20	26.40
8.9	13.35	15.58	17.80	20.03	22.25	24.48	26.70
9.0	13.50	15.75	18.00	20.25	22.50	24.75	27.00
9.1	13.65	15.93	18.20	20.48	22.75	25.03	27.30
9.2	13.80	16.10	18.40	20.70	23.00	25.30	27.60
9.3	13.95	16.28	18.60	20.93	23.25	25.58	27.90
9.4	14.10	16.45	18.80	21.15	23.50	25.85	28.20
9.5	14.25	16.63	19.00	21.38	23.75	26.13	28.50
9.6	14.40	16.80	19.20	21.60	24.00	26.40	28.80
9.7	14.55	16.98	19.40	21.83	24.25	26.68	29.10
9.8	14.70	17.15	19.60	22.05	24.50	26.95	29.40
9.9	14.85	17.33	19.80	22.28	24.75	27.23	29.70
9.9	14.85	17.33	19.80	22.28	24.75	27.23	29.70
10.0	15.00	17.50	20.00	22.50	25.00	27.50	30.00

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

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.....





