

HUDSON *JET*

FLAT RATE MANUAL

HUDSON MOTOR CAR COMPANY

DETROIT 15, MICHIGAN, U. S. A.

INTRODUCTION

This edition of the Hudson Flat Rate Manual covers service operations applicable to the 1C-2C Hudson Jet. It is to be used as a guide by the Distributor and Dealer in determining his time allocations in establishing fair and competitive service charges to Hudson owners.

The time established has been based on performance of the complete operation, with Hudson Essential Service Tools, modern equipment and Hudson Engineered Parts and mechanics of average ability.

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

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

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

INSTRUCTIONS

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

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

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

The word "install" is opposite of removal and applies to putting back the used parts 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 expedite pricing and quoting, a labor conversion table is shown at the rear of the book and is computed at rates of \$2.75 to \$5.00 per hour labor charge.

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

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

MODEL DESIGNATION

The new Hudson Jets are produced in two models, the Jet and Super Jet and are identified as follows:

Model No.	Model Name
1C	Jet
2C	Super Jet

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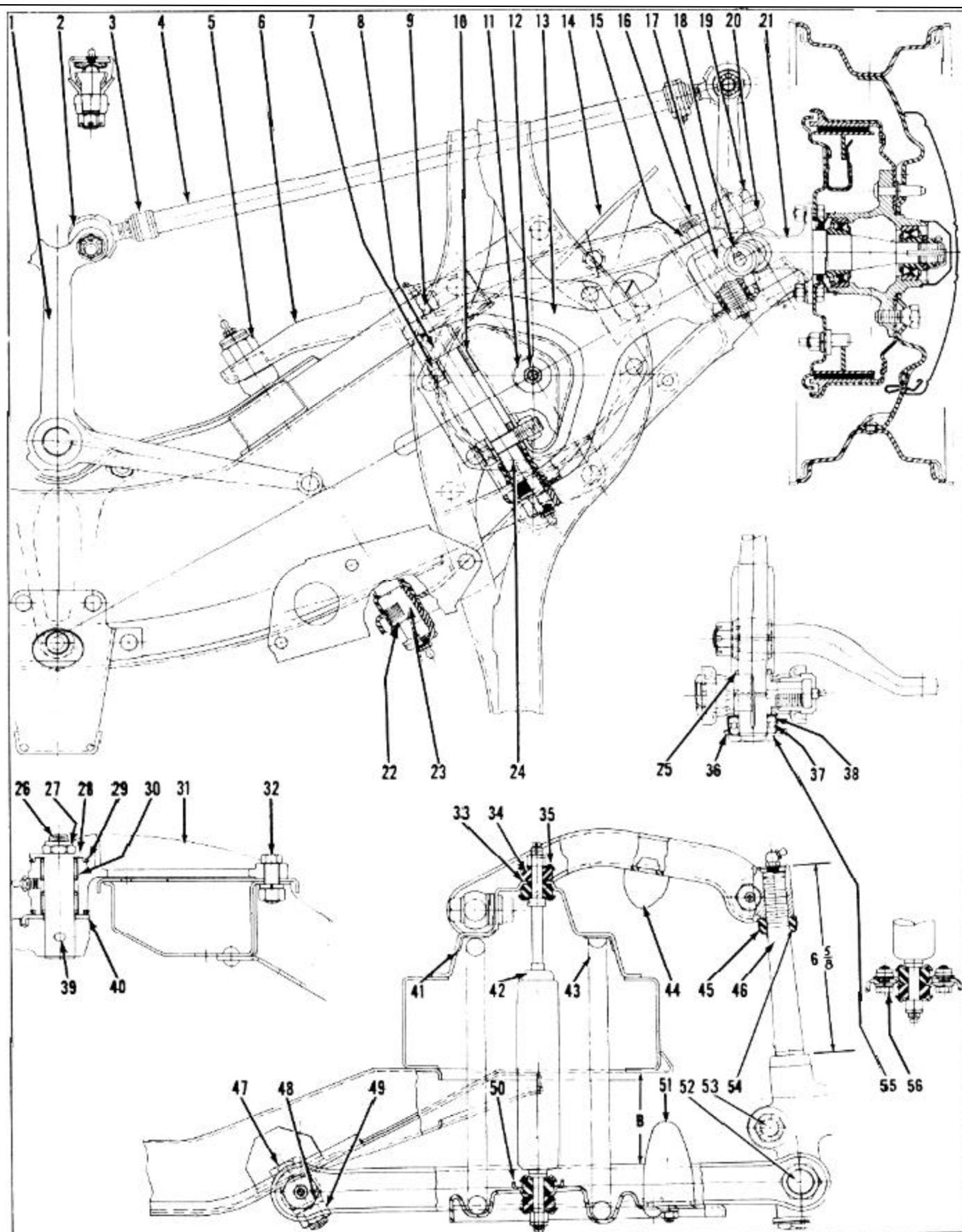
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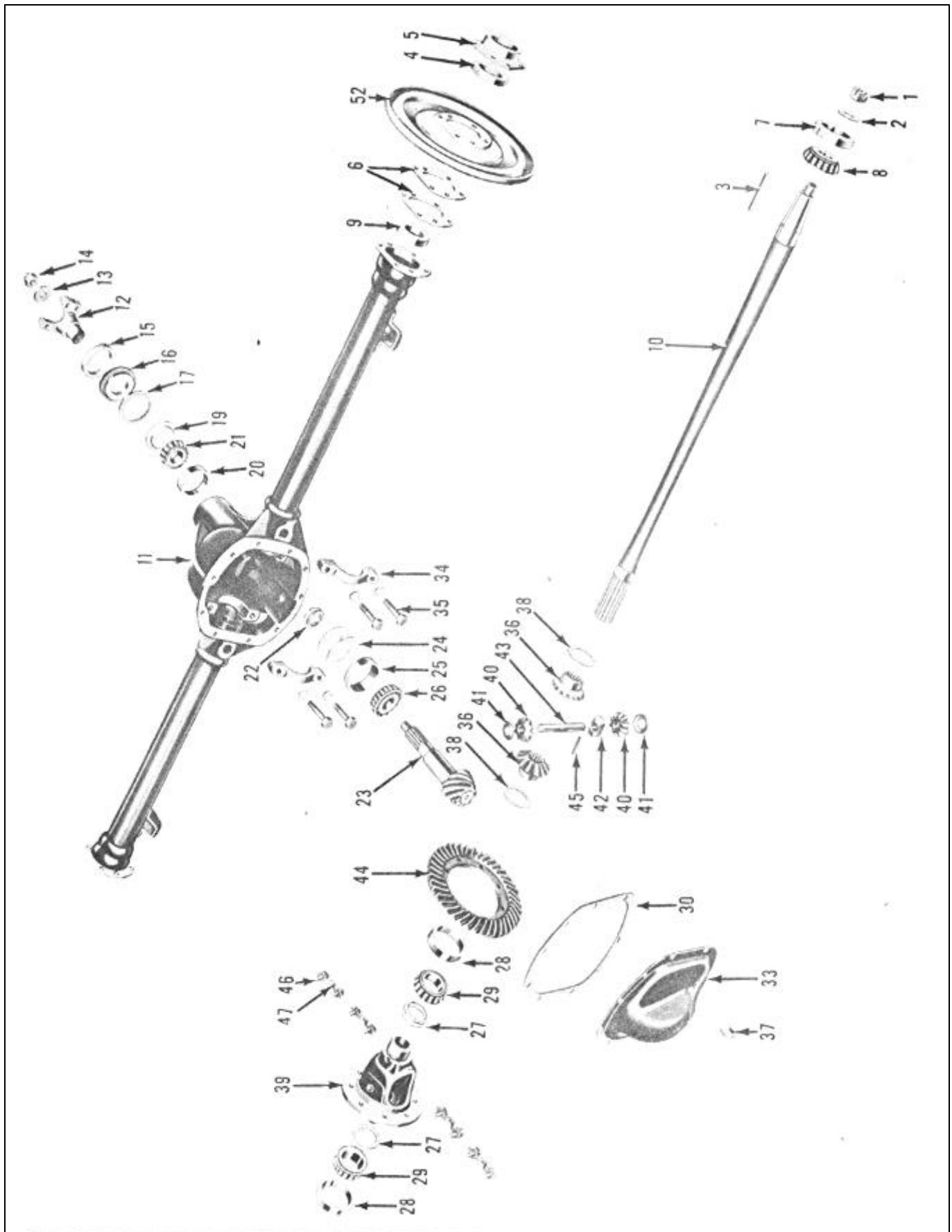
OPERATION	DESCRIPTION	TIME	PRICE
FRONT SUSPENSION			
1.1	FRONT WHEEL SUSPENSION OVERHAUL — (Both Sides) Rebush and replace any parts necessary — Includes adjusting caster, camber and toe-in	6.0	_____
LOWER SUPPORT ARMS			
1.2	LOWER SUPPORT ARM — Remove and Install. One Side	1.5	_____
	Both Sides	2.9	_____
1.3	LOWER SUPPORT ARM TRUNNION BUSHINGS — Remove and Install. One Side	.4	_____
	Both Sides	.7	_____
1.4	LOWER SUPPORT ARM (INNER) PIVOT BUSHINGS — Remove and Install. One Side	.4	_____
	Both Sides	.7	_____
1.5	LOWER SUPPORT ARM TRUNNION AND BUSHINGS — Remove and Install. One Side	2.0	_____
	Both Sides	3.9	_____
UPPER SUPPORT ARMS			
1.6	UPPER SUPPORT ARM — Remove and Install. Left Side	1.5	_____
	Right Side	1.3	_____
1.7	UPPER SUPPORT ARM (INNER) PIVOT BUSHINGS — Remove and Install — Includes remove wheel assembly and fender side pan. Left Side	1.2	_____
	Right Side	1.0	_____
1.8	SUPPORT ARM RUBBER BUMPERS — Remove and Install. One Side	.3	_____
	Both Sides	.3	_____
		.5	_____
1.9	UPPER SUPPORT STEERING SPINDLE PIVOT AND BOLT — Remove and Install. One Side	.7	_____
	Both Sides	1.3	_____
STEERING SPINDLE AND WHEEL BEARINGS			
1-10	STEERING SPINDLE — Remove and Install. One Side	1.5	_____
	Both Sides	2.9	_____
1-11	STEERING SPINDLE PIVOT PIN — Remove and Install. One Side	1.5	_____
	Both Sides	2.9	_____
1-12	STEERING SPINDLE PIVOT PIN THRUST BEARING — Remove and Install. One Side	1.5	_____
	Both Sides	2.9	_____

**FRONT SUSPENSION**

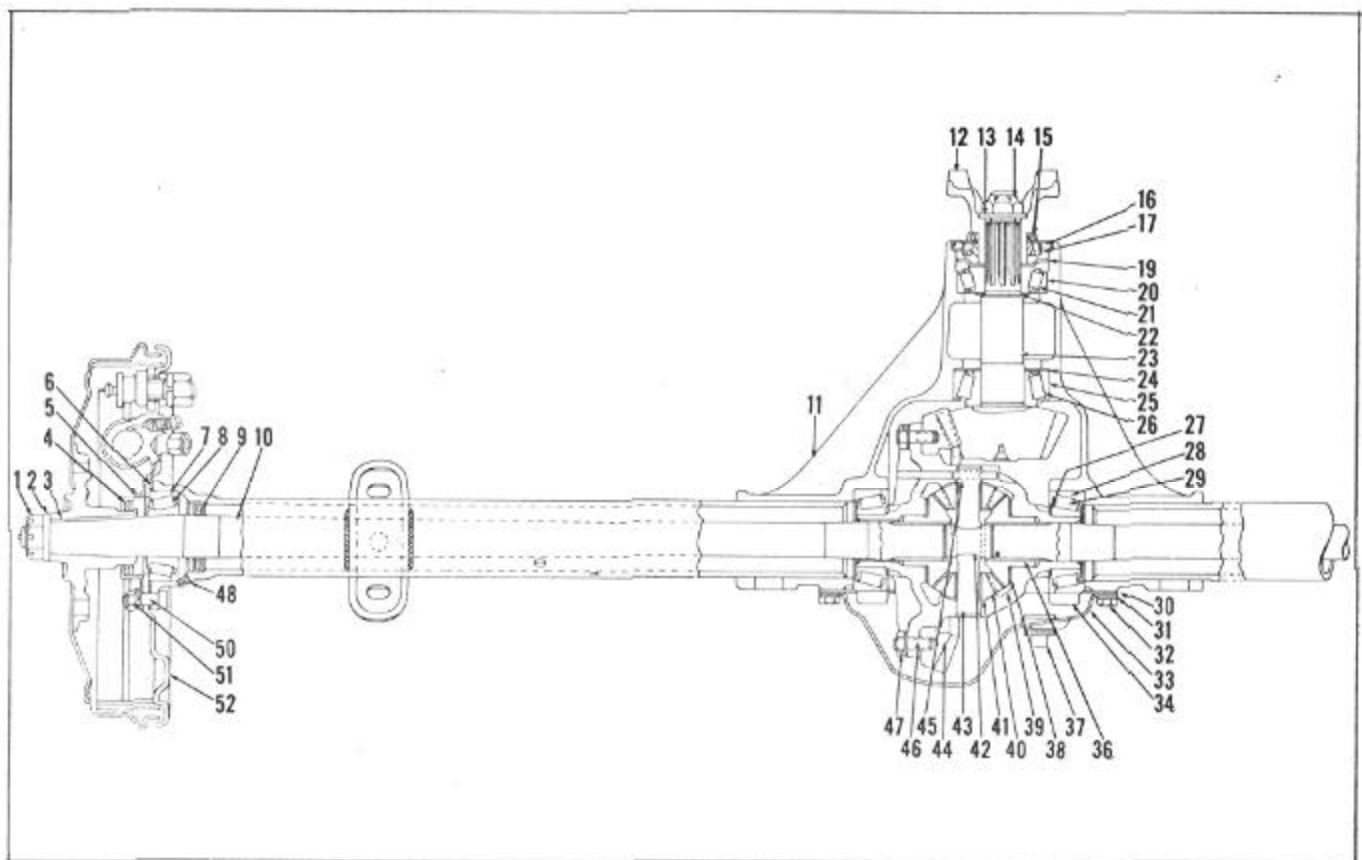
OPERATION	DESCRIPTION	TIME	PRICE
FRONT SUSPENSION — Continued			
LEGEND			
1. Center steering arm	29. Center steering arm seal		
2. Tie rod end	30. Needle bearing		
3. Tie rod clamp	31. Center steering arm bracket		
4. Tie rod	32. Center steering arm to frame nut		
5. Bushing lower support arm inner	33. Shock absorber cup washer		
6. Lower support arm	34. Shock absorber cushion		
7. Upper support pivot bolt	35. Shock absorber retainer		
8. Upper support arm bushing seal	36. Dust cover seal		
9. Upper support arm bushing rear	37. Pivot pin dust cover seal retainer washer		
10. Upper support arm shim	38. Pivot pin lower thrust bearing		
11. Shock absorber retainer	39. Center steering arm taper pin		
12. Shock absorber palnut	40. Center steering upper spacer		
13. Upper support arm assembly	41. Silencer		
14. Steering spindle stop	42. Front shock absorber		
15. Upper support arm pivot bolt nut	43. Coil spring		
16. Upper support arm pivot bolt	44. Bumper upper support arm		
17. Upper support arm steering spindle pivot	45. Steering spindle upper pivot seal retainer		
18. Grease fitting	46. Steering spindle pivot pin		
19. Bushing-lower support arm outer	47. Lower arm pivot to frame bolt		
20. Steering spindle lower seal	48. Lower arm pivot to frame lock washer		
21. Steering spindle	49. Lower arm pivot to frame nut		
22. Lower support arm bushing-inner	50. Shock absorber anchor plate		
23. Lower support arm pivot	51. Bumper lower support arm		
24. Upper support arm pivot at frame	52. Lower support arm trunnion bushing		
25. Pivot pin grease lower seal	53. Outer steering arm		
26. Center steering arm pivot	54. Steering spindle pivot pin grease seal upper		
27. Center steering arm lock nut	55. Dust cover seal		
28. Center steering arm spacer lower	56. Anchor plate bolt		
1-13	WHEEL BEARINGS — Remove, Clean, Repack, Install and Adjust.	.6	_____
1-14	WHEEL HUB AND DRUM ASSEMBLY — Remove and Install. Includes cleaning, repacking and adjusting wheel bearings.		
	One Side	.5	_____
	Both Sides	.9	_____
1-15	WHEEL BEARINGS — Adjust Only. Both Sides	.3	_____
SPRINGS, SHOCK ABSORBERS AND STABILIZER			
1-16	COIL SPRINGS AND/OR SILENCER — Remove and Install.	1.0	_____
	One Side	1.9	_____
	Both Sides		
1-17	SHOCK ABSORBER AND/OR RUBBER GROMMETS — Remove and Install.		
	One Side	.5	_____
	Both Sides	.9	_____

OPERATION	DESCRIPTION	TIME	PRICE
FRONT SUSPENSION—Continued			
1-18	SHOCK ABSORBER ANCHOR PLATE — Remove and Install.		
	One Side	.2	_____
	Both Sides	.3	_____
1-19	LATERAL STABILIZER — Remove and Install.	.7	_____
1-20	LATERAL STABILIZER MOUNTING BRACKETS TO FRAME — Remove and Install.	.5	_____
1-21	LATERAL STABILIZER CONNECTORS AND / OR BUSHINGS — Remove and Install.		
	One Side	.3	_____
	Both Sides	.5	_____
STEERING ARMS AND TIE RODS			
1-22	CENTER STEERING ARM AND PIVOT ASSEMBLY — Remove and Install.	1.0	_____
1-23	CENTER STEERING ARM PIVOT — Remove and Install.	1.8	_____
1-24	CENTER STEERING ARM BEARINGS — Remove and Install	.8	_____
1-25	CENTER STEERING ARM PIVOT BRACKET, SPACERS OR SEALS — Remove and Install.	.5	_____
1-26	TIE ROD ASSEMBLY — Remove and Install. Includes adjust toe-in.	.4	_____
	One Side		
1-27	TIE ROD ASSEMBLIES — Remove and Install. Includes adjust toe-in.	.8	_____
	Both Sides		
1-28	TIE ROD CLAMP — Remove and Install.	.3	_____
	One Side	.6	_____
	Both Sides		
1-29	TIE ROD END (INNER) — Remove and Install.	.5	_____
	One Side	.9	_____
	Both Sides		
		.4	_____
1-30	TIE ROD END (OUTER) RIGHT OR LEFT — Remove and Install.	.7	_____
1-31	STEERING ARM — RIGHT OR LEFT — Remove and Install	.4	_____
1-32	DRAG LINK ASSEMBLY — Remove and Install.		
ALIGNMENT			
1-33	CASTER, CAMBER AND TOE-IN — Adjust.	1.3	_____
1-34	CASTER, CAMBER AND TOE-IN — Check.	.5	_____
1-35	TOE-IN — Adjust Only	.6	_____

OPERATION	DESCRIPTION	TIME	PRICE
REAR AXLE			
2-1	AXLE ASSEMBLY (COMPLETE) — Remove and Install. Includes bleeding brakes.	3.7	_____
2-2	AXLE ASSEMBLY — Overhaul. Includes remove and install and complete disassembly and reassembly of rear axle and bleeding brakes.	7.8	_____
2-3	AXLE HOUSING ASSEMBLY — Remove and Install. Includes disassembly, inspection, reassembly and bleeding brakes.	7.0	_____
2-4	DIFFERENTIAL ASSEMBLY — Overhaul. When Removed From Axle. Includes removing and installing drive gear and replacing case, gears, pinions, shaft, thrust washers or spacer block.	.8	_____
2-5	DIFFERENTIAL SIDE BEARINGS — Remove and Install (Axle Housing in Car). Includes bleeding brakes.	2.8	_____
2-6	DRIVE GEAR AND PINION — Remove and Install. Includes replacing with matched set of drive gear and pinion, checking pinion depth and bleeding brakes.	6.8	_____
2-7	DRIVE GEAR AND PINION — Adjust. Includes remove and install axle assembly.	6.3	_____
2-8	DRIVE PINION OIL SEAL — Remove and Install.	1.1	_____
2-9	AXLE HOUSING COVER OR GASKET — Remove and Install.	.4	_____
2-10	REAR AXLE COMPANION FLANGE — Remove and Install.	.6	_____
2-11	DIFFERENTIAL ASSEMBLY — Remove and Install. (Axle Housing in Car). Includes bleeding brakes.	2.3	_____
2-12	DRIVE PINION BEARING CUP AND CONE FRONT OR REAR — Remove and Install. Includes checking pinion depth and bleeding brakes.	6.3	_____
2-13	AXLE SHAFT OR BEARING — Remove and Install. Includes bleeding brakes One	1.7	_____
2-14	AXLE SHAFT END PLAY — Adjust.	1.0	_____
2-15	AXLE SHAFT OIL SEAL (ONE OUTER) — Remove and Install.	.7	_____
2-16	AXLE SHAFT WHEEL BEARING — Remove and Install. Includes bleeding brakes. One Two	1.7 3.3	_____ _____
2-17	AXLE SHAFT OIL SEAL (INNER) — Remove and Install. Includes bleeding brakes. One Two	1.5 2.9	_____ _____



REAR AXLE — EXPLOSION



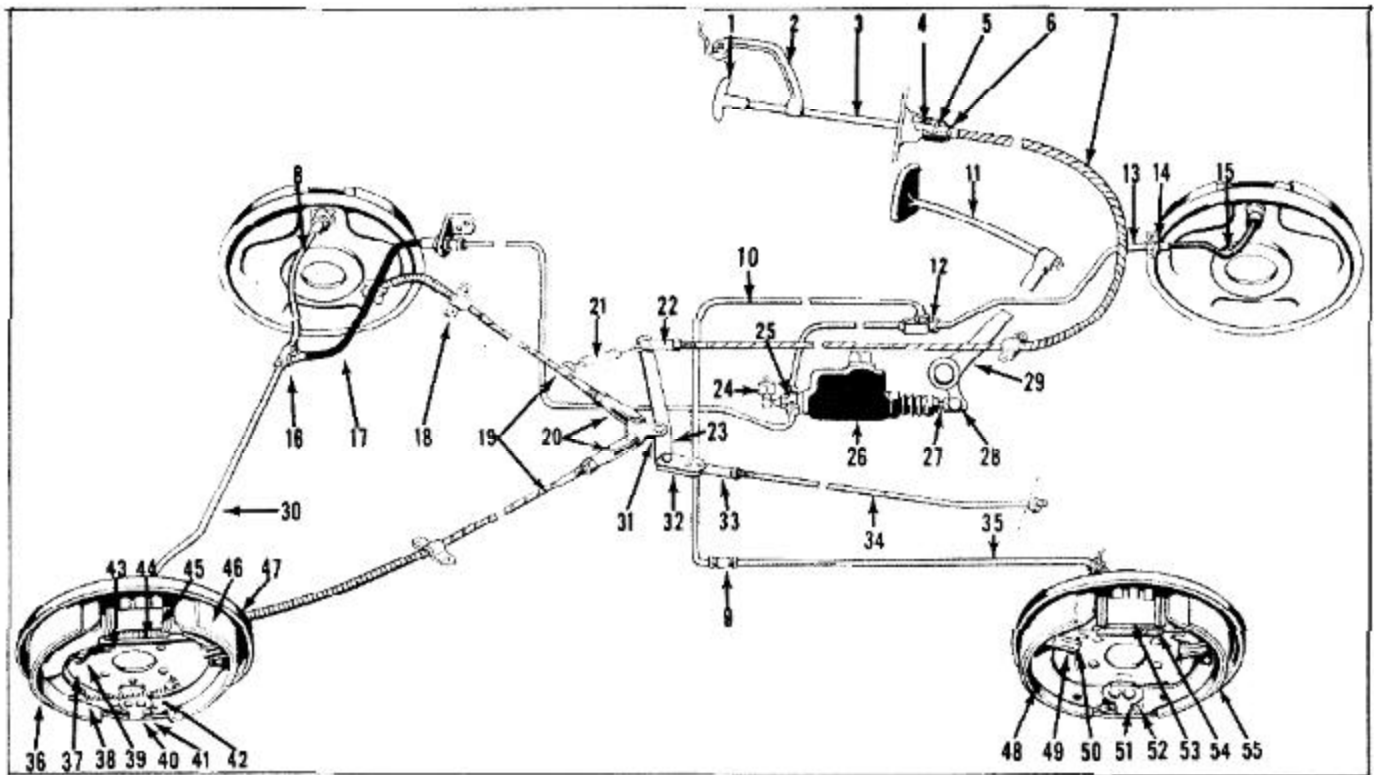
REAR AXLE—CROSS SECTION

LEGEND

- | | |
|---|--|
| 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 cup | 33. Differential housing cover |
| 8. Wheel bearing cone | 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 |
| 19. Drive pinion oil slinger | 44. Drive gear |
| 20. Drive pinion front bearing cup | 45. Differential pinion shaft locating pin |
| 21. Drive pinion front bearing cone | 46. Drive gear bolts |
| 22. Drive pinion front bearing shims | 47. Drive gear bolt lock |
| 23. Drive pinion | 48. Wheel bearing grease hole plug |
| 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
WHEELS AND TIRES			
3-1	WHEELS AND TIRES — Remove and Install — (Five). — Rotate to conserve tire life.	.6	_____
3-2	TIRE — Remove and Install.		
	One	.4	_____
	Two	.7	_____
3-3	WHEELS AND TIRES — Remove and Install — (Five). — Rotate and balance two front wheel assemblies.	1.4	_____
3-4	FRONT WHEELS — Align. Includes caster, camber, toe-in and setting steering gear on high point.	1.6	_____
3-5	FRONT WHEEL BEARINGS — Adjust Both.	.3	_____
3-6	FRONT WHEEL BEARING CUPS — Remove and Install. Includes cleaning, repacking and adjusting.		
	One Wheel	.6	_____
	Both Wheels	1.0	_____
3-7	FRONT WHEEL BEARING GREASE RETAINER — Remove and Install.		
	One Wheel	.3	_____
	Two Wheels	.6	_____
3-8	FRONT WHEEL BEARING GREASE RETAINER — Remove and Install — (When wheel is removed).	.2	_____
3-9	WHEELS — Balance. Includes remove and install and balance statically and dynamically.		
	Both Front Wheels	.9	_____
3-10	HUB AND BRAKE DRUM (FRONT) — Remove and Install. Includes clean and repack and adjust bearings.		
	One Wheel	.6	_____
	Both Wheels	1.0	_____
3-11	HUB AND BRAKE DRUM (REAR) — Remove and Install.		
	One Wheel	.4	_____
	Both Wheels	.7	_____
3-12	HUB KEY (REAR) — Remove and Install.		
	One	.4	_____
	Two	.7	_____

OPERATION	DESCRIPTION	TIME	PRICE
BRAKES			
4-1	BRAKES — Inspection. Includes remove and install wheels and inspect condition of lining and any other parts. Note — if a reline or adjustment is ordered cancel this operation charge.		
	One Wheel	.3	_____
	Four Wheels	.9	_____
4-2	BRAKES — Minor Adjustment. Setting cam adjustment only and adding fluid to master cylinder.	.6	_____
4-3	BRAKE SYSTEM — Bleed.	.5	_____
4-4	BRAKE SYSTEM — Flush. Includes flush with alcohol and refill system with brake fluid and bleed lines.	.9	_____
4-5	BRAKES — Reline and Adjust. Includes removing drums, cleaning backing plates, lubriplate shoe contact points, install new lining, repack and adjust front wheel bearings and refill master cylinder.		
	Two Front Wheels	1.6	_____
	All Four Wheels	3.5	_____
4-6	BRAKE BACKING PLATE — Remove and Install. Includes transferring all necessary parts, adjust brakes and bleed lines.		
	One Front	1.4	_____
	Two Front	2.5	_____
	One Rear	1.7	_____
	Two Rear	3.1	_____
4-7	BRAKE DRUMS — Remove and Install.		
	One Front	.5	_____
	One Rear	.4	_____
4-8	BRAKE DRUMS — Reface — (When Removed from Car).		
	One	.4	_____
	Two	.7	_____
	Four	1.3	_____
WHEEL CYLINDERS			
4-9	WHEEL CYLINDER — Remove and Install. Includes bleeding lines.		
	One Front	.9	_____
	Two Front	1.5	_____
	One Rear	1.0	_____
	Two Rear	1.6	_____
	All Four	3.1	_____
4-10	WHEEL CYLINDER — Overhaul — (On Car). Includes hone, replace necessary parts, and bleed lines.		
	One Front	.8	_____
	Two Front	1.4	_____
	One Rear	.9	_____
	Two Rear	1.6	_____
	All Four	3.0	_____

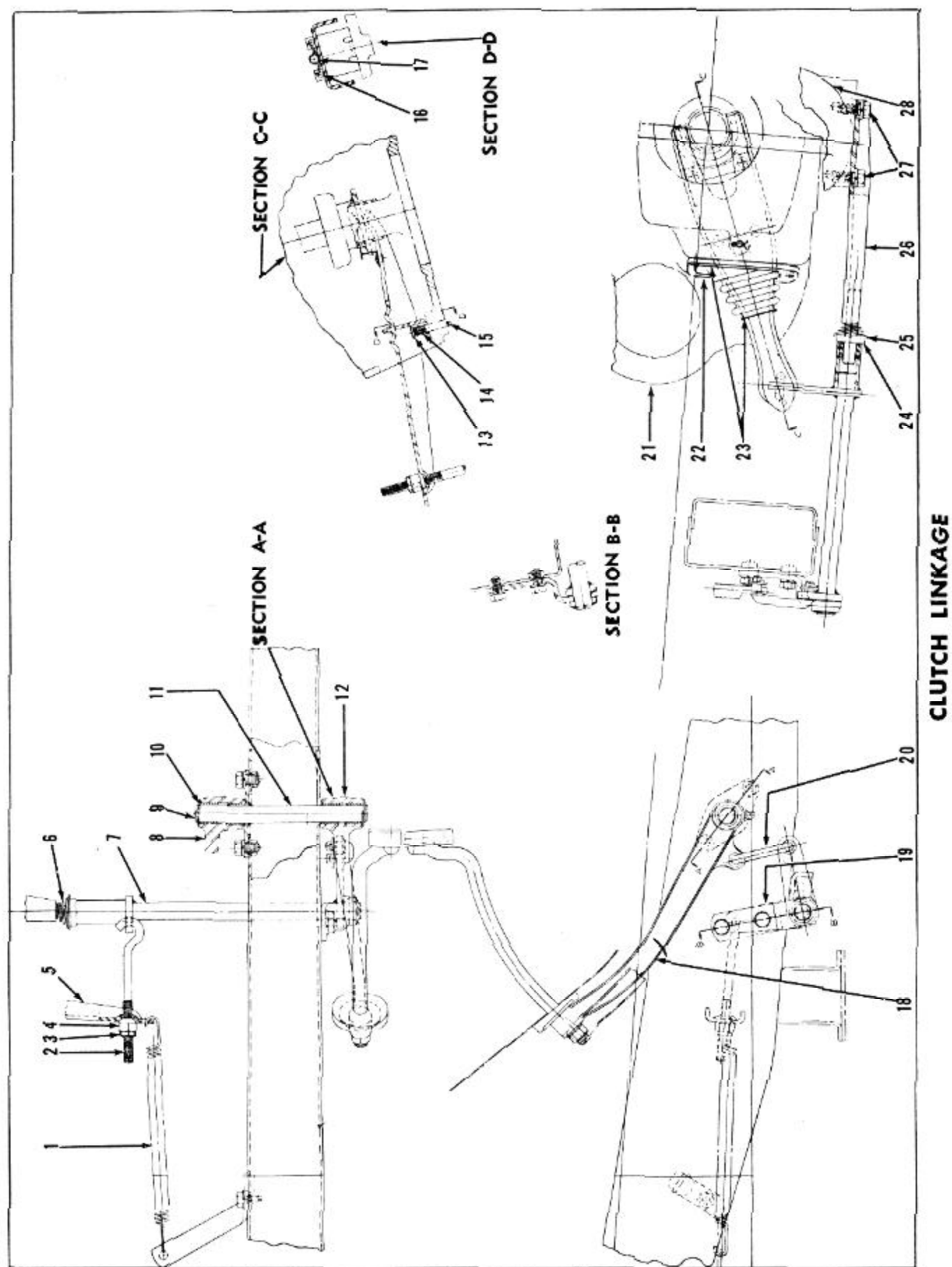


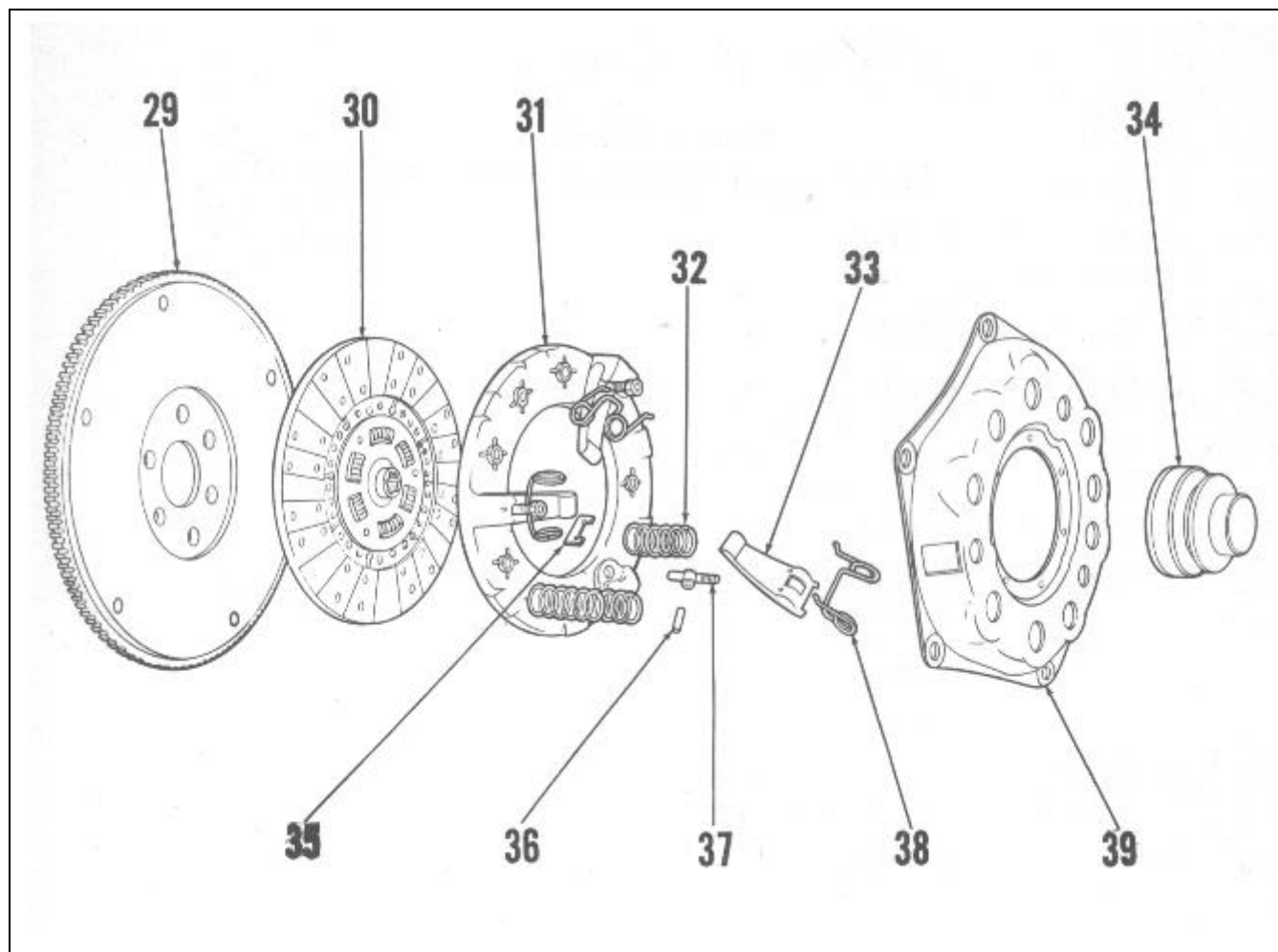
BRAKE ARRANGEMENT

LEGEND

- | | |
|--------------------------------------|---------------------------------|
| 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
BRAKES — Continued			
4-11	WHEEL CYLINDER BLEED SCREW — Remove and Install	.2	_____
MASTER CYLINDER			
4-12	MASTER CYLINDER — Remove and Install. Includes bleeding.	1.0	_____
4-13	MASTER CYLINDER — Overhaul. Includes remove and install, honing cylinder, replace necessary parts and bleed lines.	1.6	_____
4-14	MASTER CYLINDER — Overhaul — When Removed from Car	.6	_____
4-15	MASTER CYLINDER OUTLET FITTING AND / OR GASKET — Remove and Install.	.4	_____
4-16	MASTER CYLINDER STOP LIGHT SWITCH — Remove and Install.	.3	_____
4-17	MASTER CYLINDER FILLER CAP OR GASKET — Remove and Install.	.2	_____
BRAKE HOSE AND TUBES			
4-18	BRAKE HOSE — Remove and Install.— Includes bleeding lines. One Front	.9	_____
	One Rear	.8	_____
4-19	BRAKE TUBES — Remove and Install — (All). Includes bleeding lines	1.8	_____
4-20	BRAKE TUBE — (Rear Axle Tee to Right Rear Cylinder) — Remove and Install. Includes bleeding lines.	.8	_____
4-21	BRAKE TUBE — (Rear Axle Tee to Left Rear Cylinder) — Remove and Install. Includes bleeding lines.	.8	_____
4-22	BRAKE TUBE MASTER CYLINDER TO FRAME TEE — Remove and Install. Includes bleeding lines.	.9	_____
4-23	BRAKE TUBE — (Frame Tee to Front Wheel) — (Right or Left) — Remove and Install. Includes bleeding lines.	.9	_____
4-24	FRAME TEE — Remove and Install. Includes bleeding lines.	.9	_____
4-25	REAR AXLE TEE — Remove and Install. Includes bleeding lines.	.9	_____
BRAKE CABLES AND LINKAGE			
4-26	BRAKE CABLE — Remove and Install. One	.8	_____
	Two	1.5	_____
4-27	BRAKE-PULL BACK SPRINGS — (Any One) — Remove and Install.	.3	_____
4-28	BRAKE PEDAL ROD — Remove and Install.	.4	_____
4-29	BRAKE PEDAL TO MASTER CYLINDER PUSH ROD — Remove and Install.	.5	_____
4-30	BRAKE PEDAL LEVER, SHAFT AND HOUSING ASSEMBLY. Remove and Install	1.0	_____
	To Rebush — Add	.3	_____





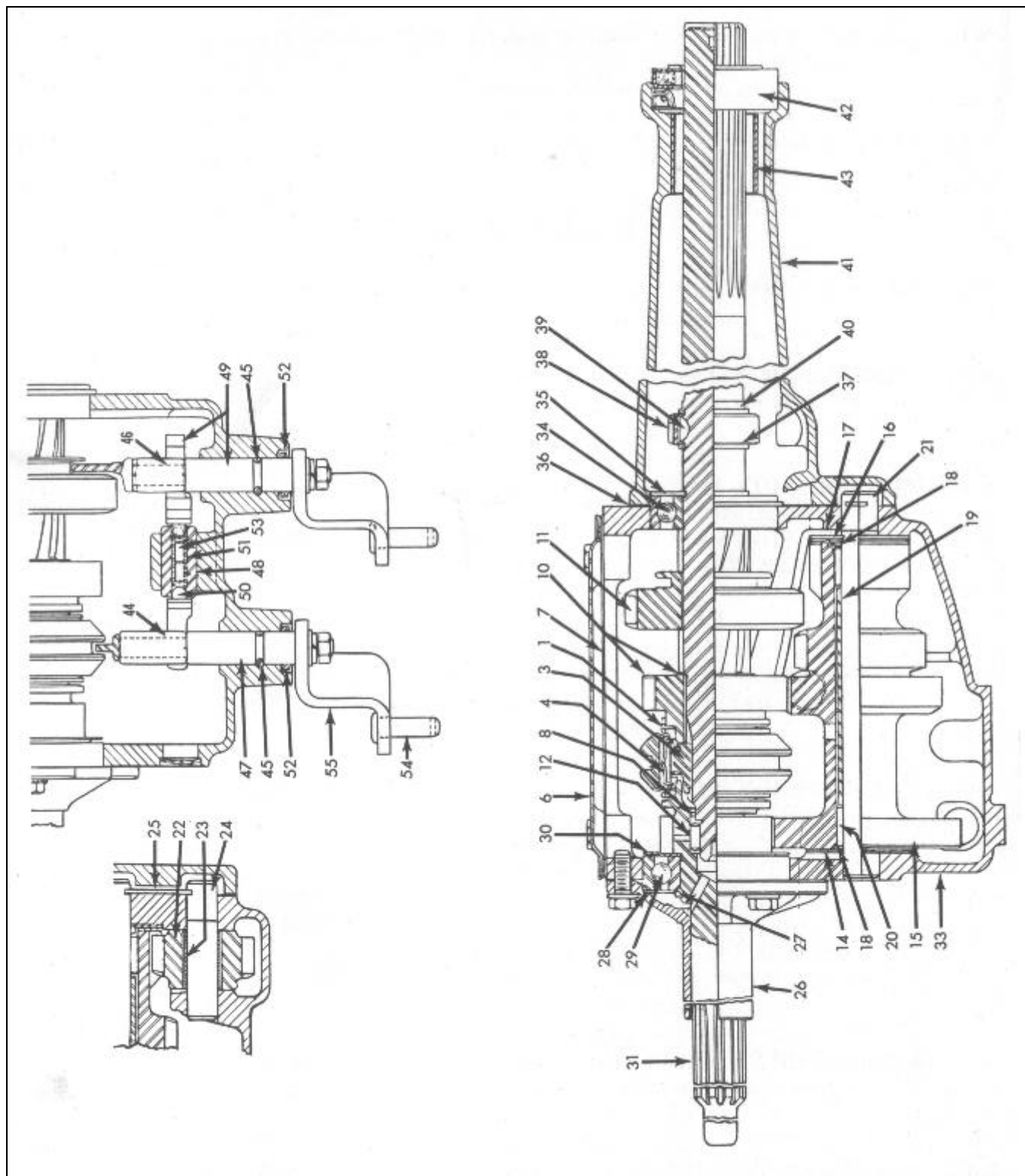
CLUTCH — EXPLOSION

LEGEND

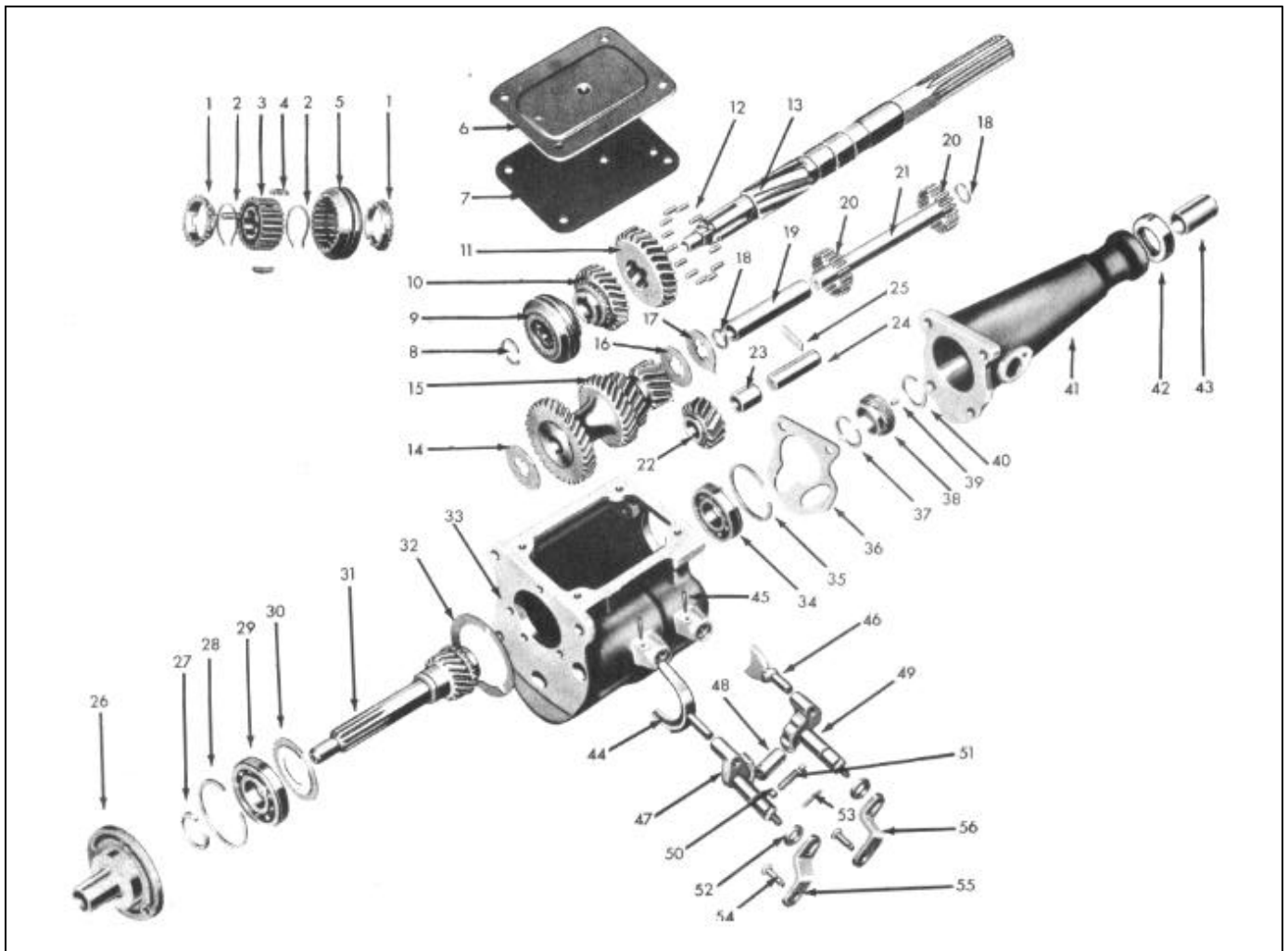
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|-------------------------------------|--------------------------------------|
| 1. Lever return spring | 21. Clutch housing |
| 2. Throwout lever release rod | 22. Retainer screw |
| 3. Locknut | 23. Retainer and boot |
| 4. Adjusting nut | 24. Felt washer |
| 5. Release lever | 25. Flat washer |
| 6. Shaft support spring | 26. Support assembly |
| 7. Clutch control cross shaft | 27. Bolts to transmission |
| 8. Brake pedal lever | 28. Transmission assembly |
| 9. Snap ring | 29. Flywheel |
| 10. Plain washer | 30. Driven disc plate assembly |
| 11. Pedal lever shaft | 31. Pressure plate |
| 12. Clutch pedal lever | 32. Clutch engaging spring |
| 13. Release lever pin | 33. Release lever |
| 14. Release lever spring | 34. Release bearing and collar |
| 15. Cotter pin | 35. Release lever retainer |
| 16. Throwout lever pivot | 36. Release lever eyebolt pin |
| 17. Throwout lever retaining spring | 37. Release lever eyebolt |
| 18. Clutch pedal lever | 38. Release lever anti-rattle spring |
| 19. Clutch control shaft assembly | 39. Clutch cover |
| 20. Cross shaft link | |

OPERATION	DESCRIPTION	TIME	PRICE
BRAKES — Continued			
4-31	HAND BRAKE CABLE — Adjust.	.3	_____
4-32	HAND BRAKE LEVER AND RATCHET ASSEMBLY — Remove and Install.	.4	_____
4-33	HAND BRAKE CABLE — Remove and Install.	.6	_____
4-34	HAND BRAKE COMPLETE ASSEMBLY — Remove and Install	1.0	_____
CLUTCH			
5-1	CLUTCH PEDAL — Adjust.	.3	_____
5-2	CLUTCH ASSEMBLY — Overhaul. Includes remove and install transmission, clutch assembly, recondition pressure plate and adjust shift linkage.		
	With Standard Transmission	3.5	_____
	With Overdrive Transmission	3.9	_____
5-3	FLYWHEEL — Remove and Install — (When Transmission and Clutch Assembly is Removed)	.6	_____
5-4	CLUTCH COVER ASSEMBLY — Overhaul — (Clutch Removed from Car).	1.1	_____
5-5	CLUTCH DRIVEN DISC AND/OR CLUTCH COVER ASSEMBLY — Replace. Includes remove and install transmission and adjust clutch pedal.		
	With Standard Transmission	2.2	_____
	With Overdrive Transmission	2.6	_____
5-6	CLUTCH DRIVEN DISC — Reface — (Clutch Removed from Car)	.5	_____
5-7	PILOT BUSHING — Replace — (When Transmission and Clutch Assembly is Removed)	.4	_____
5-8	CLUTCH PEDAL RETURN SPRING — Remove and Install.	.3	_____
5-9	CLUTCH PEDAL LEVER — Remove and Install.	.8	_____
	To Rebush — Add	.3	_____
5-10	CLUTCH PEDAL LINKAGE — Overhaul.	1.1	_____
5-11	CLUTCH PEDAL LEVER SHAFT — Remove and Install.	1.0	_____
5-12	CLUTCH THROWOUT LEVER RELEASE ROD — Remove and Install.	.4	_____
5-13	CLUTCH CROSS SHAFT SUPPORT — Remove and Install.	.4	_____
5-14	CLUTCH THROWOUT BEARING — Remove and Install.		
	With Standard Transmission	1.8	_____
	With Overdrive Transmission	2.2	_____

OPERATION	DESCRIPTION	TIME	PRICE
CLUTCH — Continued			
5-15	CLUTCH THROWOUT LEVER — Remove and Install.	1.0	_____
5-16	CLUTCH HOUSING — Remove and Install. Includes remove and install engine.	5.7	_____
	With Standard Transmission	6.1	_____
	With Overdrive Transmission		_____
5-17	CLUTCH HOUSING PAN — Remove and Install.	.4	_____
TRANSMISSION			
6-1	TRANSMISSION ASSEMBLY — Remove and Install.		
	Standard Transmission	1.4	_____
	Overdrive Transmission	1.8	_____
6-2	TRANSMISSION ASSEMBLY — Overhaul. Includes remove and install from underneath car.		
	Standard Transmission	3.9	_____
	Overdrive Transmission	5.4	_____
6-3	TRANSMISSION MAINSHAFT REAR BEARING — Remove and Install. Includes remove and install transmission.	3.4	_____
6-4	TRANSMISSION MAIN DRIVE GEAR BEARING RETAINER AND/OR GASKET — Remove and Install. Includes remove and install transmission.		
	Standard Transmission	1.7	_____
	Overdrive Transmission	2.1	_____
6-5	TRANSMISSION MAIN DRIVE GEAR AND/OR BEARING — Remove and Install. Includes remove and install transmission.		
	Standard Transmission	3.4	_____
	Overdrive Transmission	4.9	_____
6-6	TRANSMISSION MAINSHAFT — Remove and Install. Includes mainshaft gears and synchronizer assembly.		
	Standard Transmission	3.4	_____
	Overdrive Transmission	4.9	_____
6-7	COUNTERSHAFT GEAR CLUSTER AND / OR COUNTERSHAFT, ROLLER BEARINGS, ROLLER BEARING SPACER, THRUST WASHERS OR BEARING WASHERS — Remove and Install.		
	Includes remove and install transmission.		
	Standard Transmission	3.5	_____
	Overdrive Transmission	5.0	_____
6-8	REVERSE IDLER GEAR AND BUSHING OR IDLER GEAR SHAFT — Remove and Install. Includes remove and install transmission		
	Standard Transmission	3.5	_____
	Overdrive Transmission	5.0	_____
6-9	TRANSMISSION SHIFT SHAFT — LOW AND REVERSE OR SECOND AND HIGH, ALSO INTERLOCK SLEEVE, PIN, SPRING OR BALLS		
	Remove. Install — (One All).		
	Standard Transmission	3.9	_____
	Overdrive Transmission	5.4	_____



TRANSMISSION — CROSS SECTION



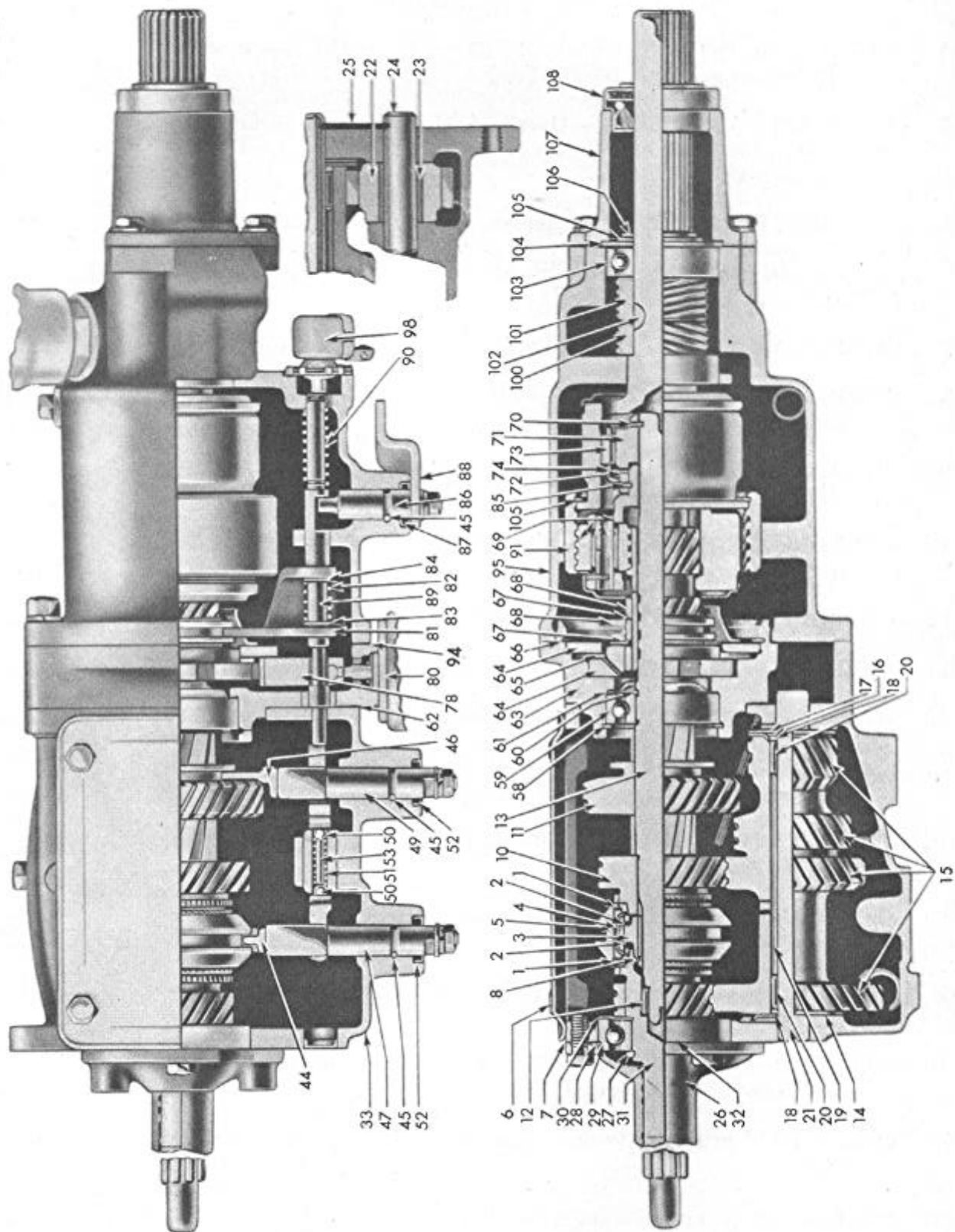
TRANSMISSION - EXPLOSION

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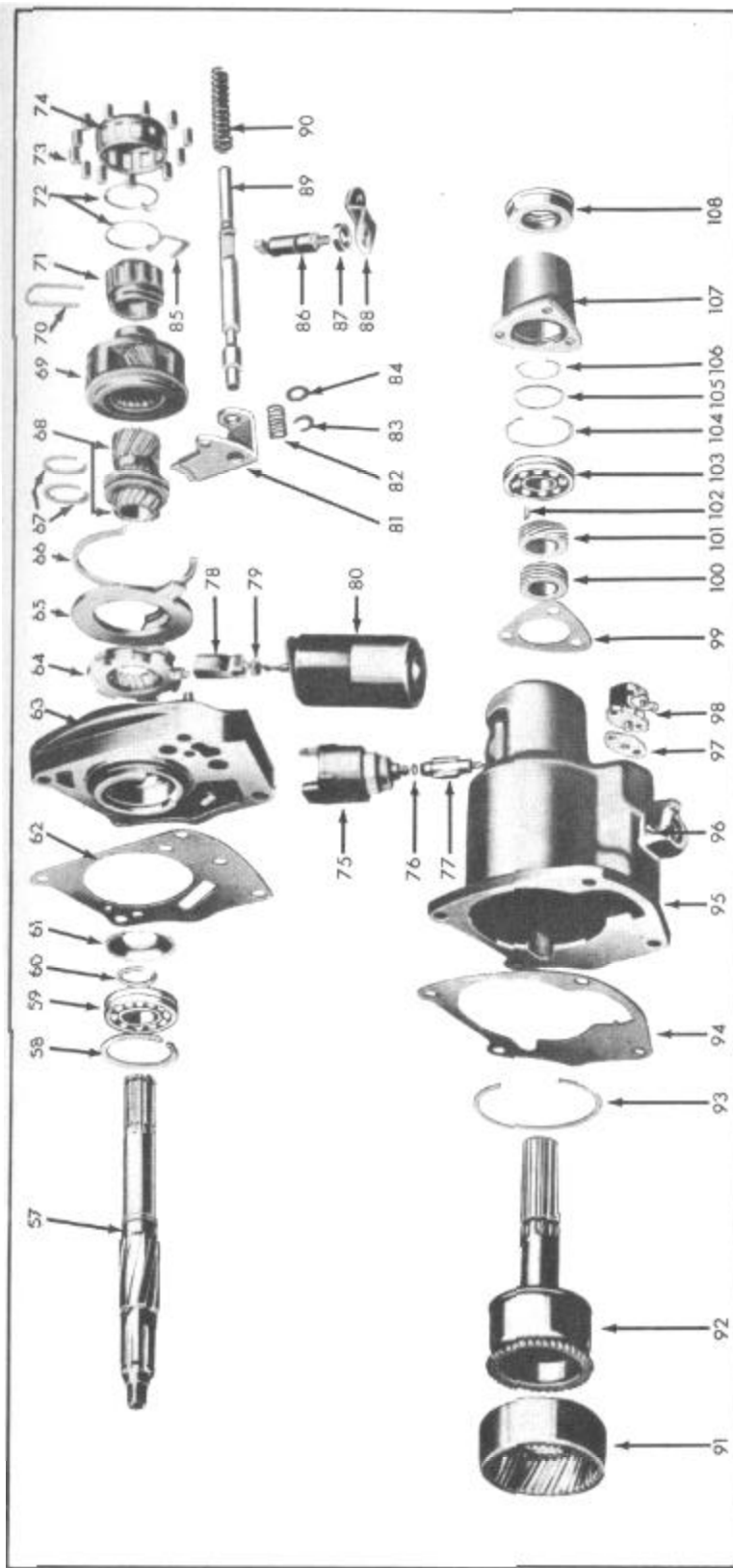
- | | | |
|-------------------------------------|--|---|
| 1. Synchronizer rings | 19. C.S. gear spacer | 39. Speedometer gear lock key |
| 2. Synchronizer springs | 20. C.S. bearing rollers | 40. Speedometer gear snap ring (rear) |
| 3. Synchronizer hub | 21. Counter shaft | 41. Mainshaft bearing retainer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

OPERATION	DESCRIPTION	TIME	PRICE
TRANSMISSION — Continued			
6-10	TRANSMISSION CASE — Remove and Install		
	Standard Transmission	3.9	_____
	Overdrive Transmission	5.4	_____
6-11	TRANSMISSION MAINSHAFT REAR OIL SEAL — Remove and Install.		
	Transmission in car	.7	_____
6-12	TRANSMISSION SPEEDOMETER CABLE — Remove and Install.	.4	_____
6-13	TRANSMISSION SPEEDOMETER DRIVE GEAR — Remove and Install.		
	Transmission in car	.9	_____
6-14	TRANSMISSION SPEEDOMETER DRIVE PINION — Remove and Install.	.3	_____
6-15	TRANSMISSION SPEEDOMETER CABLE AND HOUSING — Remove and Install.	.7	_____
6-16	TRANSMISSION CASE COVER AND/OR GASKET — Remove and Install.	1.5	_____
TRANSMISSION CONTROL			
6-17	CONTROL HAND SHIFT LEVER AND CONTROL TUBE — Remove and Install	1.0	_____
6-18	STEERING JACKET TUBE, CONTROL TUBE AND SHIFT LEVER — Remove and Install	2.0	_____
6-19	CONTROL HAND SHIFT LEVER — Remove and Install	.3	_____
6-20	CONTROL TUBE BRACKET (UPPER) — Remove and Install		
	With Direction	.7	_____
	Without Direction	.4	_____
6-21	CONTROL TUBE BRACKET (LOWER) — Remove and Install	1.9	_____
6-22	CONTROL ADJUSTMENT.	.6	_____
6-23	CONTROL TUBE PUSH ROD OR PUSH ROD ENDS, Remove and Install	1.4	_____
OVERDRIVE			
7-1	TRANSMISSION AND OVERDRIVE ASSEMBLY — Remove and Install		
	Includes replace either unit.	4.9	_____
7-2	TRANSMISSION AND OVERDRIVE — Overhaul (Both Units).		
	Includes remove and install and replace any necessary parts in either unit	5.4	_____
7-3	OVERDRIVE MAINSHAFT — Remove and Install. (Overdrive in Car)	1.3	_____

OPERATION	DESCRIPTION	TIME	PRICE
OVERDRIVE — Continued			
7-4	OVERDRIVE HOUSING AND/OR REAR BEARING — Remove and Install. — (Overdrive in Car)	1.3	_____
7-5	OVERDRIVE ASSEMBLY — Overhaul — (Overdrive in Car) . Includes replacement of any parts, except the adaptor, bearing or transmission mainshaft.	2.0	_____
7-6	OVERDRIVE ASSEMBLY — Remove and Install. Remove and Install. overdrive transmission, removing overdrive from transmission and Installing a new overdrive or overdrive transmission mainshaft.	4.9	_____
7-7	OVERDRIVE WIRING HARNESS — Remove and Install.	1.0	_____
7-8	OVERDRIVE REAR OIL SEAL — Remove and Install. — (Overdrive in Car)	.7	_____
7-9	OVERDRIVE SPEEDOMETER DRIVE GEAR — Remove and Install. — (Overdrive in Car) .	1.4	_____
7-10	OVERDRIVE SHIFT RAIL — Remove and Install. — (Overdrive in Car) .	1.6	_____
7-11	OVERDRIVE SOLENOID — Remove and Install.	.4	_____
7-12	OVERDRIVE GOVERNOR SWITCH — Remove and Install.	.4	_____
7-13	OVERDRIVE THROTTLE SWITCH — Remove and Install.	.4	_____
7-14	CONTROL CABLE ASSEMBLY — Remove and Install. adjustment.	.6	_____
7-15	STATIONARY GEAR AND/OR BALK RING — Remove and Install. — (Overdrive in Car).	1.9	_____
7-16	OVERDRIVE CONTROL SHAFT — Remove and Install. — (Overdrive in Car) .	1.5	_____
7-17	OVERDRIVE ADAPTOR TO OVERDRIVE HOUSING GASKET — Remove and Install.	1.2	_____
7-18	OVERDRIVE HOUSING ADAPTOR AND/OR GASKET—Remove and Install. — (Overdrive Transmission)	4.9	_____
7-19	OVERDRIVE SPEEDOMETER DRIVE PINION — Remove and Install.	.3	_____
7-20	OVERDRIVE RELAY SWITCH — Remove and Install.	.4	_____
7-21	OVERDRIVE CONTROL SWITCH — Remove and Install.	.3	_____
7-22	SOLENOID STATIONARY GEAR PAWL — Remove and Install.	1.9	_____



TRANSMISSION AND OVERDRIVE — CROSS SECTION



OVERDRIVE - EXPLOSION

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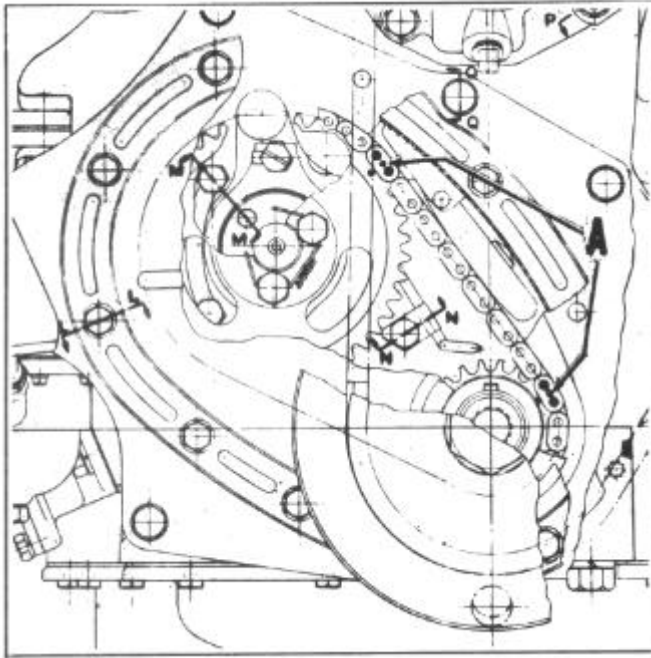
57. Mainshaft	70. Pinion cage retainer	83. Lockup rail "C" washer	96. Control shaft locating pin
58. Trans. mainshaft snap ring	71. Cam assembly	84. Lockup rail washer cup	97. Control switch gasket
59. Trans. mainshaft bearing	72. Cam roller retainer springs	85. Cam retainer clip	98. Control switch
60. Trans. mainshaft snap ring	73. Cam roller	86. Control shaft	99. Retainer gasket
61. Bearing oil baffle	74. Cam roller retainer	87. Control shaft oil seal	100. Governor drive gear
62. O/D to trans. case gasket	75. Governor switch	88. Control lever	101. Speedometer drive gear
63. Overdrive housing adapter	76. Lock ring	89. Shift rail	102. Woodruff key
64. Sun gear plate and baffle ring	77. Governor pinion	90. Shift rail retractor spring	103. Rear bearing
65. Sun gear plate cover	78. Sun gear pawl	91. O/D mainshaft ring gear	104. Rear brg. retainer snap ring
66. Cover plate snap ring	79. Sun gear pawl oil seal	92. O/D mainshaft output shaft	105. Rear bearing spacer washer
67. Sun gear snap rings	80. Solenoid assembly	93. Snap ring	106. Output shaft snap ring
68. Sun gear and shifting collar	81. Shift fork	94. Overdrive housing gasket	107. Rear bearing retainer
69. Pinion cage assembly	82. Shift rail sleeve spring	95. Overdrive housing	108. Output shaft oil seal

OPERATION	DESCRIPTION	TIME	PRICE
OVERDRIVE — Continued			
7-23	OVERDRIVE GOVERNOR DRIVE GEAR — Remove and Install	1.4	_____
7-24	OVERDRIVE WIRING HARNESS — Check.	.5	_____
7-25	OVERDRIVE TRANSMISSION CASE COVER GASKET—Remove and Install.	1.9	_____
PROPELLER SHAFT			
8-1	PROPELLER SHAFT AND UNIVERSAL JOINT ASSEMBLY — Remove and Install.	.6	_____
8-2	PROPELLER SHAFT UNIVERSAL JOINT — Remove and Install.		
8-3	One	1.0	_____
	Two	1.6	_____
	PROPELLER SHAFT YOKE SLEEVE — Remove and Install.	.6	_____
ENGINE			
9-1	ENGINE AND TRANSMISSION ASSEMBLY—Remove and Install		
	With Standard Transmission	4.7	_____
	With Overdrive Transmission	5.1	_____
	With Hydra-Matic Transmission	5.9	_____
9-2	ENGINE ASSEMBLY — Remove and Install. Includes remove engine, transfer transmission, clutch, fuel and electrical equipment to new assembly, and minor engine tune-up.		
9-3	With Standard Transmission	6.7	_____
	With Overdrive Transmission	7.1	_____
	With Hydra-Matic Transmission	9.2	_____
9-4	SKELETON ENGINE — Install. Includes removing old engine from car and transfer all sub-assemblies from old block to new, and minor engine tune-up.		
	With Standard Transmission	14.2	_____
	With Overdrive Transmission	14.6	_____
	With Hydra-Matic Transmission	16.7	_____
	CYLINDER BLOCK AND PISTON ASSEMBLY — Install. Includes transfer all sub-assemblies from old block to new and refacing old or new valves and seats, align rods, install piston and rod assemblies, and minor tune-up.		
	With Standard Transmission	19.6	_____
	With Overdrive Transmission	20.0	_____
	With Hydra-Matic Transmission	22.1	_____

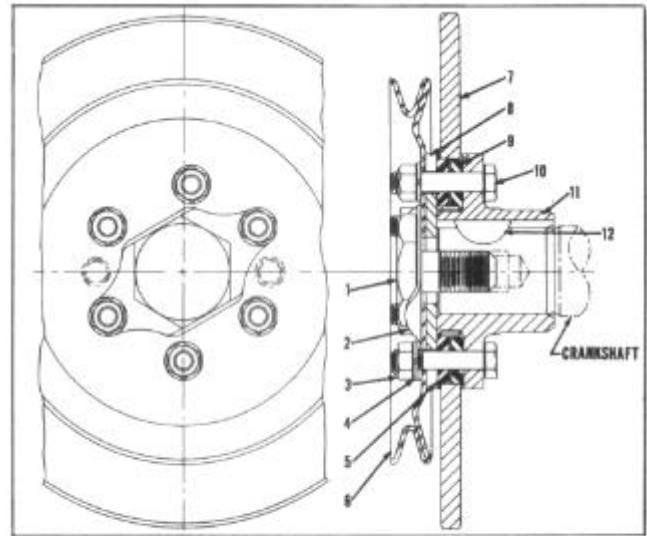
OPERATION	DESCRIPTION	TIME	PRICE
ENGINE — Continued			
9-5	ENGINE — Paint. Includes remove and install spark plugs and ignition wires.	1.0	_____
SUPPORT PLATES AND MOUNTINGS			
9-6	ENGINE SUPPORT PLATE (FRONT) — Remove and Install.	3.2	_____
9-7	ENGINE SUPPORT PLATE (REAR) — Remove and Install.		
	With Standard Transmission — Remove Engine	6.0	_____
	With Overdrive Transmission — Remove Engine	6.4	_____
	With Hydra-Matic Transmission	6.2	_____
9-8	ENGINE MOUNTINGS (FRONT) — Remove and Install — (Both)	1.0	_____
9-9	ENGINE MOUNTING (REAR) — Remove and Install.		
	All Standard Models	.5	_____
	With Hydra-Matic (Two)	.9	_____
CAMSHAFT AND MAIN BEARINGS			
9-10	CAMSHAFT — Remove and Install — (Unnecessary to Remove Cylinder Head or Valves). Includes adjusting tappets and reset timing.	5.1	_____
9-11	CAMSHAFT BEARINGS — Remove and Install — (All) — (Using Factory Reamed Bearings) . Includes removing and installing of engine.		
	With Standard Transmission	9.2	_____
	With Overdrive Transmission	9.6	_____
	With Hydra-Matic Transmission	11.4	_____
9-12	CAMSHAFT PLUG AND/OR GALLERY PLUG — Remove and Install.		
	With Standard Transmission — Remove Engine	6.3	_____
	With Overdrive Transmission — Remove Engine	6.7	_____
	With Hydra-Matic Transmission	6.5	_____
9-13	MAIN BEARINGS — Remove and Install — (All) — (With Engine in Car) . Includes remove and install oil pan.	3.3	_____
9-14	MAIN BEARINGS — Remove and Install — (All) — (Engine Removed from Car)	2.5	_____
9-15	MAIN BEARING — (No. 3 Thrust, Upper and Lower Shells) — (Replace with Engine in Car) . Includes remove and install oil pan.	1.8	_____
9-16	MAIN BEARING — (Oil Leak Correction). Includes remove and install oil pan and repacking cap.		
	Front	2.6	_____
	Rear — Includes Crankshaft Seal	2.1	_____
	Front and Rear	3.0	_____

OPERATION	DESCRIPTION	TIME	PRICE
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ENGINE — Continued



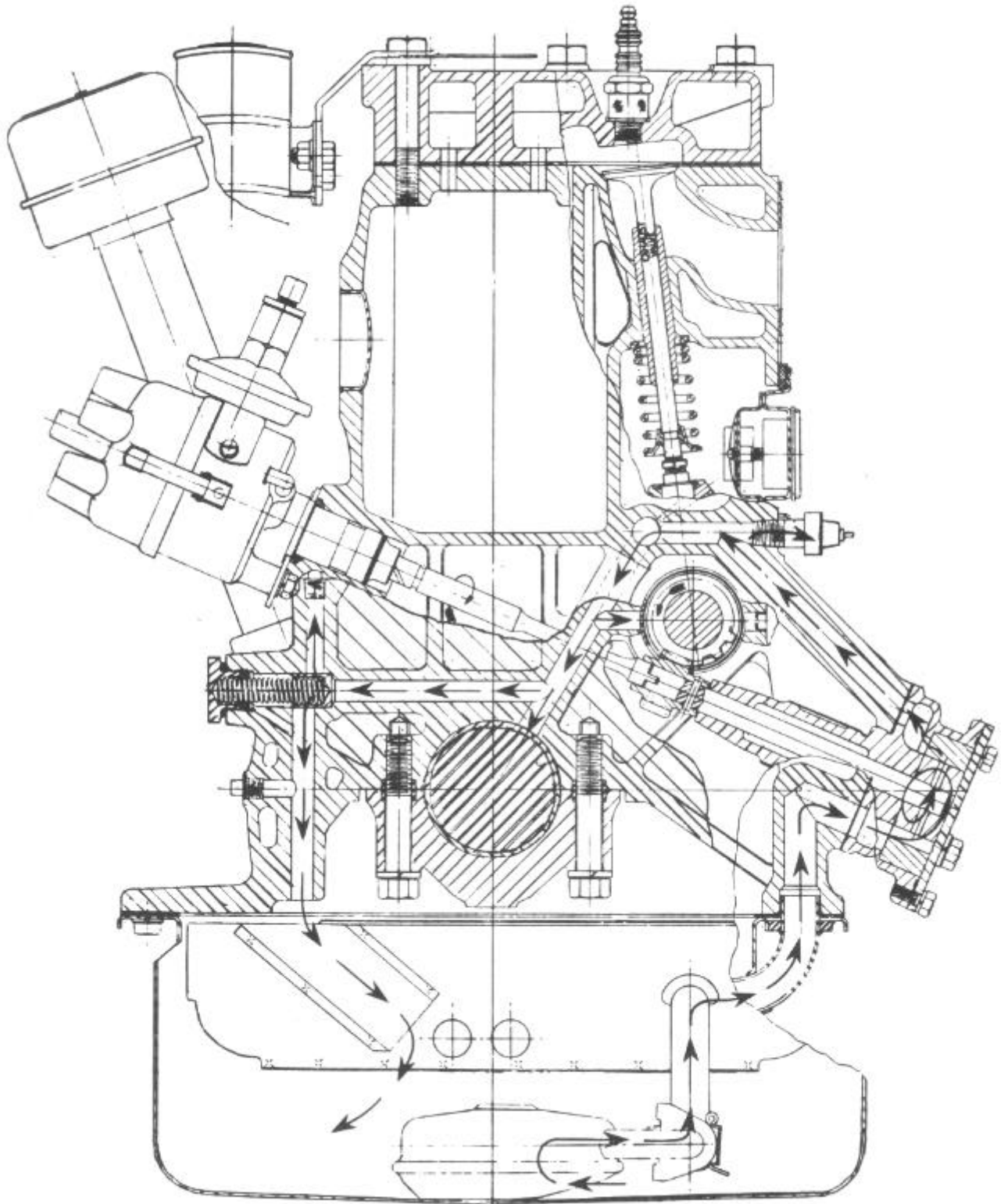
TIMING CHAIN AND SPROCKETS



VIBRATION DAMPNER

FLYWHEEL, CRANKSHAFT AND TIMING GEARS

9-17	CRANKSHAFT — Remove and Install. Includes remove and install engine. Replace rod bearings if necessary.		
	With Standard Transmission	9.3	_____
	With Overdrive Transmission	9.7	_____
	With Hydra-Matic Transmission	11.0	_____
9-18	FLYWHEEL ASSEMBLY — Remove and Install.		
	With Standard Transmission	2.8	_____
	With Overdrive Transmission	3.2	_____
	With Hydra-Matic Transmission	5.8	_____
9-19	FLYWHEEL RING GEAR — Remove and Install — (With flywheel Removed)	.6	_____
9-20	VIBRATION DAMPENER ASSEMBLY — Remove and Install. Includes remove and install radiator.	1.3	_____
9-21	TIMING CASE COVER GASKET OR OIL SEAL — Remove and Install.	2.1	_____
9-22	VIBRATION DAMPENER HUB — Remove and Install. If Scored, Add to Operation No. 9-21.	.3	_____
9-23	TIMING CHAIN AND/OR CAMSHAFT GEAR—Remove and Install. Includes reset timing.	2.8	_____



ENGINE — CROSS SECTION

OPERATION	DESCRIPTION	TIME	PRICE
ENGINE — Continued			
CYLINDER BLOCK			
9-24	CYLINDER BLOCK — Hone all Cylinders — (Cylinder Head and Pistons Removed).	4.5	_____
9-25	CYLINDER BLOCK — Hone One Cylinder — (Cylinder Head and Piston Removed)	1.0	_____
9-26	CYLINDER BLOCK — Rebore — When Cylinder Head and Pistons Are Removed.	5.5	_____
ENGINE LUBRICATION			
9-27	OIL CHECK VALVE — Remove and Install. With Hydra-Matic Transmission	.3 .5	_____ _____
9-28	OIL PRESSURE — Block Unit — Remove and Install	.4	_____
9-29	OIL PUMP ASSEMBLY — Remove and Install. Includes checking timing.	.6	_____
9-30	OIL PUMP — Overhaul. Includes checking timing.	1.1	_____
9-31	OIL PAN ASSEMBLY Remove, Clean , install. Includes replacing gaskets.	1.3	_____
9-32	OIL PRESSURE LIGHT — Remove and Install. — (Bulb).	.2	_____
9-33	OIL PRESSURE CHECK. Includes remove and install block indicator. unit.	.4	_____
CONNECTING RODS, PISTONS AND RINGS			
9-34	CONNECTING RODS — Remove and Install. — (All). remove and install cylinder head, oil pan, remove ridge from walls..	7.0	_____
9-35	CONNECTING ROD — Remove and Install. — (One). Remove and Install. install cylinder head, oil pan, remove ridge from wall For Each Additional Rod, Add	4.0 .6	_____ _____
9-36	CONNECTING RODS — Align All — When Removed from Engine.	1.0	_____
9-37	CONNECTING ROD — BEARINGS —Remove and Install. — (All) . Remove and Install. install oil pan.	3.0	_____
9-38	CONNECTING ROD — BEARINGS — Remove and Install. (All) For Each Additional Rod Bearing, Add	1.6 .3	_____ _____
9-39	CONNECTING ROD — BEARINGS —Remove and Install. — (All) (Engine Removed from Car).	2 4	_____

OPERATION	DESCRIPTION	TIME	PRICE
ENGINE — Continued			
9-40	CONNECTING ROD BUSHINGS — Ream and Fit Pins — (All) (Rods Removed).	2.2	_____
941	CONNECTING ROD BUSHINGS — Ream and Fit Pins — (Rods Removed) — Each	.4	_____
9-42	PISTONS AND RINGS — Remove and Install — (All). Includes remove and install oil pan and cylinder head. Remove ridge from walls and remove carbon. Fit new pistons and rings and align rods. If necessary to hone cylinders, Add	7.7 4.5	_____ _____
9-43	PISTON AND RINGS — Remove and Install — (One). Includes remove and install oil pan, cylinder head, piston and piston rings and align rod. If necessary to hone one cylinder, Add To hone each additional cylinder, Add	4.4 1.0 .7	_____ _____ _____
9-44	PISTON — Remove and Install — One With Rings — (When Oil Pan and Cylinder Head are Removed).	.7	_____
9-45	PISTON PINS — Remove and Install — (All). Includes remove and install oil pan, cylinder head, connecting rod bushings and align rods using old pistons, remove carbon and remove ridge from walls	7.1	_____
9-46	PISTON PIN — Remove and Install — (One Pin and Bushing). Includes remove and install oil pan, cylinder head, remove ridge from wall and align rod. For each additional pin, Add	4.1 .6	_____ _____
9-47	PISTON PIN — Remove and Install — (One) — When Piston and Rod is Removed. Includes ream bushing, fit pin and align rod. Each pin.	.4	_____
9-48	PISTON RINGS — Remove and Install — (All). Includes remove and install oil pan, cylinder head, remove carbon and ridge from walls, align rods.	6.5	_____
9-49	PISTON RINGS — Remove and Install (On One Piston Only). Includes remove and install oil pan, cylinder head, remove carbon and ridge from wall and align rod. For each additional piston, Add	4.0 .5	_____ _____
9-50	PISTON RINGS — Remove and Install — (On Piston Out of Car). Each piston	.2	_____

OPERATION	DESCRIPTION	TIME	PRICE
ENGINE — Continued			
CYLINDER HEADS			
9-51	CYLINDER HEAD AND/OR GASKET — Remove and Install. Includes removing carbon.	1.5	_____
9-52	CYLINDER HEAD — Tighten All Cap Screws.	.3	_____
9-53	CYLINDER HEAD CAP SCREW — (BROKEN) — Remove and Install — (Cylinder Head Removed)	.4	_____
9-54	CYLINDER HEAD — COMPRESSION TEST — All Cylinders	.6	_____
VALVES, SPRINGS, TAPPETS AND GUIDES			
9-55	TAPPETS — Adjust.	1.3	_____
9-56	TAPPET COVERS AND/OR GASKETS — Remove and Install — (Both).	.7	_____
	Front	.3	_____
	Rear	.4	_____
9-57	TAPPET ASSEMBLY — Remove and Install — (One) — Unnecessary to Remove Cylinder Head or Valves. Includes remove oil pan and valve covers and cam shaft and adjust tappet.	6.6	_____
9-58	TAPPET ASSEMBLIES — Remove and Install — (All) — Unnecessary to Remove Cylinder Head or Valves. Includes remove oil pan and valve covers and cam shaft and adjust tappets.	8.8	_____
9-59	VALVES — Grind. Includes remove carbon, adjust tappets and minor tune-up.	6.4	_____
9-60	VALVES — Remove and Install — (One). Includes remove and install cylinder head, checking tappet adjustment also refacing valve and seat. For each additional valve, Add	3.3 .3	_____ _____
9-61	VALVE SPRINGS — Remove and Install — (All). Includes remove and install cylinder head and adjust tappets.	4.2	_____
9-62	VALVE SPRINGS — Remove and Install — (One). Includes remove and install cylinder head and checking tappet adjustment. For Each additional spring, Add	3.3 .2	_____ _____
9-63	VALVE GUIDES — Remove and Install — (All) — When Valves are Removed. To replace one guide	1.6 .2	_____ _____
9-64	VALVE GUIDES — Install One New Guide. Includes remove and install cylinder head, remove and install valve, adjust tappet. For each additional guide	3.0	_____

OPERATION	DESCRIPTION	TIME	PRICE
ENGINE — Continued			
ENGINE COMBINATION OPERATION #1			
9-65	MINOR ENGINE TUNE-UP. Includes clean and regap or replace spark plugs, adjust or replace distributor points, check timing, adjust carburetor and climatic control, clean and/or re-oil air cleaner.	1.5	_____
ENGINE COMBINATION OPERATION #2			
9-66	MAJOR ENGINE TUNE - UP. Includes check battery gravity, battery cables, 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 primary and secondary test, check engine timing, check generator output, check generator regulator, clean and adjust carburetor and climatic control, check fuel pump pressure and clean air cleaner.	3.3	_____
ENGINE COMBINATION OPERATION #3			
9-67	VALVES AND / OR VALVE SPRINGS, PISTONS, PINS, RINGS AND MAIN AND CONNECTING ROD BEARINGS. Includes remove and install cylinder head, oil pan, main and connecting rod bearings, aligning rods, refacing valves and seats, replacing pistons, piston rings and pins, and minor tune-up.	14.4	_____
	If necessary to hone cylinder walls, Add	4.5	_____
ENGINE COMBINATION OPERATION #4			
9-68	VALVES, RINGS AND CONNECTING ROD BEARINGS. Includes grinding valves, clean carbon, replace piston rings and connecting rod bearings and minor tune-up.	10.9	_____
ENGINE COMBINATION OPERATION #5			
9-69	VALVES, AND/OR VALVE SPRINGS, RINGS AND MAIN AND CONNECTING ROD BEARINGS. Includes remove and install cylinder head, oil pan, main and connecting rod bearings, aligning rods, refacing valves and seats, replacing piston rings and minor tune-up.	12.2	_____
ENGINE COMBINATION OPERATION #6			
9-70	VALVES, VALVE GUIDES AND SPRINGS. Includes remove and install cylinder head, refacing valves and seats, replacing all guides and springs and minor tune-up.	9.5	_____

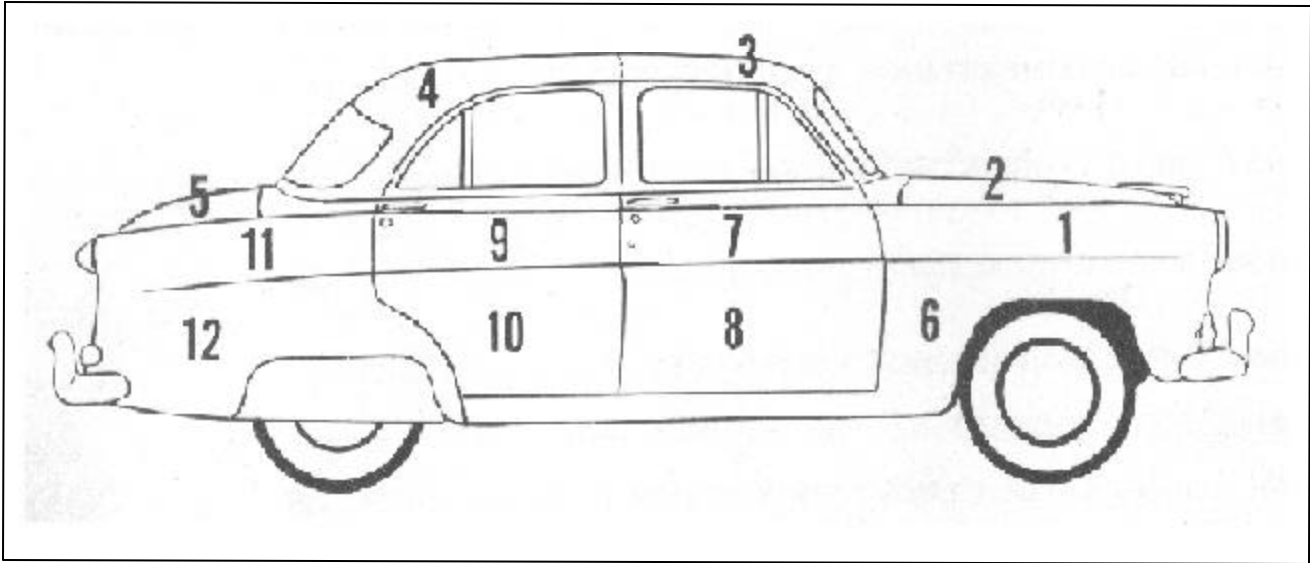
OPERATION	DESCRIPTION	TIME	PRICE
BODY AND HARDWARE			
DOORS			
10-1	DOOR ASSEMBLY — Complete — Remove and Install.		
	Front	1.0	_____
	Rear	1.0	_____
10-2	DOOR ASSEMBLY — Skeleton — Remove and Install.		
	Front or Rear. (Does not include painting.)	2.8	_____
10-3	DOOR (FRONT) WINDOW REGULATOR ASSEMBLY—Remove and Install.	1.0	_____
104	DOOR (REAR) WINDOW REGULATOR ASSEMBLY — Remove and Install.	1.0	_____
10-5	DOOR VENTILATING WING REGULATOR ASSEMBLY — (FRICTION TYPE) — Remove and Install	1.2	_____
10-6	DOOR WINDOW REGULATOR HANDLES — Remove and Install.	.2	_____
10-7	DOOR HANDLE (INSIDE) — Remove and Install. One.	.2	_____
10-8	DOOR HANDLE (OUTSIDE) — Remove and Install. One.	.2	_____
10-9	DOOR LOCK CYLINDER AND HOUSING — Remove and Install.	.2	_____
10-10	DOOR LOCK COMPLETE ASSEMBLY — Remove and Install. Includes remove and install trim panels and regulator handles.		
	Front	1.1	_____
	Rear	1.1	_____
10-11	DOOR LOCK REMOTE CONTROL ASSEMBLY — Remove and Install.		
	Front or Rear.	.7	_____
10-12	DOOR LOCK STRIKER PLATE — Remove, Install and Adjust	.5	_____
10-13	DOOR CHECK STRAP — Remove and Install.	1.0	_____
10-14	DOOR HINGE AND/OR HINGE PIN — Remove and Install. Upper or Lower, Front or Rear.	.5	_____
DOOR LINERS			
10-15	FRONT DOOR TRIM PANEL — Remove and Install.	.4	_____
10-16	FRONT DOOR LINER PANEL — Remove and Install.	.5	_____
10-17	REAR DOOR TRIM PANEL — Remove and Install.	.4	_____
10-18	REAR DOOR LINER PANEL — Remove and Install.	.5	_____

OPERATION	DESCRIPTION	TIME	PRICE
BODY AND HARDWARE — Continued			
SEATS, SEAT TRACK AND UPHOLSTERY			
10-19	FRONT SEAT AND SEAT TRACK ASSEMBLY — Remove and Install.	.8	_____
10-20	FRONT SEAT TRACK — Remove and Install. Right or Left.	.5	_____
10-21	REAR SEAT AND SEAT BACK — Remove and Install.	.3	_____
10-22	FRONT SEAT BACK ROBE HANGER — Remove and Install.	.3	_____
10-23	REAR SEAT BACK — UPHOLSTERY. Includes remove and install seat covering — (Factory cut to size).	1.6	_____
10-24	SEAT CUSHION — UPHOLSTERY. Includes remove and install covering — (Factory cut to size).		
	Front	2.0	_____
	Rear	1.5	_____
10-25	FRONT SEAT BACK — Upholstery. Includes remove and install covering — (Factory cut to size).	2.5	_____
WINDSHIELD			
10-26	WINDSHIELD GLASS AND/OR WEATHERSTRIP—Remove and Install.		
	With Outside Chrome Mouldings	2.3	_____
	Without Chrome Mouldings	1.8	_____
10-27	WINDSHIELD GARNISH MOULDING RIGHT OR LEFT —Remove and Install.	.3	_____
10-28	WINDSHIELD WIPER ARMS — Adjust Travel.	.3	_____
10-29	WINDSHIELD WIPER CONTROL KNOB ASSEMBLY — Remove and Install.	.3	_____
10-30	WINDSHIELD WIPER CABLES — Remove and Install. One	.6	_____
10-31	WINDSHIELD WIPER MOTOR — Remove and Install.	.3	_____
10-32	WINDSHIELD WIPER PULLEY HOUSING AND CABLE — Remove and Install.	.5	_____
10-33	WINDSHIELD WIPER CABLE TENSION PULLEY — Remove and Install.	.4	_____
10-34	WINDSHIELD WIPER AND WASHER CONTROL KNOB ASSEMBLY — Remove and Install.	.4	_____

OPERATION	DESCRIPTION	TIME	PRICE
ENGINE — Continued			
10-35	DOOR GLASS — Remove and Install.		
	Front	1.0	_____
	Rear	1.0	_____
10-36	DOOR VENTILATING WING GLASS — Remove and Install.		
	Front	1.3	_____
	Rear	1.3	_____
10-37	REAR WINDOW GLASS AND/OR WEATHERSTRIP — Remove and Install.		
	With Outside Chrome Mouldings	2.8	_____
	Without Chrome Mouldings	2.3	_____
10-38	DOOR GLASS RUN CHANNEL — Remove and Install.		
	Front	1.1	_____
	Rear	1.1	_____
10-39	DOOR WINDOW REGULATOR ASSEMBLY — Remove and Install.		
	Front	1.0	_____
	Rear	1.0	_____
10-40	CENTER BAR GLASS RUN — Remove and Install.	1.0	_____
10-41	WINDOW REGULATOR HANDLES OR ESCUTCHEONS — Remove and Install.	.2	_____
10-42	DOOR VENTILATING WING REGULATOR ASSEMBLY — Remove and Install.		
	Front	1.2	_____
	Rear	1.2	_____
10-43	DOOR WINDOW GARNISH MOULDING — Remove and Install		
	One	.2	_____
10-44	FRONT DOOR REVEAL MOULDING — Remove and Install	.8	_____
10-45	REAR DOOR REVEAL MOULDING — Remove and Install.	.8	_____
BODY INTERIOR TRIM			
10-46	DOOR WINDLACE — Remove and Install.		
	Complete Car	2.0	_____
	Each Door	.5	_____
10-47	FLOOR MAT (FRONT) — Remove and Install.	.3	_____
10-48	FLOOR MAT (REAR) — Remove and Install.	.3	_____
10-49	REAR COMPARTMENT FLOOR MAT — Remove and Install	.2	_____
10-50	COWL KICK PANEL — Remove and Install.	.3	_____
10-51	DOOR PILLAR POST TRIM PANEL — Remove and Install	.4	_____

OPERATION	DESCRIPTION	TIME	PRICE
BODY AND HARDWARE — Continued			
10-52	HEADLINING — Remove and Install.	9.0	_____
10-53	SUN VISOR — Remove and Install. One	.2	_____
10-54	ROOF PANEL INSULATION — Remove and Install.	9.2	_____
REAR COMPARTMENT DOORS			
10-55	REAR COMPARTMENT DOOR — Remove, Install and Align	1.0	_____
10-56	REAR COMPARTMENT DOOR WEATHERSTRIP—Remove and Install.	.7	_____
10-57	REAR COMPARTMENT DOOR NAME PLATE — Remove and Install	.3	_____
10-58	REAR COMPARTMENT DOOR LOCK ASSEMBLY — Remove and Install.	.4	_____
10-59	REAR COMPARTMENT CYLINDER LOCK — Remove and Install.	.2	_____
10-60	REAR COMPARTMENT DOOR HINGE — Remove and Install	.5	_____
10-61	REAR COMPARTMENT DOOR STRIKER — Remove and Install.	.2	_____
WEATHERSTRIPPING			
10-62	FRONT DOOR OPENING WEATHERSTRIP (UPPER) — Right or Left — Remove and Install.	.6	_____
10-63	FRONT DOOR OPENING WEATHERSTRIP (LOWER END) — Right or Left — Remove and Install	.4	_____
10-64	FRONT DOOR (FRONT) WEATHERSTRIP AT BELT LINE (5-RUBBER) — Remove and Install.	.2	_____
10-65	FRONT DOOR VENTILATING WING WEATHERSTRIP — Remove and Install.	1.2	_____
10-66	REAR DOOR WEATHERSTRIP (UPPER) — Remove and Install One	.6	_____
10-67	REAR DOOR WEATHERSTRIP (LOWER) — Remove and Install.	.4	_____
10-68	REAR DOOR BELT RUBBER WEATHERSTRIP — Remove and Install.	.2	_____
10-69	REAR COMPARTMENT DOOR WEATHERSTRIP — Remove and Install.	.7	_____

DESCRIPTION	TIME	PRICE
<p>The necessary time for each operation is shown after the area locations as indicated by numbers on the car print sketch below.</p> <p>The flat rate times shown are for complete sanding, priming and refinishing the area indicated on the sketch.</p> <p>The time allowances also includes either removing and installing or masking of mouldings or hardware and polishing out finish.</p>		



OPERATION NO.	AREA	PRICE
1	FRONT FENDER — (Upper One Side) — Refinish	1.4
2	HOOD — (Complete Area) — Refinish	2.8
3	ROOF PANEL — (Front) — Refinish	1.9
4	ROOF PANEL — (Rear) — Refinish	1.9
5	REAR COMPARTMENT DOOR — (Complete Area) — Refinish	1.9
6	FRONT FENDER LOWER — (One Side) — Refinish	.9
7	FRONT DOOR UPPER PANEL — (One Side) — Refinish	.9
8	FRONT DOOR LOWER PANEL — (One Side) — Refinish	.9
9	REAR DOOR UPPER PANEL — (One Side) — Refinish	.9
10	REAR DOOR LOWER PANEL — (One Side) — Refinish	.9
11	REAR FENDER UPPER PANEL — (One Side) — Refinish	1.4
12	REAR FENDER LOWER PANEL — (One Side) — Refinish.	.9
	COMPLETE CAR — (One-color) — Refinish	24.5
	COMPLETE CAR — (Two-tone) — Refinish	25.0

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

OPERATION	DESCRIPTION	TIME	PRICE
COOLING SYSTEM			
11-1	COOLING SYSTEM — Flush and Refill.	.5	_____
11-2	CYLINDER WATER JACKET PLUGS — Remove and Install.		
	Replace (3 Plugs)	1.3	_____
	Replace Front Plug	.5	_____
	Replace Center Plug	.6	_____
	Replace Rear Plug	.5	_____
11-3	RADIATOR CORE — Remove and Install.	.7	_____
11-4	RADIATOR DRAIN COCK — Remove and Install.	.3	_____
11-5	RADIATOR INLET HOSE — Remove and Install.	.4	_____
11-6	RADIATOR OUTLET HOSE — Remove and Install.	.4	_____
11-7	THERMOSTAT, HOUSING AND/OR GASKET — Remove and Install.	.5	_____
11-8	WATER PUMP ASSEMBLY — Remove and Install.	1.0	_____
11-9	WATER PUMP — Overhaul.	1.7	_____
11-10	FAN BLADES — Remove and Install	.3	_____
11-11	FAN BELT — Remove and Install and Adjust	.3	_____
11-12	FAN BELT — Adjust Only.	.2	_____
11-13	WATER DISTRIBUTING TUBE — Remove and Install.	3.0	_____
11-14	TEMPERATURE INDICATOR ELEMENT — Remove and Install. (Cylinder Head Unit).	.3	_____
11-15	TEMPERATURE GAUGE — Remove and Install — (Instrument Panel Unit).	.9	_____

OPERATION	DESCRIPTION	TIME	PRICE
EXHAUST SYSTEM			
12.1	EXHAUST MANIFOLD AND/OR GASKETS—Remove and Install. When necessary to drill out and replace broken stud, Add	1.8 .4	
12-2	EXHAUST MANIFOLD HEAT TUBE — Remove and Install	.3	
12-3	INTAKE MANIFOLD AND/OR GASKETS — Remove and Install.	1.8	
12-4	EXHAUST MANIFOLD DAMPER VALVE — Remove and Install	2.1	
12-5	INTAKE MANIFOLD TO CARBURETOR GASKETS — Remove Install.	.4	
12-6	EXHAUST PIPE FLANGE GASKET — Remove and Install.	.4	
12-7	EXHAUST PIPE (FRONT) — Remove and Install.	1.0	
12-8	EXHAUST PIPE (REAR) — Remove and Install.	1.0	
12-9	EXHAUST MUFFLER — Remove and Install.	1.0	
12-10	EXHAUST (AUXILIARY) MUFFLER — Remove and Install.	1.0	
12-11	EXHAUST TAIL PIPE — Remove and Install.	.6	
12-12	MUFFLER CLAMP (AT NO. 4 CROSSMEMBER) — Remove and Install	.3	
12-13	EXHAUST PIPE CLAMP TO ENGINE — Remove and Install	.3	
12-14	TAIL PIPE CLAMP — Remove and Install.	.3	
ELECTRICAL			
13-1	BATTERY — Remove and Install. New or Charging. Does not include recharging time.	.3	
13.2	BATTERY COVER — Remove and Install.	.2	
13-3	BATTERY CABLE TO STARTER MOTOR — Remove and Install.	.2	
13-4	BATTERY GROUND STRAP — Remove and Install.	.3	
13-5	BATTERY TERMINALS — Clean and Apply a Coating of Grease	.3	
GENERATOR			
13.6	GENERATOR ASSEMBLY — Remove and Install.	.5	
13-7	GENERATOR COMMUTATOR — Clean Commutator and Brushes and Adjust Charging Rate.	.5	
13-8	GENERATOR BRACKET — Remove and Install.	.6	
13.9	GENERATOR BRUSHES — Remove and Install. Includes remove and install generator.	1.1	

OPERATION	DESCRIPTION	TIME	PRICE
ELECTRICAL — Continued			
13-14	GENERATOR OVERHAUL — Remove and Install. Includes clean, repair and replace any necessary parts and test. If necessary to turn down commutator and undercut mica, Add	1.3 .5	
13-15	GENERATOR ARMATURE — Remove and Install.	1.0	
13-16	GENERATOR VOLTAGE REGULATOR — Remove and Install...	.4	
13-17	GENERATOR — Check Charging Rate	.3	
HORN			
13-10	HORN ASSEMBLY — Remove and Install. Right Horn Left Horn	.3 .7	
13-11	HORN RING — Remove and Install	.3	
13-12	HORN BUTTON WIRE — Remove and Install.	.3	
13-13	HORN RELAY — Remove and Install.	.2	
COIL, DISTRIBUTOR AND SPARK PLUGS			
13-18	COIL — Remove and Install	.3	
13-19	COIL — Test, Make Primary and Secondary Check. Includes remove and install.	.7	
13-20	DISTRIBUTOR ASSEMBLY — Remove and Install. Includes checking ignition timing.	.6	
13-21	DISTRIBUTOR ASSEMBLY — Overhaul. Includes remove and install. Replace any necessary parts, checking mechanical and vacuum advance, condenser, rotor, cap and setting ignition timing.	1.5	
13-22	DISTRIBUTOR CAP — Remove and Install	.2	
13-23	DISTRIBUTOR POINTS — Clean or Replace and Adjust. Includes checking ignition timing.	.6	
13-24	DISTRIBUTOR CONDENSER — Remove and Install.	.4	
13-25	DISTRIBUTOR VACUUM ADVANCE UNIT—Remove and Install. Includes checking ignition timing.	.7	
13-26	DISTRIBUTOR DRIVE SHAFT — Remove and Install. Includes checking ignition timing.	.8	
13-27	IGNITION CABLES — COMPLETE SET — Remove and Install	.5	
13-28	IGNITION SWITCH AND/OR LOCK — Remove and Install.	.3	

OPERATION	DESCRIPTION	TIME	PRICE
ELECTRICAL — Continued			
13-29	SPARK PLUGS — Remove and Install.	.3	_____
13-30	SPARK PLUGS — Remove, Clean, Adjust and Install.	.5	_____
LIGHTS			
13-31	HEADLIGHT ASSEMBLY — Remove and Install One — Adjust Two	.8	_____
13-32	HEADLIGHT SEALED BEAM UNIT — Remove and Install One. Includes adjusting beam.	.3	_____
13-33	PARKING LIGHTS — Remove and Install.		
13-34			
13-35		.7	_____
13-36		1.3	_____
13-37	Light Bulb (only) One	.1	_____
13-38	HEADLIGHTS — Adjust.	.2	_____
13-39	STOPLIGHT SWITCH — Remove and Install.	.3	_____
13-40	TAIL LIGHT GLASS — Remove and Install	.3	_____
	HEADLIGHT SWITCH AND/OR CIRCUIT BREAKER—Remove and Install.	.4	_____
	DOME LIGHT — LENS OR BULB — Remove and Install	.1	_____
	DOME LIGHT SWITCH — Remove and Install.		
	At Door	.2	_____
	At Pillar	.2	_____
	LICENSE LIGHT — LENS OR BULB — Remove and Install.	.2	_____
STARTER MOTOR			
13-41	STARTER BENDIX DRIVE — Remove and Install — With Starter Removed.	.3	_____
13-42	STARTER MOTOR ASSEMBLY — Remove and Install.	.4	_____
13-43	STARTER MOTOR ASSEMBLY — Overhaul. Includes remove and install, clean, replace any necessary parts.	1.8	_____
13-44	STARTER MOTOR SOLENOID — Remove and Install.	.3	_____
13-45	STARTER SWITCH AND IGNITION LOCK ASSEMBLY — Remove and Install.	.3	_____

OPERATION	DESCRIPTION	TIME	PRICE
ACCESSORIES			
14-1	BACK-UP LIGHT — Install.		
	2C — With Hydra-Matic Transmission	.8	_____
	2C — With Standard Transmission	1.0	_____
	1C — With Standard Transmission	1.7	_____
	1C — With Hydra-Matic Transmission	1.5	_____
14-2	BATTERY FILLER — Install.	.3	_____
14-3	CIGARETTE LIGHTER — Install.	.3	_____
144	CLOCK ELECTRIC — Install.	.6	_____
14-5	DIRECTION INDICATOR — Install — Complete.	2.5	_____
14-6	DIRECTION INDICATOR SWITCH AND WIRE ASSEMBLY—Remove	.7	_____
14-7	DIRECTION INDICATOR FLASHER SWITCH — Remove and Install.	.3	_____
14-8	OIL FILTER — Install — (Without Hydra-Matic Transmission) .	.5	_____
14-9	OUTSIDE REAR VIEW MIRROR — Install	.3	_____
14-10	RADIO ANTENNA — Install — Complete.	1.2	_____
14-11	RADIO ANTENNA — Remove and Install	.5	_____
14-12	RADIO ASSEMBLY — Install (Initial Installation). Includes antenna and speaker installation.	2.2	_____
14-13	RADIO ASSEMBLY — Remove and Install — (Includes speaker) .	1.0	_____
14-14	RADIO DIAL LIGHT BULB — Remove and Install.	.7	_____
14-15	RADIO REAR SEAT SPEAKER — Install	2.0	_____
14-16	RADIO RECEIVER — Remove and Install.	.7	_____
14-17	RADIO SPEAKER ASSEMBLY — Remove and Install	.5	_____
14-18	SEAT COVERS — Install.	1.6	_____
14-19	WEATHER CONTROL — Install — Complete Unit.	2.2	_____
14-20	WEATHER CONTROL RANCO VALVE — Remove and Install	.5	_____
14-21	WEATHER CONTROL MOTOR — Remove and Install.	.5	_____
14-22	WEATHER CONTROL CORE — Remove and Install.	1.3	_____
14-23	WEATHER CONTROL — CONTROL ASSEMBLY—Remove and Install.	.7	_____
14-24	WEATHER CONTROL MOTOR SWITCH — Remove and Install.	.4	_____
14-25	WHEEL TRIM RINGS — Install.	.3	_____
14-26	WINDSHIELD WASHER — Install.	1.0	_____

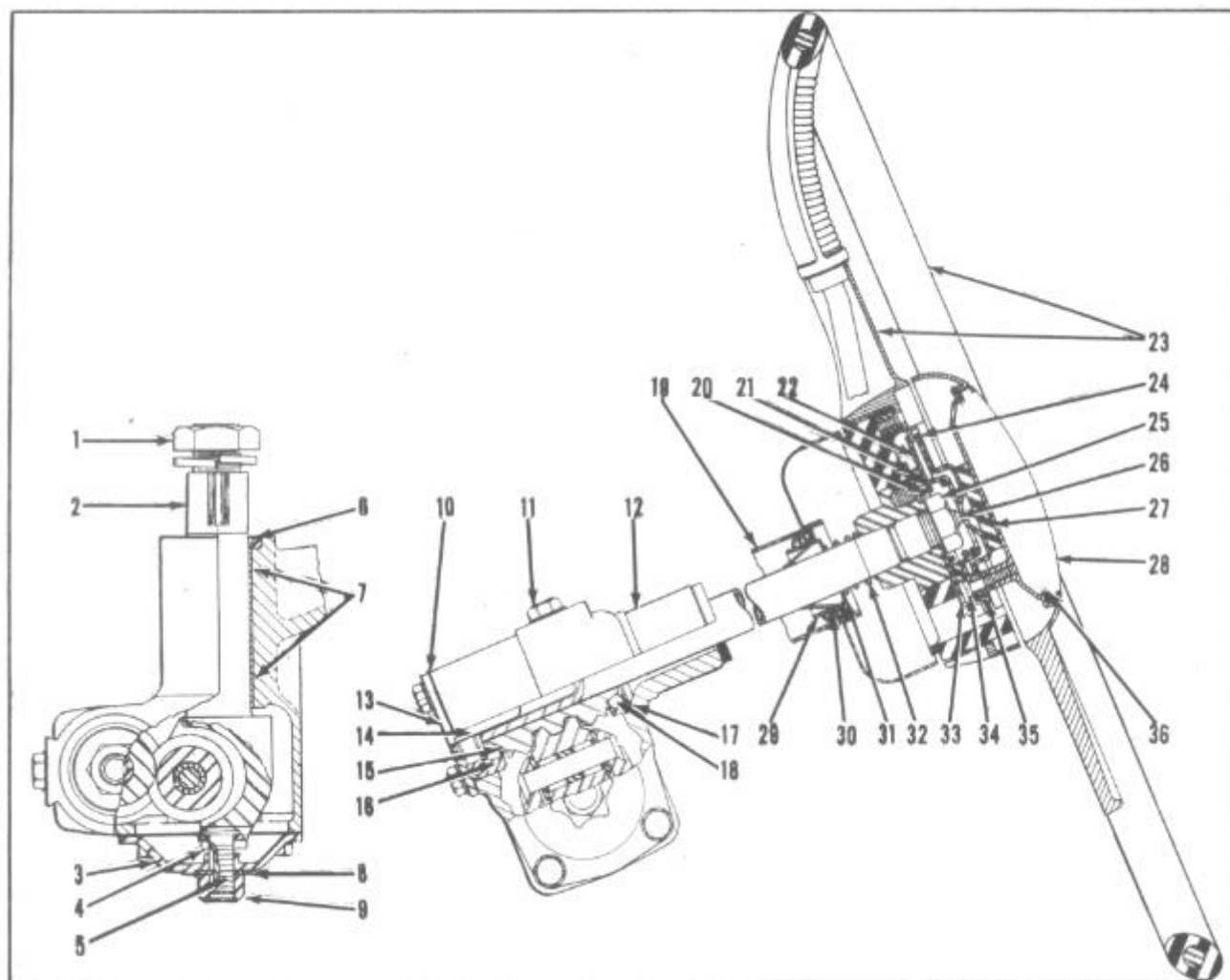
OPERATION	DESCRIPTION	TIME	PRICE
FRAME AND SHEET METAL			
FENDERS AND DOOR MOULDINGS			
15-1	FRONT FRAME ASSEMBLY — Remove and Install. Includes transfer front fenders and radiator assembly, engine, front suspension complete and clutch and brake pedals, master cylinder, etc. Breaking welds and reweld to No. 4 crossmember.		
	With Standard Transmission	11.8	_____
	With Overdrive Transmission	12.2	_____
	With Hydra-Matic Transmission	13.2	_____
15-2	FRONT FRAME NO. 3 CROSSMEMBER — Remove and Install. Includes disconnect hand brake, removing bolts at rear engine supports and frame. With Hydra-Matic Transmission (Only)	1.4	_____
15-3	FRONT FENDER — Remove and Install.	2.7	_____
15-4	FRONT FENDER NAME PLATE — Remove and Install.	.3	_____
15-5	FRONT FENDER SIDE DUST SHIELD — Remove and Install.		
	Right Side	.4	_____
	Left Side	.7	_____
15-6	GAS TANK FILLER DOOR — Remove and Install.	.3	_____
15-7	GAS TANK FILLER DOOR SPRINGS — Remove and Install... .	.2	_____
15-8	GAS TANK FILLER NECK GROMMET — Remove and Install	.2	_____
15-9	REAR WHEEL COVER — Remove and Install.	.2	_____
15-10	DOOR SCUFF PLATE — Remove and Install.	.3	_____
15-11	COWL VENTILATOR ASSEMBLY — Remove and Install.	.8	_____
HOOD			
15-12	HOOD — Remove, Install and Adjust.	.8	_____
15-13	HOOD — Adjust. Includes adjusting lower lock plate.	.4	_____
15-14	HOOD LOCK LOWER — Remove and Install and Adjust.	.3	_____
15-15	HOOD LOCK UPPER — Remove and Install and Adjust.	.3	_____
15-16	HOOD HINGE — Remove and Install. One.	.5	_____
15-17	HOOD HINGE SPRING — Remove and Install.	.3	_____
15-18	HOOD CREST ORNAMENT — Remove and Install.	.3	_____

OPERATION	DESCRIPTION	TIME	PRICE
FRAME AND SHEET METAL — Continued			
GRILLE			
15-19	GRILLE UPPER MOULDING — Remove and Install.	.5	_____
15-20	GRILLE UPPER LOUVER — Remove and Install.	1.1	_____
15-21	GRILLE LOWER LOUVER — Remove and Install.	1.2	_____
15-22	PARKING LIGHT ORNAMENT — Remove and Install. Right or Left	.7	_____
15-23	GRILLE ASSEMBLY — Remove and Install. Includes replacing all mouldings and louvers and both parking light ornaments and ornament extensions. If necessary to replace grill structure assembly, Add	2.5 1.5	_____ _____
15-24	RADIATOR MOUNTING CHANNEL ASSEMBLY — Remove and Install.	1.4	_____
15-25	PARKING LIGHT ORNAMENT EXTENSION — Remove and Install. Right or Left	.3	_____
INSTRUMENT PANEL AND INSTRUMENTS			
15-26	INSTRUMENT PANEL ASSEMBLY COMPLETE — Remove and Install.	4.0	_____
15-27	INSTRUMENT PANEL TOP COVERING (LEATHER) — Remove and Install.	2.5	_____
15-28	LOCKER BOX DOOR — Remove and Install.	.3	_____
15-29	LOCKER BOX — Remove and Install.	.4	_____
15-30	LOCKER BOX — Lock and Cylinder. Remove and Install.	.3	_____
15-31	HEADLIGHT SWITCH AND/OR CIRCUIT BREAKER. Remove and Install.	.4	_____
15-32	DIMMER SWITCH — Remove and Install.	.4	_____
15-33	STARTER MOTOR SWITCH — Remove and Install	.3	_____
15-34	REMOVE AND INSTALL ANY INSTRUMENT PANEL LIGHT BULB — (EXCEPT HIGH BEAM BULB)	.2	_____
15-45	HIGH BEAM BULB — Remove and Install.	1.0	_____
15-36	FUEL OR TEMPERATURE GAUGE — Remove and Install.	.9	_____
15-37	SPEEDOMETER HEAD— Remove and Install.	1.0	_____
15-38	SPEEDOMETER LENS — Remove and Install.	1.1	_____
15-39	SPEEDOMETER CABLE — Remove and Install.	.4	_____
15-40	SPEEDOMETER CABLE AND HOUSING — Remove and Install.	.7	_____
15-41	SPEEDOMETER DRIVE PINION — Remove and Install.	.3	_____

OPERATION	DESCRIPTION	TIME	PRICE
BUMPERS			
16-1	FRONT BUMPER — INCLUDES GUARDS — Remove and Install.	.6	_____
16-2	FRONT BUMPER IMPACT BAR TO FRAME — Remove and Install.	.8	_____
16-3	REAR BUMPER — INCLUDES GUARDS — Remove and Install.	.6	_____
16-4	BUMPER GUARD — Remove and Install — (One). Front or Rear	.2	_____
16-5	REAR BUMPER IMPACT BAR TO FRAME — Remove and Install.	.8	_____
16-6	LICENSE PLATE BRACKET ASSEMBLY — Remove and Install Front or Rear	.2	_____
16-7	REAR SPLASH GUARD — Remove and Install.	.9	_____
REAR SUSPENSION			
17-1	REAR SPRING — Remove and Install.		
	One	1.4	_____
	Two	2.7	_____
17-2	REAR SPRING LEAF — Remove and Install.		
	One Spring	2.2	_____
	Two Springs	4.3	_____
17-3	REAR SPRING SHACKLE AND/OR BUSHING — Remove and Install.		
	One Spring	.4	_____
	Two Springs	.8	_____
17-4	REAR SPRING (FRONT) BUSHING OR PIN — Remove and Install.		
	One Spring	.5	_____
	Two Springs	.9	_____
17-5	REAR SPRING MOUNTING CLIPS — Remove and Install.		
	One Spring	.6	_____
	Two Springs	1.1	_____
17-6	REAR SPRING MOUNTING CLIPS — Tighten.	.4	_____
17-7	SPRING SHACKLE BUSHINGS AND SPRING CLIPS — Tighten.	.6	_____
17-8	REAR SHOCK ABSORBERS AND /OR BUSHINGS — Remove and Install.		
	One	.6	_____
	Two	1.0	_____

OPERATION	DESCRIPTION	TIME	PRICE
FUEL SYSTEM			
18-1	CARBURETOR ASSEMBLY — Remove and Install.	.4	_____
18-2	CARBURETOR ASSEMBLY — Overhaul — (When Removed from Engine) .	2.0	_____
18-3	CARBURETOR ASSEMBLY — Remove and Install. Includes disassembly and assembly, clean and overhaul, replace necessary parts and adjust.	2.4	_____
184	CARBURETOR ASSEMBLY — Check With Vacuum Gauge.	.3	_____
18-5	CARBURETOR FLOAT OR NEEDLE VALVE — Remove and Install. Includes adjusting float level, remove and install carburetor	.7	_____
18-6	CARBURETOR AUTOMATIC CHOKE — Remove and Install. Includes cleaning and overhaul.	.7	_____
18-7	CARBURETOR AIR CLEANER — Remove and Install. Oil Bath — Refill Dry — Clean	.4 .2	_____ _____
18-8	CARBURETOR IDLE PORT PLUGS AND METERING RODS — Install.	.5	_____
18-9	STANDARD FUEL PUMP AND/OR GASKET — Remove and Install.	.9	_____
18-10	STANDARD FUEL PUMP — Overhaul — (When Removed from Car) .	.8	_____
18-11	COMBINATION FUEL PUMP AND/OR GASKET — Remove and Install.	1.0	_____
18-12	COMBINATION FUEL PUMP — Overhaul — (When Removed from Car).	1.0	_____
1-813	FUEL PUMP FLEXIBLE HOSE — Remove and Install.	.4	_____
18-14	GAS LINE, FUEL PUMP TO TANK — Remove and Install.	.7	_____
18-15	GAS LINE, FUEL PUMP TO CARBURETOR — Remove and Install.	.2	_____
18-16	GASOLINE GAUGE DASH UNIT — Remove and Install.	.9	_____
18-17	GASOLINE TANK GAUGE — Remove and Install.	.6	_____
18-18	GASOLINE TANK — Remove, Clean and Install.	1.5	_____

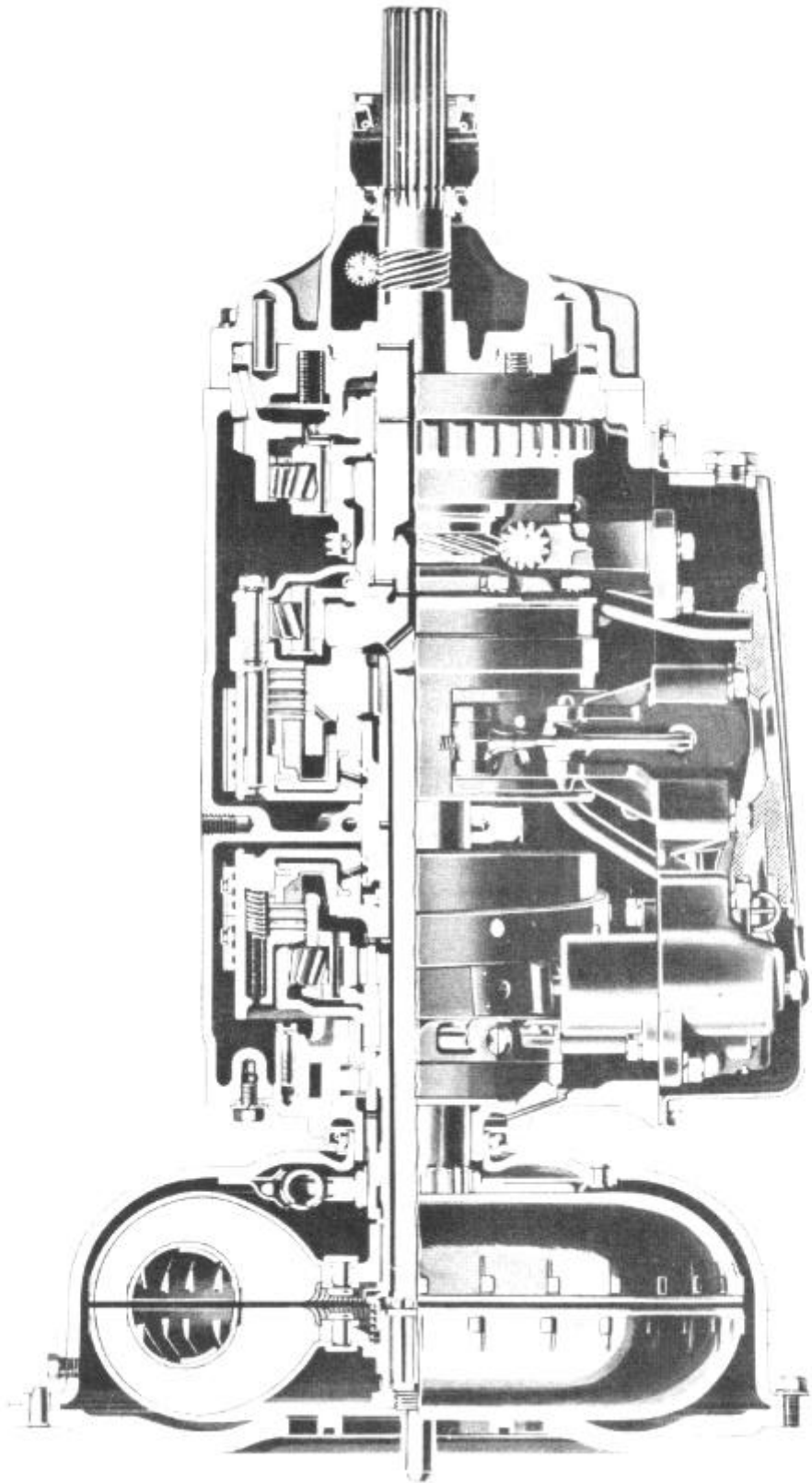
OPERATION	DESCRIPTION	TIME	PRICE
LUBRICATION AND INSPECTION			
19-1	LUBRICATION — Complete.	.5	_____
19-2	PRE-DELIVERY INSPECTION AND ADJUSTMENTS.	4.8	_____
19-3	1,000 MILE INSPECTION AND ADJUSTMENTS.	2.0	_____
19-4	2,000 MILE INSPECTION AND ADJUSTMENTS.	4.0	_____
19-5	DIFFERENTIAL — Drain, Flush and Refill.	.4	_____
19-6	FRONT WHEEL BEARINGS — Clean, Repack and Adjust— (Both Sides)	.6	_____
19-7	REAR WHEEL BEARINGS — Clean, Repack and Adjust — (Both Sides)	3.0	_____
19-8	REAR SPRINGS WITH COVERS — Lubricate.	.5	_____
19-9	STEERING GEAR — Lubricate.	.3	_____
19-10	TRANSMISSION — Drain, Flush and Refill. Standard Transmission	.4	_____
19-11	TRANSMISSION — Drain and Refill. Hydra-Matic Transmission.	.7	_____
STEERING			
20-1	STEERING GEAR ASSEMBLY — Remove and Install.	3.0	_____
	With Directional Indicator, Add	.3	_____
20-2	STEERING GEAR — Adjust. Complete. Includes disconnect drag-link adjust end play of sector shaft, adjust toe-in, set gear on high spot	1.6	_____
20-3	STEERING GEAR — Tighten to Frame.	.3	_____
20-4	STEERING GEAR — Overhaul — (On Bench) .	1.2	_____
20-5	STEERING JACKET TUBE AND BEARING ASSEMBLY — Remove and Install.	1.2	_____
20-6	STEERING JACKET TUBE BEARING — Remove and Install	.8	_____
20-7	STEERING WHEEL — Remove and Install	.5	_____
20-8	STEERING PITMAN ARM — Remove and Install	.7	_____
20-9	STEERING GEAR SECTOR SHAFT — Adjust End Play.	.6	_____
20-10	STEERING GEAR ASSEMBLY — Overhaul. Includes remove and install assembly.	4.2	_____
20-11	STEERING HORN BUTTON OR HORN RING — Remove and Install.	.2	_____
20-12	STEERING GEAR SECTOR SHAFT — Remove and Install.	1.3	_____
	To replace oil seal, Add	.2	_____



STEERING GEAR — CROSS SECTION

LEGEND

- | | |
|----------------------------------|--|
| 1. Gear shaft nut | 19. Steering jacket tube assembly |
| 2. Gear shaft | 20. Index plate spring |
| 3. Gear shaft cover | 21. Index plate shock pad |
| 4. Adjusting screw thrust plate | 22. Index plate |
| 5. Adjusting screw | 23. Steering wheel assembly |
| 6. Oil seal | 24. Horn button contact cup |
| 7. Bushings | 25. Steering wheel nut |
| 8. Adjusting screw lock plate | 26. Horn wire assembly |
| 9. Adjusting screw lock nut | 27. Pressure contact pad |
| 10. Worm cover shims | 28. Horn button and horn ring |
| 11. Oil filler plug | 29. Jacket tube bearing retaining spring |
| 12. Housing | 30. Jacket tube bearing assembly |
| 13. Worm shaft cover | 31. Jacket tube bearing spacer |
| 14. Grease retainer tube | 32. Jacket tube bearing spring |
| 15. Worm shaft lower bearing | 33. Horn ring blowing cam |
| 16. Worm shaft lower bearing cup | 34. Horn ring screw |
| 17. Worm shaft upper bearing cup | 35. Insulator step washer |
| 18. Worm shaft upper bearing | 36. Steering wheel horn button spacer |



HYDRA-MATIC TRANSMISSION — CROSS SECTION

OPERATION	DESCRIPTION	TIME	PRICE
HYDRA-MATIC TRANSMISSION			
21-1	TRANSMISSION ASSEMBLY — Remove and Install. Includes removing and installing propeller shaft removing No. 3 crossmember	4.9	_____
21-2	TRANSMISSION ASSEMBLY — Remove and Install. Includes removing and installing propeller shaft, removing No. 3 crossmember, also removing torus members, flywheel cover, and bell housing and installing on new transmission	5.4	_____
21-3	TRANSMISSION ASSEMBLY — Overhaul. Includes removing and install transmission, No. 3 crossmember, thoroughly cleaning, disassembling and inspecting all units, replacing any necessary parts and making all adjustments	12.8	_____
21-4	TRANSMISSION ASSEMBLY — Overhaul. Includes removing and installing transmission, No. 3 crossmember, disassembly and inspection and reassembly. (By Units)	8.8	_____
21-5	TRANSMISSION ASSEMBLY—Inspect. Includes removing, cleaning and installing transmission oil pan, inspecting front and rear drums, rear pump drive gear, inspecting oil pan and oil for metal cuttings. Cancel this operation if replacements are authorized	1.5	_____
21-6	HYDRA-MATIC TRANSMISSION—Drain and Refill.	.7	_____
21-7	TORUS COVER AND/OR SEAL — Remove and Install. Includes remove and install propeller shaft, transmission with flywheel housing and torus members and replacing seal	5.4	_____
FLYWHEEL AND HOUSING			
21-8	FLYWHEEL—Remove and Install. (When Transmission is Removed.)	.5	_____
21-9	FLYWHEEL HOUSING — Remove and Install — (When Transmission is Removed)	.5	_____
21-10	MAINSHAFT BUSHING IN FLYWHEEL—Remove and Install — (When Transmission is Removed)	.7	_____
REGULATOR VALVE, OIL PUMPS AND GOVENOR			
21-11	FRONT OIL PUMP ASSEMBLY — Overhaul. Includes removing and installing transmission and checking torus cover run out.	6.5	_____
21-12	FRONT OIL PUMP — Remove and Install. Includes removing and installing transmission assembly.	6.0	_____

OPERATION	DESCRIPTION	TIME	PRICE
HYDRA-MATIC — Continued			
21-13	OIL PRESSURE — Check. Includes remove and install floor mat and inspection hole cover.	.6	_____
21-14	OIL PRESSURE REGULATOR VALVE BODY SPRING AND/OR PLUNGER — Remove and Install. Includes remove and install floor mat and access hole cover.	.8	_____
21-15	REAR OIL PUMP AND GOVERNOR ASSEMBLY — Remove and Install. Includes making necessary adjustments.	2.0	_____
21-16	REAR OIL PUMP AND GOVERNOR. Includes removing, cleaning and installing side cover and bottom oil pan with screen. Removing and installing valve body and correcting governor run-out, includes removing and installing parking brake bracket assembly.	3.1	_____
21-17	TRANSMISSION BOTTOM OIL PAN AND/OR GASKET — Remove and Install.	.7	_____
21-18	FRONT PUMP COVER OIL SEAL — Remove and Install. Includes remove and installing transmission and replacing seal and/or oil rings.	6.7	_____
21-19	TRANSMISSION OIL PUMP ASSEMBLIES — (FRONT AND REAR). Includes remove and install transmission and disassembly and reassembly of both pumps and governor, cleaning oil pan and making necessary adjustments.	9.6	_____
21-20	TRANSMISSION GOVERNOR — Overhaul. Includes remove and install side cover, valve body and governor, replace necessary parts and check governor runout.	2.6	_____
21-21	REAR OIL SEAL — Remove and Install.	.7	_____
CONTROL VALVE			
21-22	CONTROL VALVE ASSEMBLY — Remove and Install. Includes removing and installing valve body and adjusting manual and throttle control levers	1.8	_____
21-23	CONTROL VALVE ASSEMBLY — Disassemble. Includes clean out and assemble, oil pressure check, adjust control linkage and neutral switch.	2.6	_____
21-24	CONTROL VALVE — INSIDE THROTTLE VALVE LEVER ASSEMBLY — Remove and Install. Includes removing and installing control valve assembly, adjusting manual and throttle control levers.	2.2	_____
21-25	TRANSMISSION SIDE COVER GASKET — Remove and Install.	.8	_____

OPERATION	DESCRIPTION	TIME	PRICE
HYDRA-MATIC — Continued			
PLANETARY UNITS			
21-26	TRANSMISSION CLUTCH PLATE ASSEMBLIES — Overhaul. Includes removing, disassembling, assembling and installing transmission and making all necessary adjustments. Does not include disassembly of other units. .	9.6	_____
21-27	INTERMEDIATE SHAFT — Remove and Install. Includes removing, disassembling, assembling and installing transmission, No. 3 cross-member and make all necessary adjustments	9.3	_____
21-28	FRONT UNIT DRIVE GEAR — Remove and Install. Includes removing and installing transmission, No. 3 crossmember, servo units, includes replacing front oil seal and adjusting servo bands.	9.0	_____
21-29	PARKING BRAKE BRACKET ASSEMBLY — Remove and Install. Includes removing and installing valve body and adjusting servo bands.	2.8	_____
21-30	REVERSE UNIT ASSEMBLY — Overhaul. Includes removing and installing oil pan and side cover, oil pump and governor assembly	5.3	_____
21-31	SPEEDOMETER DRIVE GEAR — (Integral with Mainshaft) — Remove and Install.	5.5	_____
SERVOS			
21-32	SERVO — (FRONT OR REAR) — Remove and Install. Includes remove and install the bottom oil pan and adjustment of both servos.	1.7	_____
21-33	SERVO (FRONT) — Overhaul. Includes remove, install, cleaning — bottom oil pan and install new gasket and adjust both bands.	2.0	_____
21-34	SERVO — (REAR) — Overhaul. Includes remove, install new gasket and adjust both bands.	2.0	_____
21-35	SERVOS — (BOTH) — Overhaul. Includes remove, install and adjust, cleaning bottom oil pan and install new gasket	2.5	_____
21-36	SERVO BANDS — Replace One or Both. Includes remove and install transmission and units necessary to enable band replacement and adjustment of band.	8.6	_____

OPERATION	DESCRIPTION	TIME	PRICE
HYDRA-MATIC — Continued			
SHIFT CONTROL LEVER			
21-37	CONTROL SHIFT LEVER — Remove and Install.	.3	_____
21-38	CONTROL SHIFT LEVER AND HOUSING — Remove and Install. Includes remove and install steering wheel and setting quadrant with selector switch.	2.0	_____
21-39	QUADRANT INDICATOR PIN — Remove and Install.	.7	_____
ADJUSTMENTS			
21-40	ENGINE IDLE SPEED ADJUSTMENT.	.1	_____
21-41	THROTTLE LINKAGE ADJUSTMENT. Lever at Transmission	.4	_____
	Lever at Engine	.1	_____
21-42	SHIFTER ROD ADJUSTMENT.	.2	_____
21-43	NEUTRAL LIMIT SWITCH ADJUSTMENT	.1	_____
21-44	EXTERNAL BAND ADJUSTMENT.	.6	_____
21-45	INTERNAL BAND ADJUSTMENT.	1.3	_____
21-46	OIL LEVEL AND BAND ADJUSTING SCREWS — Check.	.2	_____
21-47	OIL LEAK — Check.	.2	_____
21-48	ROAD TEST.	.6	_____
21-49	MANUAL CONTROL AND THROTTLE CONTROL ADJUSTMENT — Check.	.2	_____
21-50	SERVOS — Adjust Front and Rear.	.4	_____

CONVERSION TABLE

Hour	\$ 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

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

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Service Manager.....

SUGGESTED CHANGE IN FLAT RATE TIME

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

DISTRIBUTOR OR DEALER.....

CITY AND STATE.....

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

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

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Service Manager.....

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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.

SUGGESTED CHANGE IN FLAT RATE TIME

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

DATE

DISTRIBUTOR OR DEALER.....

CITY AND STATE.....

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

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

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

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

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Service Manager.....

SUGGESTED CHANGE IN FLAT RATE TIME

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

DISTRIBUTOR OR DEALER.....

CITY AND STATE.....

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

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

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

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Service Manager.....

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