

**INVOICING TIMES**



**CITROËNA** 

**"D" ALL TYPES**

**INVOICING**

**TIMES**

# USE OF THE INVOICING TIME SCHEDULE

In automobile repair work, two types of work can occur :

- Routine Maintenance and running repairs, on the one hand,
- Accident repairs, on the other.

The invoicing times in this Schedule are arranged according to each category.

## 1° - ROUTINE MAINTENANCE AND RUNNING REPAIRS :

- Maintenance
- Adjustments
- Tuning
- Replacement of components
- Overhaul

## 2° - ACCIDENT REPAIRS

These repairs can include mechanical, electrical, trimming, body and paint work, and can vary according to the severity and area of impact. You should therefore consult the section entitled **IMPACT AREAS**, the vehicle being divided into 4 Impact Areas, and for extreme cases the **BODY SHELL** section.

a) According to the severity and direction of the impact, repairs may include **MECHANICAL** work, namely ;

- **COMPLEMENTARY** : See **COMPLEMENTARY MECHANICAL OPERATIONS**
- **COMPLETE** : See **ROUTINE MAINTENANCE AND RUNNING REPAIRS**

b) **PAINT** repairs are dealt with in the summary table at the end of the Schedule.

## SUMMARY OF CONTENTS

Page	3	- USE OF THE SCHEDULE intended for use by the <b>WORSHOPS OF THE CITROEN NETWORK</b>
	4	- <b>AGREEMENT BETWEEN CITROEN and S.R.A.</b>
	6	<b>CHECKS, ADJUSTMENTS, and TESTS</b>
	7	<b>ROUTINE MAINTENANCE and RUNNING REPAIRS</b>
		<b>COMPLEMENTARY MECHANICAL OPERATIONS</b>
	14	- Complete engine
	15	- Work on the engine
	16	- Auxiliary equipment for engine
	17	- Hydraulic equipment
	18	- Gearbox
	19	- Front Axle
	20	- Rear Axle
		<b>IMPACT AREAS</b>
	22	- Front impact
	26	- Side impact
	30	- Rear impact ( Saloon )
	33	- Rear impact ( Estate )
	36	- Interior impact
	38	- Complete Body
	39	- <b>PAINTWORK</b>

# USE OF THE SCHEDULE

intended for use by the  
**WORKSHOPS OF THE CITROEN NETWORK**  
( rights of reproduction reserved )

The new layout of this Schedule is intended to provide on the one hand information to the Repairer to assist him in establishing rapidly his invoice times for Mechanical and Body Repair Work, and, on the other hand, information to the Customer.

The times in this Schedule, expressed in Hours and Hundredths of an hour, are **INVOICING TIMES**.

They cancel and replace those which dealt with « D » Models in the Times Schedule 08.388.

**These Times apply when invoicing :**

- Customer and insurance Repairs
- Guarantee work
- « Company » Work

**These Times include all the work necessary for correct execution of the operations, namely :**

- Reception and Diagnosis
- Making out Repair Orders
- Preparation and distribution of work
- Execution of the work
- Examination and making out requisition for components needing replacement
- Checking work during and after its execution
- If necessary, making out quotations.

## ROAD TESTING

When a road test is required after repairs, it is necessary to add, for each Repair Order :

- Short test . 0.25 hr Code ref. 01.780
- or Complete test 0.50 hr Code ref. 01.782
- or Extended test 1.00 hr Code ref. 01.784

## ESTIMATES

When preparing estimates, operations of adjustment and bleeding must only be mentioned once, so as to avoid cumulation.

## PAINT

Times for putting the work in hand, preparing the paint, cleaning the spraygun and cup, are not included in the Paint Times; for each Repair Order it is necessary to add 0.70 hrs. Code ref. 31.501.

## ABBREVIATIONS

- |             |                             |            |                                     |
|-------------|-----------------------------|------------|-------------------------------------|
| - adj.      | = adjust (ment)             | - inject   | = Electronic Fuel Injection         |
| - assem.    | = assemble                  | - LH       | = Left-hand                         |
| - assy.     | = assembly                  | - mech.    | = manual ( steering or gearchange ) |
| - carb.     | = carburettor               | - man.     | = manual ( steering or gearchange ) |
| - disassem. | = disassemble               | - PMP      | = Partial Tune-up                   |
| - ECU       | = Electronic Control Unit   | - RH.      | = Right-hand                        |
| - EFI       | = Electronic Fuel Injection | - reassem. | = reassemble                        |
| - est.      | = estate                    | - recon.   | = recondition                       |
| - excl.     | = excluding                 | - rem/ref  | = remove and refit                  |
| - F         | = front                     | - replt.   | = replacement                       |
| - hyd.      | = hydraulic                 | - sal.     | = saloon                            |
| - incl.     | = including                 | - supplt.  | = supplement (ary)                  |

### Categories of labour

- |                 |                      |
|-----------------|----------------------|
| E : Electrical  | P : Paint            |
| F : Body repair | S : Trimming         |
| M : Mechanical  | T : Sheet-metal work |

## **AGREEMENT BETWEEN CITROEN AND S. R.A.**

**The times in this Schedule were the subject of an agreement signed in February 1975 by, CITROEN and the French Organisation S.R.A. representing the French Motor Vehicle Insurance Companies, to give a common basis for establishing repair times, for Repair Workshops, for Insurance Claims, and for Insurance Assessments.**

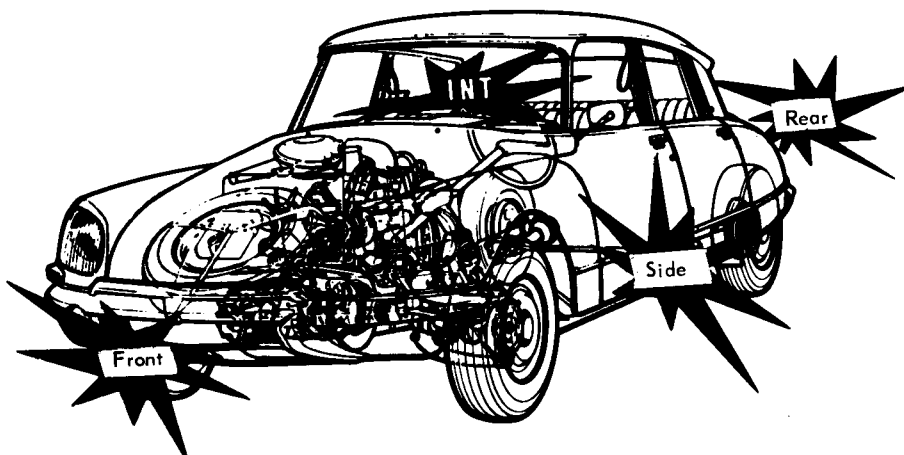
# invoicing times

# CITROËN

## complementary mechanical operations

These operations are complementary to the routine maintenance and running-repair operations and also to accident-repair operations classified in the impact-area section. They are so drawn up so as to avoid duplication of times.

## IMPACT AREAS



CHECKS, ADJUSTMENTS AND TESTS

Page 6 \_\_\_\_\_

ROUTINE MAINTENANCE and RUNNING REPAIRS

Page 7 \_\_\_\_\_

ENGINE OPERATIONS  
ENGINE ACCESSORIES

Pages 14-16 \_\_\_\_\_

HYDRAULIC EQUIPMENT  
GEARBOXES

Pages 17-18 \_\_\_\_\_

AXLE, FRONT

AXLE, REAR

Pages 19-20 \_\_\_\_\_

IMPACT, FRONT

Pages 22 - 25 \_\_\_\_\_

IMPACT, SIDE

Pages 26 - 29 \_\_\_\_\_

IMPACT, REAR

Pages 30 - 35 \_\_\_\_\_

IMPACT, INTERNAL

Pages 36 - 37 \_\_\_\_\_

BODY SHELLS

Page 38 \_\_\_\_\_

PAINT

Page 39 \_\_\_\_\_

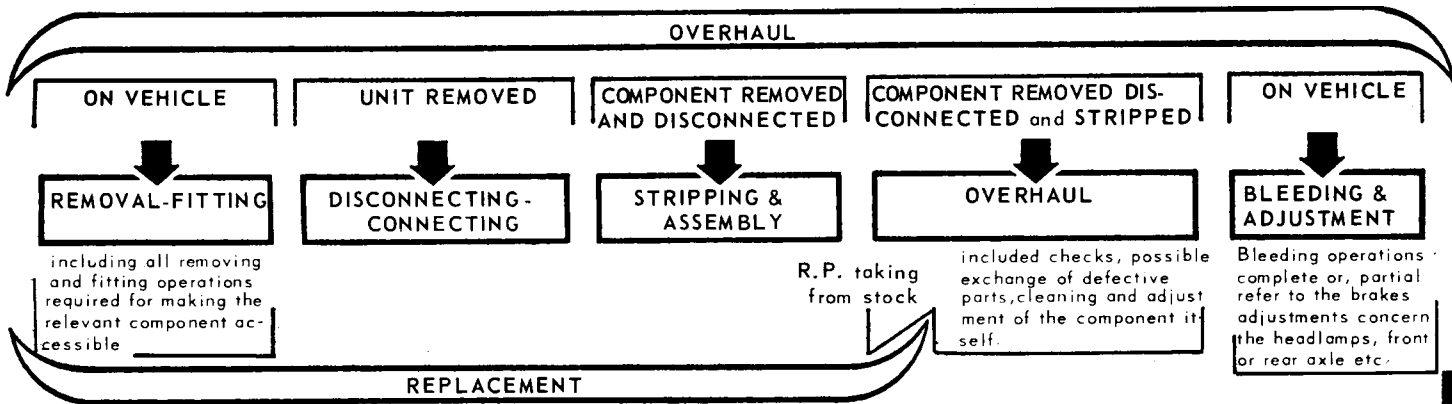
# CHECKS, ADJUSTMENTS AND TESTS



TIMES expressed in hours and hundredths of an hour

Operation	Code	Time
BRAKES - Complete bleed .....	Mec. 25.005	0.35
	Hyd. 25.005	0.45
PARKING BRAKE CABLE - Adjust .....	Mec. 25.601	0.45
	Hyd. 25.601	0.65
BRAKE CAM-ADJUSTERS REAR-Adjust .....	25.435	0.25
CLUTCH CLEARANCE - Adjust .....	Mec. 08.001	0.15
BASIC SETTINGS .....	Carb. Hyd. 08.276	0.50
	Inject. Hyd. 08.276	1.05
HEADLIGHTS- .....	Self Levelling 53.797	0.30
	Directional & Self Levelling 53.490	0.50
HEIGHTS - FRONT .....	Check 23.001	0.35
	Check & Adjust 23.003	0.50
HEIGHTS - REAR .....	Check 23.005	0.35
	Check & Adjust 23.007	0.70
HEIGHTS - FRONT & REAR .....	Check 23.010	0.45
	Check & Adjust 23.012	0.90
MANUAL HEIGHT CONTROL-Adjust incl. check heights, remove and refit L.H.F. wing and adjust lights .....	43.001	1.65
STEERING ALIGNMENT(Projection equipment) Check .....	24.010	0.35
	Check & Adjust 24.013	0.45
CAMBER - Front incl. checking heights ..	Check 24.017	0.70
incl. remove and refit 1 wing ....	Check & Adjust 24.020	2.30
LOCK ANGLE - .....	Check 24.024	0.10
LOCK ANGLE- including remove & refit R.H.F. Wing and adjust lights .....	Check & Adjust 24.025	1.25
FRONT AXLE GEOMETRY-Check with projec- tion equipment comprising check camber, castor toe-in, lock angle - not incl. check heights .....	24.030	0.85
	including Check Heights 20.001	1.30
REAR AXLE GEOMETRY-Check comprising : alignment of front axle to rear axles, toe-in and rear camber,not incl. check heights .....	21.001	0.70
FRONT-REAR AXLE GEOMETRY - Check with projection equipment As per op. n° 20.001 plus check alignment of front-axle to rear-axle, check rear toe-in and camber .....	20.003	1.70
+ Supplt. additional to operations 20.001 & 20.003		
- HEIGHTS front & rear - Adjust. ....	23.009	0.45
- LOCK-ANGLE Adjust incl. remove & refit 1 wing .....	24.026	1.25
- CAMBER Adjust. incl. remove & refit 1 wing ..	24.022	1.60
- TOE-IN Adjust .....	24.011	0.25
OIL - Consumption test .....	01.786	3.25
FUEL - Consumption test .....	01.787	1.00
BRAKE TEST ON ROLLING ROAD-placing ve- hicle in position and checking .....	01.793	0.70
POWER TEST ON ROLLING ROAD-placing ve- hicle in position and taking readings D. Carb.	01.792	1.50
	D. Injec. 01.792	1.10
ELECTRONIC CHECK .....	01.301	1.50
ROAD TEST - Short .....	01.780	0.25
ROAD TEST - Complete .....	01.782	0.50
ROAD TEST - Extended .....	01.784	1.00

Before looking for the operation concerned, please take note of the significance of some expressions defined below.



This ROUTINE MAINTENANCE & RUNNING REPAIRS section refers to complete operations which include work required to gain access to the component concerned (removal-fitting, draining, refilling etc.) and in addition the bleeding operations, checks and adjustments appropriate to the operation carried out. For several operations all requiring the same degree of access, or made easier by removal of a unit, use the COMPLEMENTARY MECHANICAL OPERATIONS specially drawn up to avoid duplication of times.

**TIMES** expressed in hours and hundredths of an hour

Operation	Code	Time	Operation	Code	Time
<b>TUNE UP</b>			<b>COMPLETE TUNE-UP</b> - Comprising replace sparking plugs, clean air filter, carburettor (on the vehicle) including adjusting float level, idling, remove and refit distributor, replace contacts, check and adjust on dist. test bench, adjust valve clearances, adjust clutch clearance (Mech.) or adjust basic settings (Hyd.) check levels of radiator, battery, engine and suspension.		
SIMPLE TUNE UP -- Comprising cleaning and adjusting sparking-plugs, carburettor (on the vehicle) including adjusting float level, idling, cleaning air filter, check points resistance, adjust dwell angle and timing. Adjust clutch clearance (Mech.) or adjust basic settings (Hyd.). Check levels of radiator, battery, engine and suspension					
D. Carb. - Mech.	01.001	2.75	D. Carb. - Mech.	01.004	3.70
D. Carb. - Hyd.	01.001	3.05	D. Carb. - Hyd.	01.004	4.00
D. Inject. - Mech.	01.001	2.20	D. Inject. - Mech.	01.004	3.70
D. Inject. - Hyd.	01.001	3.05	D. Inject. - Hyd.	01.004	4.70

Operation necessitating the removal and refitting of the ENGINE	Code	TIMES					
		D. CARB.			D. INJECT.		
		Mech.	Hyd.	Auto	Mech.	Hyd.	Auto
<b>ENGINE</b>							
ENGINE - Replace ..... not including P.M.P.	01.055	16.35	18.05	22.65	21.70	23.25	28.00
..... including P.M.P.	01.050	17.75	19.45	24.05	22.70	24.25	29.00
ENGINE - Overhaul - including P.M.P.							
..... not including cylinder head overhaul	01.037	30.00	31.65	36.30	33.90	36.15	39.30
..... including cylinder head overhaul	01.036	35.20	36.85	41.50	40.50	42.75	45.90
SUMP - Replace	01.072	12.10	12.90	17.70	15.45	16.20	21.00
+ Supplt. OIL PUMP - Replace	01.161	0.20	+ 0.20	+ 0.20	+ 0.20	+ 0.20	+ 0.20
OIL PUMP - Replace	01.707	12.30	13.10	17.90	15.65	16.40	21.20
TIMING CHAIN COVER - Replace	01.204	10.55	11.35	15.80	13.90	14.65	19.10
CHAIN TENSIONER - Replace	01.238	10.25	11.05	16.05	13.60	14.35	19.35
TIMING CHAIN - Replace	01.229	10.90	11.70	16.45	14.25	15.00	19.75
CAM-SHAFT - Replace	01.213	19.60	21.05	25.90	22.95	24.35	29.20
Same operation made following an examination of the tappets on the vehicle	01.220	22.05	23.50	—	25.40	26.80	—
BARRELS & PISTONS - Replacement including P.M.P.	01.153	21.15	21.95	26.65	24.10	24.85	29.25
+ Supplt. Cylinder head - Overhaul	01.433	+ 5.20	+ 5.20	+ 5.20	+ 6.60	+ 6.60	+ 6.60
CRANKSHAFT - Replace including P.M.P.	01.075	30.00	31.65	—	33.90	36.15	—

P.M.P. PARTIAL TUNE-UP - Comprising clean air filter, carburettor (except inject.) replace contact points with test-bench adjustment.

Carb.	01.005	1.40
Inject.	01.005	1.00



# ROUTINE MAINTENANCE AND RUNNING REPAIRS



TIMES expressed in hours and hundredths of an hour

Operations carried out on the vehicle		TIMES			
		D. Carb.		D. Inject.	
		Code	Mech.	Hydr.	Mech.
<b>ENGINE ( Cont. )</b>					
COMPRESSION - Check .....	01.007	0.70	0.70	1.05	1.05
REAR WATER COVER GASKET ( on head )-Replace .....	01.318	1.30	1.30	1.60	1.60
VALVE COVER and/or GASKET - Replace .....	01.309	0.50	0.50	1,20	1.20
VALVE CLEARANCES - Adjust .....	01.305 *	0.90	0.90	1.65	1.65
CYL. HEAD - Tighten down including adjust. valve clearances .....	01.342 *	1.05	1.05	1.80	1.80
SPARKING PLUG TUBE - Replace .....	01.313	1.40	1.40	1.90	2.10
Supplement each tube .....	01.314	+ 0.20	+ 0.20	+0.20	+0.20
ROCKER SPINDLES AND ARMS - Replace .....	INLET 01.717 *	2.90	2.90	3.65	3.65
EXHAUST .....	01.718 *	1.95	1.95	2.70	2.70
INL & EX. ....	01.329 *	3.65	3.65	4.40	4.40
HEAD GASKET - Replace or CYL. HEAD remove and refit .....	01.337 *	6.30	7.95	11.50	11.50
CYL. HEAD - Overhaul or replace with bare cylinder head .....	01.407 *	11.50	13.15	18.10	18.10
+ Supplement : Tappets - Replace .....	01.533	+ 0.35	+ 0.35	+ 0.35	+ 0.35
CAMSHAFT PULLEY - replace & refit or replace .....	01.281	4.75	4.75	5.00	5.00
CAMSHAFT BEARING - FRONT - Replace .....	01.255	4.90	4.90	5.15	5.15

(\* ) - + Supplement : ADJUST VALVE CLEARANCES ( on vehicles equipped with 5 speed gearbox ) + 0.25

Operation	Code	Times	Operation	Code	Times
<b>ENGINE AUXILIARY EQUIPMENT</b>			<b>TIMES FOR « D » INJECTION ONLY</b>		
<b>COOLING</b>			<b>SLOW RUNNING - Adjust .....</b>		
AIR DUCT - Replt. ....	Carb. 05.150	1.45	Mech. ....	03.175	0.10
Injct. ....	05.150	1.60	Hyd. ....	03.175	0.15
BOTTOM HOSE - Replace .....	05.023	0.85	FUEL FILTER at PUMP - .....	Replace 03.105	1.00
TOP HOSE on THERMOSTAT - replace....	05.075	0.45	FUEL PUMP .....	Replace 03.052	1.75
WATER TEMPERATURE TRANSMITTER- replt. ....	05.123	0.70	AIR FILTER ELEMENT - Remove, refit & clean .....	03.027	0.45
WATER PUMP/ALTERNATOR BELT -replt. except DS 23 and Injct. ....	11.035	0.30	Replace .....	03.107	0.30
DS 23 and Injct. ....	11.035	0.80	AIR FILTER .....	Replace 03.022	0.40
RADIATOR - Replace .....	05.005	1.40	THROTTLE VALVE HOUSING - .....	Replace 03.275	1.65
except DS 23 and Injct. ....	05.005	2.35	ACCELERATOR CABLE .....	Replace 03.181	1.45
FAN on WATER PUMP - Replace .....	05.012	0.20	INJECTOR HARNESS .....	Replace 03.186	1.40
except DS 23 and Injct. ....	05.012	0.70	E.C.U. HARNESS .....	Replace 03.187	2.40
WATER PUMP OR GASKET - Replace .....	05.035	2.00	COMPLETE INJECTION HARNESS .....	Replace 03.188	3.40
except DS 23 and Injct. ....	05.035	2.90	SUPPLEMENTARY AIR CONTROL .....	Replace 03.151	2.25
+ Supplement WATER PUMP COVER -replt. Mech. ....	05.038	+0.65	FAST IDLE DEVICE .....	Replace 03.153	2.75
Hyd. ....	05.038	+1.00	CHECK OF ELECTRONIC INJECTION CIRCUIT .....	01.302	2.25
MOTOR or FAN electric - Replace .....	05.175	2.10	E.C.U. following a check - .....	Replace 03.169	0.75
DS 23 and Injct. ....	05.115	0.50	HOSE FROM CYL. HEAD TO S.A.C. ....	Replace 03.140	0.75
WATER FEED TANK - Replace .....	05.116	0.55	HOSE FROM WATER PUMP TO S.A.C. ....	03.142	1.20
SILENT BLOCKS OF WATER FEED TANK replt. ....	05.116	0.55	INJECTOR N°1 or N° 2 cyl. ....	Replace 03.253	1.00
LUBRICATION			INJECTOR N° 3 cyl. - Replace ....	Mech. 03.257	1.25
OIL PRESSURE SWITCH - Replace .....	Carb. 01.675	1.50	Hyd. ....	03.257	1.75
Injct. ....	01.675	2.60	INJECTOR N° 4 cyl. ....	Replace 03.259	1.25
CRANKCASE BREATHER ON GASKET - replt. ....	01.635	0.90	INJECTORS Complete set. - Replace - Mech. ....	03.261	4.75
OIL COOLER - Replace - .....	Injct. 05.057	6.25	Hyd. ....	03.261	5.25
FUEL SUPPLY			COLD START INJECTOR .....	Replace 03.155	0.40
SLOW RUNNING - Adjust - .....	Mech. 03.175	0.10	FULL LOAD SWITCH .....	Replace 03.263	0.60
Hyd. ....	03.175	0.15	SEALS BETWEEN INLET MANIFOLD & HEAD Replace .....	Mech. 03.030	3.10
FUEL TANK FILLER PIPE - .....	Replace 03.065	0.95	Hyd. ....	03.030	3.30
FUEL TANK VENT PIPE - .....	Replace 03.067	1.50	INJECTOR PIPE ASSEMBLY FRONT OR REAR Replace .....	03.265	2.50
FUEL TANK - .....	Remove and Refit 03.076	2.80	INJECTOR PIPE ASSEMBLY COMPLETE Replace .....	03.269	3.50
Replace .....	03.082	3.00	FUEL PRESSURE REGULATOR - Replace .....	03.271	2.75
FUEL TANK RHEOSTAT - .....	Replace 03.121	0.80	PRESSURE SENSOR .....	Replace 03.273	0.60
			THERMO - SWITCH OPERATING COLD START IN - JECTOR .....	Replace 03.146	1.25

**ROUTINE MAINTENANCE AND RUNNING REPAIRS**

TIMES expressed in hours and hundredths of an hour

Operation	Code	Times
<b>TIMES FOR « D » CARBURETTOR MODELS</b>		
PETROL FILTER IN TANK - Replace	03.105	0.70
FUEL PUMP - Replace	03.052	0.50
	03.052	0.70
CHOKER CABLE	03.015	0.80
AIR FILTER ELEMENT - Remove, refit and clean	03.027	0.35
	03.107	0.20
AIR FILTER	03.022	0.30
CARBURETTOR - Remove, refit check and adjust on test bench	03.166	2.40
	03.166	2.85
CARBURETTOR ( removed ) - Check and adjust on test bench	03.167	1.50
CARBURETTOR - Replace	03.006	0.70
	03.006	1.15
CARBURETTOR - Clean and adjust float level ( on vehicle )	03.002	1.40
INLET MANIFOLD GASKETS - Replace	03.030	1.60
	03.030	4.35
<b>EXHAUST</b>		
EXH. MANIFOLD HEAT SHIELD - Replace	04.001	0.55
EXHAUST MANIFOLD GASKETS - Replace	04.012	1.85
MAIN SILENCER	04.033	0.70
REAR SILENCER	04.053	0.55
REAR SILENCER & INTERMEDIATE PIPES	04.054	1.25
BOTH SILENCERS, INTERMEDIATE PIPES AND FLEXIBLE PIPE	04.060	2.25
EXHAUST MANIFOLD - Replace	04.005	1.75
	04.007	2.65
	04.007	2.75
DOWN PIPE	04.018	1.15
FLEXIBLE PIPE	04.022	0.75
DOWN PIPE & FLEXIBLE PIPE	04.019	1.50

Operation	Code	Times
<b>ENGINE SUSPENSION</b>		
ENGINE MOUNTINGS - Replace	R.H. 07.060	1.50
	L.H. 07.062	2.10
	Both sides 07.064	3.30
<b>ENGINE ELECTRICAL EQUIPMENT</b>		
ALTERNATOR - Replace	Carb. 11.005	0.65
	Inject. 11.005	1.65
ALTERNATOR - Overhaul	Carb. 11.002	1.65
	Inject. 11.002	2.65
VOLTAGE REGULATOR - Replace	Carb. 11.030	0.35
	Inject. 11.030	0.70
STARTER SOLENOID - Replace	53.083	0.75
STARTER MOTOR - Remove & Refit or replace	9-71 53.015	1.25
	9-71 53.002	4.00
STARTER MOTOR ( removed ) Overhaul	53.020	1.50
<b>IGNITION</b>		
DISTRIBUTOR - Check and adjust ignition timing with stroboscope	06.050	0.70
DISTRIBUTOR - Replace incl. adjustment	06.057	0.90
	06.057	1.20
CONDENSER - Replace	06.035	0.25
CONTACT BREAKER - Replace on vehicle incl. adjust ignition timing with strobe	06.025	0.85
	06.025	1.00
CONTACT BREAKER - Replace incl. remove and re-fit distributor and adjust on test bench	06.125	1.40
	06.125	1.70
COIL - Remove & Refit or Replace incl. check	06.080	0.35
PLUG LEADS - Replace	06.006	0.40
PLUGS - Replace	06.006	0.50
	06.001	0.30
	06.001	0.65
PLUGS - Remove & Refit including clean	06.003	0.55
	06.003	0.90

Operation	Code	TIMES			
		D. Carb.		D. Inject.	
		Mec.	Hyd.	Mec.	Hyd.
<b>CLUTCH AND GEAR CHANGE CONTROLS</b>					
CLUTCH CABLE - Replace	08.040	0.65	—	0.65	—
GEAR CHANGE CONTROL CABLE - Replace	09.172	2.30	—	2.30	—
GEAR CHANGE CONTROL LEVER (Mec) or SELECTOR (Hyd.) - Repl.	42.110	1.00	2.30	1.00	2.30
BALL PIN ON BELL CRANK - Adjust	09.236	0.30	—	0.30	—
CLUTCH CYLINDER - Replace	08.207	—	1.50	—	1.50
CLUTCH CYLINDER - Overhaul	08.204	—	1.80	—	1.80
HYDRAULIC SELECTOR - Remove and refit or replace	09.211	—	3.00	—	3.80
	09.207	—	5.40	—	6.20
GEAR ENGAGEMENT CONTROL - Replace	09.223	—	0.50	—	0.50
CENTRIFUGAL REGULATOR - Replace	08.110	—	1.30	—	1.30
CENTRIFUGAL REGULATOR ( on the vehicle ) Overhaul	08.104	—	1.00	—	1.00
BELT DRIVING CENTRIFUGAL REGULATOR - Replace	08.130	—	0.25	—	0.25
CLUTCH LOCK - Replace	08.123	—	1.00	—	1.10
CLUTCH LOCK - Adjust (on vehicle)	08.117	—	0.75	—	0.85
CLUTCH RE-ENGAGEMENT CONTROL - Replace	08.220	—	0.85	—	1.05
FAST IDLE DEVICE - Replace	08.268	—	0.45	—	—
FEED PIPES FOR 1st & 3rd ON GEARBOX LID - Replace	09.329	—	2.80	—	3.35
FEED PIPES FOR 2nd & 4th ON GEARBOX LID - Replace	09.334	—	2.95	—	3.50
PIPING BETWEEN GEARBOX AND SELECTOR - Replace	09.324	—	3.80	—	4.35
SEALS ON FEED PIPES FOR 1st & 3rd - Replace	09.327	—	2.80	—	3.35
SEALS ON FEED PIPES FOR 2nd & 4th - Replace	09.332	—	2.95	—	3.50

# ROUTINE MAINTENANCE AND RUNNING REPAIRS



TIMES expressed in hours and hundredths of an hour

Operation	Code	TIMES			
		D. Carb.		D. E.F.I.	
		Mec.	Hyd.	Mec.	Hyd.
<b>CLUTCH</b>					
DISC incl/or PRESSURE PLATE - Replacement incl. remove/refit GB only .....	08.004	10.70	11.95	10.70	11.95
+ Supplt. THRUST BEARING - Replacement .....	08.051	+ 0.15	+ 0.15	+ 0.15	+ 0.15
+ Supplt. STARTER GEAR RING- Replacement incl. remove/refit engine flywheel .....	01.122	+ 0.35	+ 0.35	+ 0.35	+ 0.35
+ Supplt. Replace COMPLETE FLYWHEEL with starter gear ring .....	01.113	+ 0.15	+ 0.15	+ 0.15	+ 0.15
<b>GEARBOX</b>					
<b>MANUAL AND HYDRAULIC GEAR CHANGE</b>					
GEARBOX without removing engine .....	Replacement 09.006	13.00	15.00	13.00	15.40
	Overhaul 09.003	● 20.95	24.30	22.35	24.70
+ Supplement : CONTROL SHAFT .....	Replacement 09.065	+ 0.65	+ 0.65	+ 0.65	+ 0.65
+ Supplement : DIFFERENTIAL SHAFT or DIFFERENTIAL HOUSING .....	Replacement 09.178	+ 0.50	+ 0.50	+ 0.50	+ 0.50
+ Supplement : GEARBOX HOUSING .....	Replacement 09.033	+ 0.40	+ 0.40	+ 0.40	+ 0.40
+ Supplement : CROWN WHEEL and PINION ....	Replacement 09.044	+ 0.45	+ 0.45	+ 0.45	+ 0.45
+ Supplement : GEARBOX LID, - Replacement or Overhaul .....	09.017	+ 0.35	+ 1.35	+ 0.35	+ 1.35
DIFFERENTIAL SHAFT or DIFFERENTIAL HOUSING or ROLLER BEARING or OIL SEAL - Replacement .....	R.H. 09.134	7.15	7.25	8.35	8.45
	L.H. 09.132	7.20	7.30	8.35	9.05
	Both sides 09.136	11.30	11.40	12.50	13.35
	09.024	● 19.65	23.00	21.05	23.40
5th GEAR HOUSING - Replacement .....	09.265	2.20	—	2.40	—
GEARBOX LID, (Mec /Hyd.) or SET OF PISTONS-Replacement .....	09.001	4.55	5.65	5.45	6.20
DISTANCE PIECE between differential shaft housing and gearbox housing .....	Replacement R.H. 10.375	6.65	6.75	7.85	7.95
	L.H. 10.379	6.75	6.85	7.85	8.55
	Both sides 10.383	10.30	10.40	11.50	12.35
SPEEDO CABLE .....	Replacement 09.175	1.25	1.25	1.40	1.40
SPEEDO-CABLE PINION DRIVE, 4-speed gearbox Replacement .....	09.170	2.05	2.05	—	2.25
5th SPEED PINION and SYNCHRO or SPEEDO CABLE PINION DRIVE .....	5-speed gearbox Replacement 09.271	1.70	—	1.90	—
FRONT BEARING Replacement, Gearbox 4 speeds .....	09.240	2.25	2.25	—	2.45
	Gearbox 5 speeds 09.243	3.10	—	3.30	—
● + Supplement : 5 speed gearbox ( 09.020 + 1.40 )					
<b>AUTOMATIC TRANSMISSION - BORG WARNER</b>					
GEARBOX, without removing engine - .....	Replacement 09.439	18.80	—	18.80	—
	Overhaul 09.433	33.00	—	33.00	—
CROWN-WHEEL and PINION and DIFFERENTIAL Replacement .....	09.425	23.40	—	23.40	—
OIL SEAL FOR BEVEL PINION SHAFT .....	Replacement 09.428	21.15	—	21.15	—
SUN GEAR TRAIN-VALVE CHEST ASSEMBLY-OIL PUMP .....	Overhaul 09.422	23.50	—	23.50	—
<b>HYDRAULIC SYSTEM</b>					
HYDRAULIC FLUID-Drain-clean filter - refill .....	13.057	1.15	1.15	1.15	1.15
HYDRAULIC RESERVOIR-Replacement incl. clean filter .....	13.050	1.60	1.60	1.60	1.60
HYDRAULIC FILTER - Cleaning .....	13.055	0.20	0.20	0.20	0.20
INLET RUBBER PIPE, between reservoir and HP pump-repltd. ....	13.072	0.65	0.65	0.65	0.65
OUTLET STEEL PIPE, between HP pump and pressure regulator .....	Replacement 13.075	2.10	2.10	3.80	3.80
	PIPE between pressure regulator and 3-way union - Repltd. 13.073	1.10	1.10	1.90	1.90
HP PUMP DRIVE BELT .....	Replacement 13.085	1.00	1.00	1.25	1.25
HP PUMP - remove and refit or replacement .....	13.005	1.40	1.40	1.65	1.65
	Overhaul 13.006	5.25	5.25	5.50	5.50
OUTPUT PIPE SEAL, pressure regulator end .....	Replacement 13.126	0.30	0.30	1.20	1.20
PIPE SEAL on 3-way union .....	Replacement 13.127	0.40	0.40	1.20	1.20
PRESSURE REGULATOR - Remove and refit or replacement .....	13.020	1.55	1.70	1.70	2.30
	Overhaul 13.025	2.75	2.90	2.90	3.55
MAIN ACCUMULATOR .....	Replacement 13.035	1.55	1.70	1.55	0.85
MAIN PIPING .....	Replacement 13.243	5.90	5.90	5.90	5.90
OVERFLOW RETURN PIPING In side-member of shell ( Right or Left) .....	Replacement 13.583	4.05	4.05	4.05	4.05

Supplement for optional AIR CONDITIONER - See page 12

TIMES expressed in hours and hundredths of an hour

Operation	Code	Times
<b>STEERING</b>		
STEERING, MANUAL - incl. rem/ref. 1 front wing		
Replacement	24.265	2.60
Overhaul	24.260	4.50
STEERING, POWER - Replacement incl. rem/ref.-		
2 front wings	Carb. 24.285	3.30
	EFI 24.285	3.55
STEERING, POWER - Overhaul incl. rem/ref. -		
2 front wings, and adj. cross-over pressures		
Carb.	24.281	8.55
EFI	24.281	8.80
CROSS-OVER PRESSURES ( steering on car )		
Adjust	24.040	1.25
CROSS-OVER PRESSURES ( steering removed )		
Adjust	24.043	1.05
RACK CYLINDER ASSEMBLY ( on car )- Replace-		
Carb.	24.216	2.80
EFI	24.216	3.05
Overhaul	Carb. 24.224	3.50
EFI	24.224	3.75
STEERING RELAY-rem/ ref. or replacement		
Carb. RH	24.171	3.00
EFI RH	24.171	3.25
Carb. or EFI LH	24.168	3.25
Carb. both sides	24.174	4.60
EFI both sides	24.174	4.85
+ Supplt. STEERING RELAY - Overhaul or replace-		
ment of lower lever	24.159	+ 0.80
TRACK ROD - Replacement incl. adjust wheel		
alignment	24.089	1.10
excl. adjust wheel alignment	24.088	0.80
<b>SWIVEL - DRIVE-SHAFT</b>		
SWIVEL COMPLETE-replacement incl. rem/ ref.		
swivel/ drive shaft assy. →3-70, 1 side	20.150	2.30
→3-70 both sides	20.152	4.20
3-70 → 1 side	20.151	1.50
3-70 → both sides	20.153	2.65
+ Supplt. DRIVE SHAFT - Replacement		
→3-70	20.155	+ 0.30
3-70 →	20.157	+ 0.70
SWIVEL UPPER BALL PIN - Replt.	20.163	1.75
SWIVEL LOWER BALL PIN - Replt.	20.173	1.90
SWIVEL BALL PINS UPPER & LOWER - Replt. -		
1 side	20.183	2.50
DRIVE-SHAFT ( on car )-Replt. incl. rem/ ref. drive		
housing	1 side 10.030	1.75
both sides	10.034	3.30
TRI - AXLE - Replt. incl. rem/ ref. drive-housing		
1 side	10.010	1.60
both sides	10.012	3.00
<b>FRONT AXLE - FRONT SUSPENSION</b>		
HEIGHT CORRECTOR, FRONT - Replt.	23.137	2.80
SPHERE-Rem/ ref. or replacement incl. check		
1 side	23.015	0.30
both sides	23.018	0.50
SUSPENSION CYLINDER, FRONT - Replt. or rem/		
ref.	RH 23.053	1.85
LH	23.056	2.00
both sides	23.059	3.10
+ Supplt. CYLINDER ( removed ) - Overhaul	23.061	+ 0.40
SUSPENSION CYLINDER GAITER - Replacement -		
1 side	23.120	1.80
both sides	23.126	2.75
ANTI-ROLL BAR - Adjust	23.148	1.50
ANTI-ROLL BAR - Replacement	23.154	5.90
FRONT HALF-AXLE COMPLETE - rem/ ref. or -		
replacement	RH 20.109	7.45
LH	20.111	8.20
both sides	20.113	10.45
Overhaul -	RH 20.115	9.45
LH	20.118	10.20
both sides	20.121	14.15

Operation	Code	Times
<b>REAR AXLE - REAR SUSPENSION</b>		
HEIGHT CORRECTOR, REAR - Replt	23.341	1.95
SPHERE - Rem/ ref, or replt. incl. check		
1 side	23.201	0.50
both sides	23.204	1.00
SUSPENSION CYLINDER BALLS- Replt.	23.310	1.20
SUSPENSION CYLINDER-replt. or rem/ ref.		
1 side	23.253	1.00
both sides	23.256	2.00
+ Supplt. CYLINDER - Overhaul	23.258	+ 0.45
SUSPENSION CYLINDER GAITER - Replacement -		
1 side	23.323	1.10
both sides	23.329	2.20
STUB - AXLE ON ARM, or STUB- AXLE BEA		
RINGS - Replacement	1 side 21.113	1.25
both sides	21.115	2.30
WHEEL ARM - Replacement incl. check		
1 side	21.050	7.10
both sides	21.060	12.10
+ Supplt. for replt. WHEEL ARM, REAR		
Estate	21.033	+1.90

Operation	Code	Times	
		Mec.	Hyd.
<b>BRAKES</b>			
BRAKE-VALVE - Replacement	25.540	2.35	
BRAKE PEDAL GEAR - Replt.	25.526	2.80	2.90
BRAKE PRESS. DISTR. Adjust	25.520		1.70
Replt.	25.553		2.25
STOP LAMP SWITCH - Replt.	53.750	0.20	0.90
BRAKE PRESSURE SWITCH - Replt	25.533	1.15	1.15
VALVE SECURITY or PRIORITY			
Replt.	13.062	1.95	2.05
BRAKE ACCUMULATOR - Check on car			
13.077		0.65	0.65
Replt.	13.060	0.90	0.90
PARKING BRAKE CABLE - Adjust			
Hand op.	25.601	0.45	
Foot op.	25.601		0.65
PARKING BRAKE CONTROL-Replt.			
→7-70	25.610	2.60	1.25
7-70 →	25.611	1.25	1.25
<b>FRONT BRAKES</b>			
PARKING BRAKE PADS	Adjust 25.625	1.00	1.00
Replt. Carb.	25.630	4.50	4.70
EFI	25.630	8.80	9.00
PARKING BRAKE CALLIPER-Replt.			
Carb. RH	25.185	3.30	3.50
LH	25.186	3.95	4.15
both sides	25.187	5.00	5.20
EFI RH	25.185	3.65	3.85
LH	25.186	7.80	8.00
both sides	25.187	9.20	9.40
MAIN BRAKE PADS-Replt. or rem/ ref. and			
emerging	Carb. 25.106	1.00	1.00
EFI	25.106	1.15	1.15
MAIN BRAKE UNIT-rem/ ref or replt.			
Carb. 1 side	25.156	2.70	2.70
both sides	25.158	3.20	3.20
EFI 1 side	25.156	2.85	2.85
both sides	25.158	3.35	3.35
MAIN BRAKE UNIT- Overhaul			
Carb. 1 side	25.138	3.85	3.85
both sides	25.141	5.50	5.50
EFI 1 side	25.138	4.00	4.00
both sides	25.141	5.65	5.65
FRONT BRAKE DISC ( on car )-Check			
run-out and thickness	Carb. 25.202	1.70	1.70
EFI	25.202	1.85	1.85
FRONT BRAKE DISC - Replacement -			
Carb. 1 side	25.215	5.70	5.70
both sides	25.220	8.40	8.40
EFI 1 side	25.215	7.15	7.15
both sides	25.220	10.00	10.00
+ Supplt. 1 BRAKE UNIT-Recondition	25.125	+1.15	+1.15

# ROUTINE MAINTENANCE AND RUNNING REPAIRS



**TIMES** expressed in hours and hundredths of an hour

Operation	Code	Times	
		Mec.	Hyd.
<b>BRAKES, REAR</b>			
BRAKE DRUM, REAR - rem/ ref. or replt.			
1 side	25.309	0.50	0.50
both sides	25.313	0.85	0.85
TWO DRUMS (removed) - grinding	25.305	1.50	1.50
BRAKE-SHOE, REAR - replt.	25.419	1.75	1.75
BRAKE-SHOES, REAR, and WHEEL-CYLINDERS - replt.	25.420	2.90	3.00
BRAKE-SHOES, REAR (replacement) and WHEEL CYLINDER - recon.	25.425	3.20	3.30
PIVOTING PIPE, REAR BRAKE (→2-69) - Repl.			
REAR RH	25.458	1.05	1.05
REAR LH	25.455	1.25	1.25
BOTH SIDES	25.461	2.20	2.20
BRAKE PIPING, REAR (2-69 →) - replt.			
1 side	25.450	1.00	1.00
both sides	25.462	1.75	1.75
+ Suppl. 1 HOSE - replt.	25.451	+0.25	+0.25
BRAKE-HOSE, REAR - replt.			
1 side	25.491	1.15	1.15
both sides	25.493	2.00	2.00

Operation	Code	Times	
		Mec.	Hyd.
<b>ELECTRICAL EQUIPMENT ON BODY</b>			
BATTERY, DRY, incl. topping up - replt.			
Carb	11.055	0.60	
EFI	11.055	0.85	
+ Suppl. BATTERY CRADLE - replt.	11.056	+0.40	
WIRING HARNESS, FRONT - replt.	54.005	3.80	
WIRING HARNESS, REAR - replt.	Sal. 54.025	7.15	
Est.	54.020	8.90	
CABLE, REAR, FOR AUTO HEADLAMP BEAM LEVEL - replt.	53.630	1.55	
CABLE, REAR, FOR AUTO HEADLAMP BEAM LEVEL - replt.	53.620	1.50	
HORN - Replacement	51.012	0.25	
HORN, COMPRESSOR - Replacement	51.028	0.50	
HORN RELAY - Replacement	51.003	0.25	
HEADLAMP RELAY - replt.	53.458	0.20	
HEADLAMP GLASS - replt.	53.559	2.45	
+ Suppl. LIGHT UNIT, MAIN OR LONG-RANGE - Replacement	53.589	+0.15	
LIGHT-UNIT, MAIN OR LONG RANGE - replt.	53.541	1.90	
LIGHT-UNITS ( 1 side ) or HOUSING FOR LIGHT UNIT - replt.	53.530	2.05	
DIRECTION INDICATOR - replt.	53.675	0.25	
BULB FOR HEADLAMP OR DIRECTION INDICATOR Replacement	53.480	0.15	
<b>SALOON, REAR</b>			
RIM FOR DIRECTION INDICATOR - replt.	53.748	0.15	
DIRECTION INDICATOR - replt.	53.735	0.15	
HOUSING FOR DIRECTION INDICATOR-repl.	53.742	0.50	
GLASS FOR REAR LAMP CLUSTER - replt.	53.728	0.15	
REAR LAMP CLUSTER - replt.	53.705	0.40	
REVERSING LAMP AND BRACKET - replt.	53.724	0.40	
BULB FOR DIRECTION INDICATOR OR REAR LAMP OR REVERSING LAMP - replt.	53.770	0.15	

Operation	Code	Times	
		Mec.	Hyd.
<b>ESTATE ( SAFARI ), REAR</b>			
REAR NUMBER PLATE LAMP - replt.	53.788	0.10	
BRACKET FOR NUMBER PLATE LAMP-repl.	53.789	0.15	
GLASS FOR REAR LAMP - replt.	53.782	0.10	
REAR LAMPS COMPLETE ( 1 side ) - replt. incl. rem/ ref. wing	53.784	0.55	
SUPPORT FOR REAR LAMPS - replt. incl. rem/ ref. wing	53.786	0.70	
<b>INSTRUMENTS ON FASCIA BOARD</b> ( See IMPACT, INTERNAL )			
<b>HEATING</b>			
HEATER CONTROL CABLE - replt.	50.173	1.40	
HEATER RADIATOR ( - 5° C ) COMPLETE - rem/ ref. or Replacement	50.302	1.00	
HEATER MOTOR or 2 HALF-CASINGS-repl.	50.350	1.45	
THERMOSTATIC VALVE (heater control) - Replacement	50.329	0.65	
HEATER TAKE-OFF PIPE - Repl.	Mec. 50.358	1.00	
Hyd.	50.358	1.20	
THERMOMETER UNIT - replt.	50.318	0.65	
<b>AIR-CONDITIONING</b>			
FREON GAS - recharge	50.036	0.80	
FREON CONTAINER - replt. incl. FREON recharge - replt.	50.037	1.45	
COMPRESSOR BELT - Adjust tension	50.044	0.25	
repl.	50.045	0.50	
COMPRESSOR - replt. incl. FREON-recharge	50.040	2.85	
BRACKET FOR COMPRESSOR - replt.	50.042	3.90	
AIR BLOWER or CONDENSER - replt. incl. rem/ ref. - 1 wing and FREON recharge	50.152	3.05	
( wing removed )	50.153	2.15	
AIR BLOWER or CONDENSER (removed)-repl.	50.154	0.65	
HOSE, RUBBER, between CONDENSER and THREE-WAY UNION - Repl. incl. rem/ ref. 1 wing and FREON recharge	05.156	2.85	
1 side, 1 hose	05.157	3.50	
1 side, 2 hoses	05.157	1.95	
( Wing removed ) - replt.	05.158	2.60	
1 side, 1 hose	05.159		
1 side, 2 hoses			
HOSE, RUBBER, between FREON CONTAINER and EVAPORATOR or EVAPORATOR to COMPRESSOR - replt. incl. FREON recharge	05.166	3.60	
HOSE, RUBBER, from THREE-WAY UNION to FREON CONTAINER or from THREE-WAY UNION to COMPRESSOR - replt. incl. FREON recharge	05.167	1.45	

SUPPLEMENTARY TIMES NECESSITATED BY PRESENCE OF AIR-CONDITIONING		
OPERATION AFFECTED	+ Suppl. for AIR-COND.	
Remove and fit engine/ gearbox unit, or gearbox alone	01.009	+1.95
Strip and reassemble engine after removal	None	None
Remove and fit starter motor ( on car )	Carb. 53.016	+3.90
	EFI 53.016	+4.55
Remove and fit exhaust manifold, or replace gasket	04.008	+1.30
Removal and fitting or replacement of following units ( on vehicle ) :		
Radiator duct - water pump - gearbox front bearing cap - Radiator - clutch lock - gearbox cover	13.168	+0.55

# COMPLEMENTARY MECHANICAL OPERATIONS

---

## complementary mechanical operations

These operations are complementary to the routine maintenance and running repair operations and also to operations following an accident classified in the impact areas. They are so defined as to avoid accumulations of times.

**ENGINE OPERATIONS  
ENGINE EQUIPMENT**

Pages 14 to 16 \_\_\_\_\_

**HYDRAULIC EQUIPMENT  
GEARBOXES**

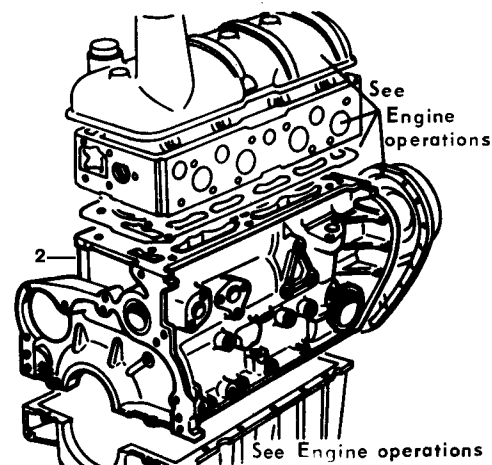
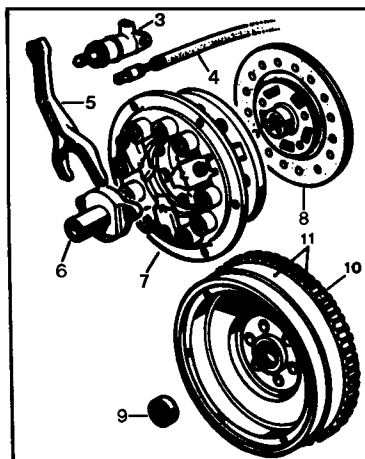
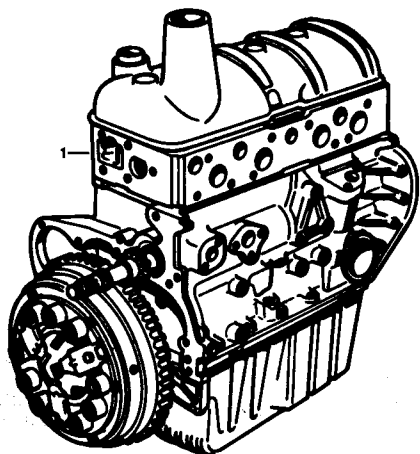
Pages 17-18 \_\_\_\_\_

**AXLE, FRONT  
AXLE, REAR**

Pages 19-20 \_\_\_\_\_

# COMPLEMENTARY MECHANICAL OPERATIONS

## ENGINE ASSEMBLIES

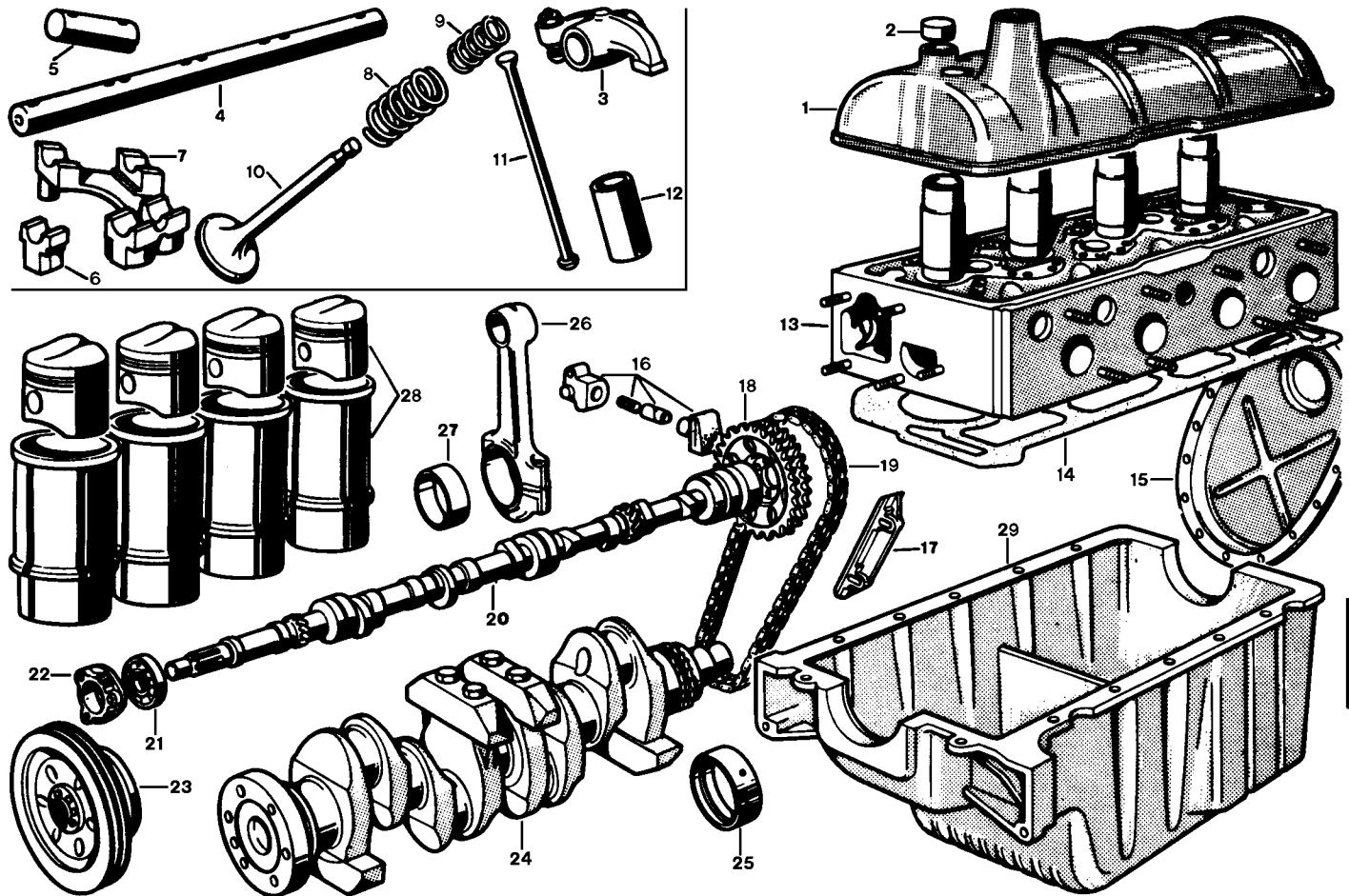


**TIMES** expressed in hours and hundredths of an hour

Ref.	Operation	Code	Times	Ref.	Operation	Code	Times
	<b>PARTIAL TUNE-UP</b>	Carb. 01.005	1.40		<b>engine removed and disconnected</b>		
		EFI 01.005	1.00				
	<b>ENGINE-GEARBOX UNIT - rem/ref. incl. - rem/ref. front wings, radiator, steering, battery, front suspension spheres, partial removal hydraulic reservoir, drive-shafts, and controls, incl. adjustment parking brake, idling, and check of levels - Incl. adjust headlamps, and bleed</b>	Carb. - Mec. 01.008	9.75		<b>1 ENGINE - recondition including strip and reassemble - Incl. Partial Tune-Up. Excluding recondition cylinder-head.</b>		
		- Hyd. 01.008	10.55		Carb. - Mec. 01.025	18.15	
		EFI - Mec. 01.008	13.10		- Hyd. 01.025	18.35	
		- Hyd. 01.008	13.85		EFI - Mec. 01.025	18.70	
					- Hyd. 01.025	19.55	
	<b>ENGINE-GEARBOX UNIT ( removed ) - disconnect and reconnect gearbox and engine</b>	Mec. 09.089	2.10		<b>Including recondition cylinder-head</b>		
		Hyd. 09.089	2.75		Carb. - Mec. 01.026	23.55	
	<b>engine removed and disconnected</b>				- Hyd. 01.026	23.55	
<b>1</b>	<b>ENGINE-replacement or strip reassem. excl. Part Tune-Up</b>	Carb. - Mec. 01.790	4.50	<b>3 CLUTCH SLAVE CYLINDER - recondition</b>	Hyd. 08.025	0.30	
		- Hyd. 01.790	4.75	<b>6 CLUTCH THRUST RACE - replt.</b>	08.051	0.15	
		EFI - Mec. 01.790	6.50	<b>7 &amp; 8 CLUTCH DISC AND MECHANISM - replt.</b>	08.007	0.45	
		- Hyd. 01.790	6.65	<b>10 STARTER RING - replt. incl. rem/ref. clutch</b>	01.127	0.80	
	<b>Incl. Partial Tune-Up</b>	Carb. - Mec. 01.791	5.90	<b>11 FLYWHEEL - replt. incl. rem/ref. clutch</b>	01.117	0.60	
		- Hyd. 01.791	6.15				
		EFI - Mec. 01.791	7.50		<b>CAMSHAFTS AND TAPPETS ( refs. 20 - page 15 ) - replt.</b>	01.774	7.75
		- Hyd. 01.791	7.65				

Supplements for **AIR CONDITIONING** ( optional extra ) • See page 12

ENGINE OPERATIONS



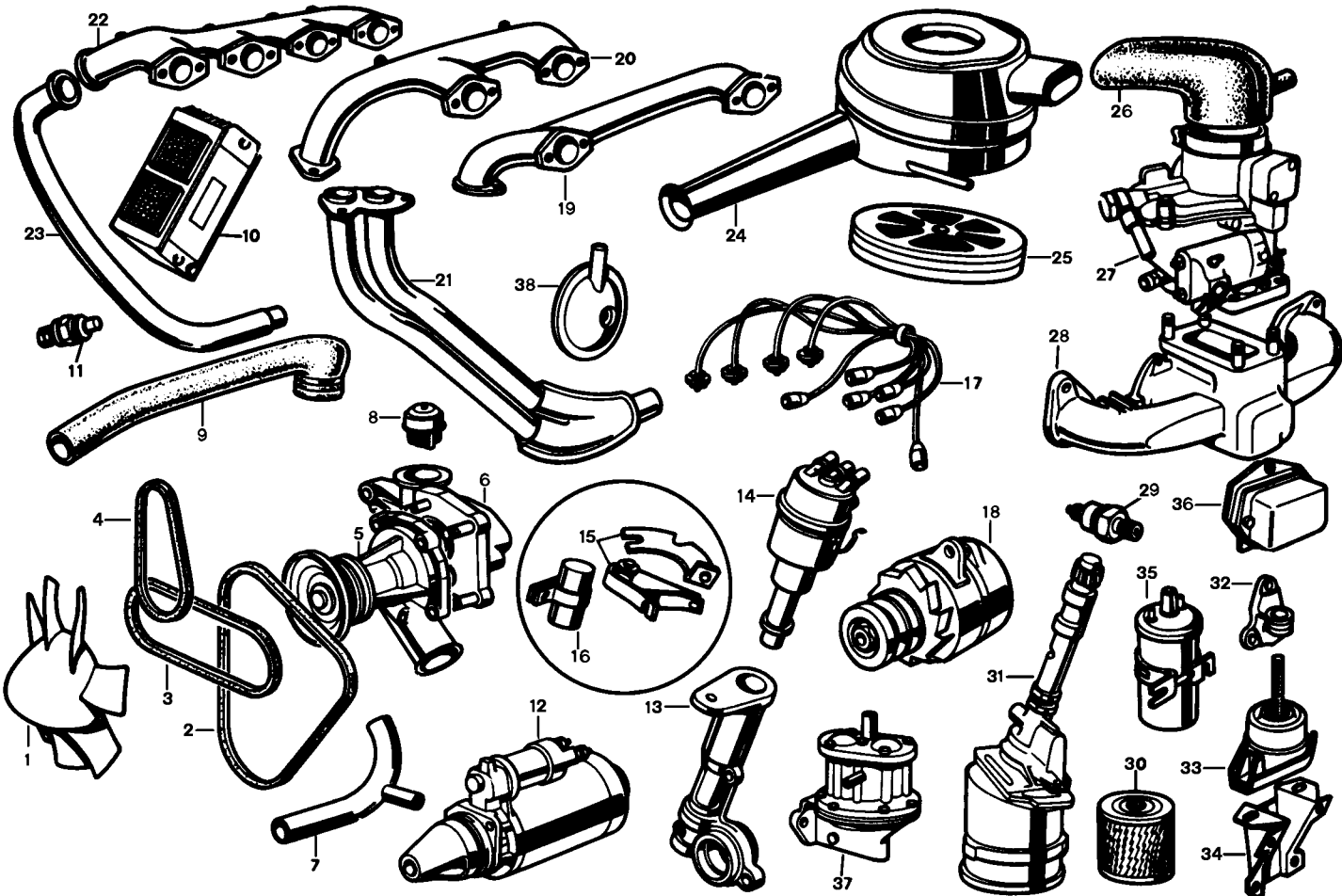
TIMES expressed in hours and hundredths of an hour

Ref.	Operation	Code	Times	Ref.	Operation	Code	Times
	<b>engine/gearbox unit removed</b>				<b>engine/gearbox unit removed</b>		
4	INLET ROCKER SHAFT - replt.	01.725	1.95	16	TIMING CHAIN TENSIONER - Replt.	01.243	0.80
5	EXHAUST ROCKER SHAFT-replt.	01.735	1.40	19	TIMING CHAIN - replt. ....	01.241	1.20
4 & 5	INLET AND EXH. ROCKER SHAFT-replt.	01.733	2.65	21	CAMSHAFT BEARING, incl. rem. ref. drive pulley - replt. ....	01.218	1.15
	+ Supplt.: 1 ROCKER (3) - replt.	01.734	+ 0.10	23	DRIVE-PULLEY - replt. ....	01.284	0.90
13	CYLINDER - HEAD-recondition, or CYLINDER - HEAD BARE - replt.			28	BARRELS and PISTONS, incl. PARTIAL TUNE-UP - replt. ....		
	Carb. - Mec.	01.422	8.20		Carb.	01.139	11.40
	Hyd.	01.422	8.75		EFI	01.139	11.00
	EFI - Mec.	01.422	10.00		+ Supplt. CAMSHAFT AND CHAIN ( 19 and 20 ) - Replt. ....	01.207	+1.60
	Hyd.	01.422	10.45		+ Supplt. TIMING CHAIN ( 19)-replt.	01.232	+0.45
14	+ Supplt. : TAPPETS - replt. ....	01.533	+ 0.35		+ Supplt. CRANKSHAFT BEARING ( 25 ) Replacement .....	01.168	+0.65
	CYLINDER-HEAD GASKET - replt., or CYLINDER-HEAD - Remove. refit				+ Supplt. CYLINDER-HEAD - recon		
	Carb. - Mec.	01.690	3.00		Carb.	01.433	+5.20
	- Hyd.	01.690	3.55		EFI	01.433	+6.60
	EFI - Mec.	01.690	3.40				
	- Hyd.	01.690	3.85				
	REAR CLOSING PLATE GASKET - replt.			29	SUMP - Replacement .....	01.073	2.45
		01.319	0.30				
15	TIMING COVER or COVER GASKET-replt.	01.203	0.55				



# COMPLEMENTARY MECHANICAL OPERATIONS

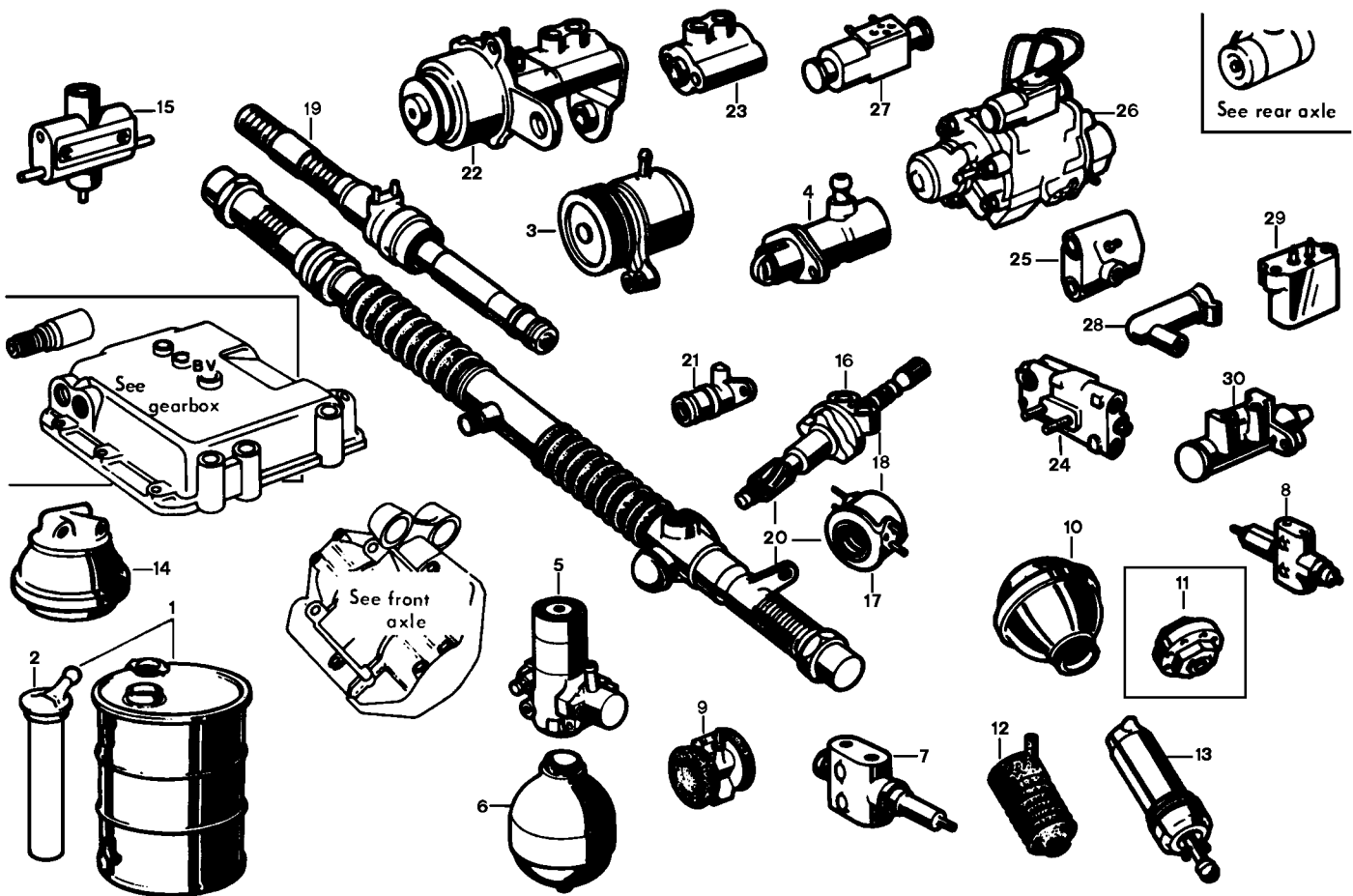
## ENGINE EQUIPMENT



TIMES expressed in hours and hundredths of an hour

Ref.	Operation	Code	Times
<b>Engine gearbox removed</b>			
1	FAN ON WATER-PUMP - replt., except DS 23 and EFI	05.013	0.20
	FAN or MOTOR ( electric ) on radiator after removal - replt. DS 23 and EFI	05.257	0.25
2	BELT (s) for WATER PUMP or ALTERNATOR - replt.	05.021	0.20
5	WATER PUMP or GASKET - replt.	05.036	1.35
	+ Supplt. WATER PUMP BACK-PLATE ( 6 )		
	Repl't.	Mec. 05.038	+0.65
		Hyd. 05.038	+1.00
9	HOSE, UPPER or LOWER, for RADIATOR or THERMOSTAT ( 8 ) - replt.	05.024	0.15
10	OIL COOLER - replt.	05.066	0.50
11	WATER WARNING LAMP SWITCH - replt.	05.124	0.15
12	STARTER MOTOR - replt.	53.004	0.25
	( removed ) - recon.	53.020	1.50
14	DISTRIBUTOR - replt. incl. bench-test	06.064	0.70
15	CONTACT BREAKER - replt. incl. rem. ref. distributor and bench test	06.118	0.90
18	ALTERNATOR - replt.	Carb. 11.020	0.35
		EFI 11.020	0.50
	ALTERNATOR ( removed ) - recon.	11.007	1.00
19-20	EXHAUST MANIFOLD - replt.	04.006	1.30
	EXHAUST MANIFOLD GASKETS - replt.	04.013	0.55
23	EXHAUST DOWN-PIPE - replt.	04.017	0.30
27	CARBURETTOR - replacement	03.159	0.45
	CARBURETTOR - clean and adj. float level	03.160	0.90
28	INLET MANIFOLD - replt.	Mec. 03.033	0.70
		Hyd. 03.033	1.00
	INLET MANIFOLD GASKETS - replt.	Mec. 03.029	0.60
		Hyd. 03.029	0.85

Ref.	Operation	Code	Times
<b>Engine gearbox removed</b>			
29	OIL PRESSURE SWITCH-repl't.	01.676	0.15
30	OIL PUMP - repl't.	01.708	2.65
33	ENGINE SUSPENSION RUBBER - repl't.	07.020	0.25
32	ENGINE BEARER ARM, incl. rem. ref. suspension rubber - repl't.	07.025	0.50
36	VOLTAGE REGULATOR - repl't.	11.031	0.25
37	FUEL PUMP - repl't.	03.053	0.15
38	BREATHER, or BREATHER - GASKET-repl't.	01.634	0.20
<b>INJECTION EQUIPMENT</b>			
	BUTTERFLY-HOUSING-repl't.	Mec. 03.277	0.70
		Hyd. 03.277	1.00
	SUPPLEMENTARY AIR CONTROL - repl't.	03.152	0.45
	ACCELERATED IDLING CONTROL - repl't.	03.154	0.45
	HOSE between WATER-PUMP and SUPPLEMENTARY AIR CONTROL-repl't.	03.143	0.20
	HOSE between CYLINDER-HEAD and SUPPLEMENTARY AIR CONTROL -repl't.	03.141	0.15
	1 INJECTOR - Replacement	03.254	0.20
	4 INJECTORS - Replacement	03.262	1.00
	COLD-START INJECTOR-repl't.	03.156	0.15
	FULL-LOAD SWITCH - repl't.	03.264	0.20
	INJECTOR PIPING FT. or REAR - repl't.	03.279	0.85
	INJECTOR PIPING COMPLETE-repl't.	03.270	1.15
	FUEL-PUMP PRESSURE REGULATOR-repl't.	03.272	1.00
	PRESSURE-SENSOR - repl't.	03.274	0.20
	COLD-START TIME-DELAY SWITCH -repl't.	03.147	0.20
	INLET MANIFOLD - repl't.	03.033	0.50
	INLET MANIFOLD GASKETS ( on cylinder-head ) - repl't.	03.029	1.25



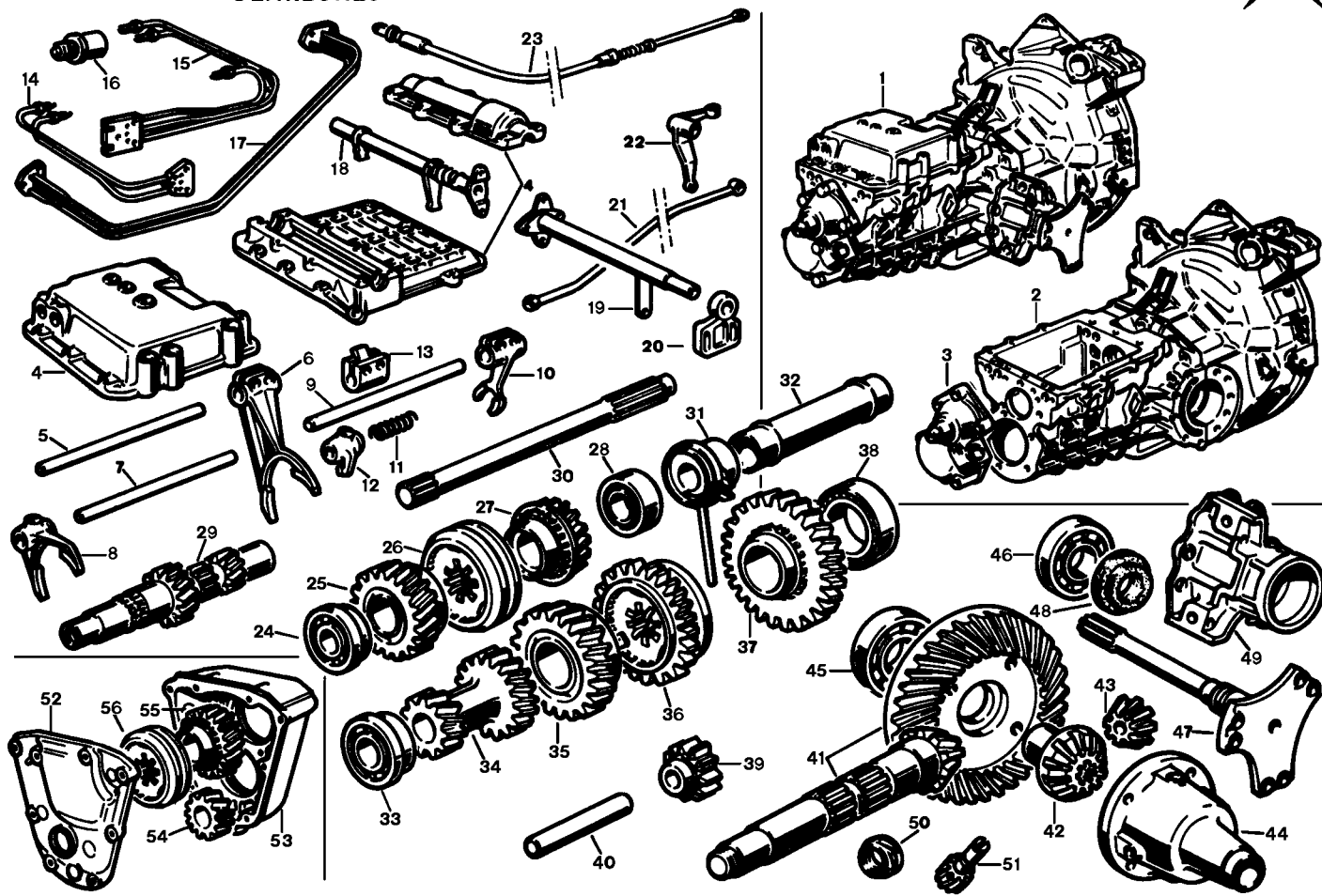
TIMES expressed in hours and hundredths of an hour

Ref.	Operation	Code	Times	Ref.	Operation	Code	Times
1	HEIGHT CONTROLS ( Engine - gearbox removed ) - adjust	43.002	0.50	12	REAR SUSPENSION CYLINDER DUST SHIELD - ( wheel arm removed ) -repl.	23.324	0.90
	HYDRAULIC RESERVOIR ( Engine or Gearbox removed ) - replt.	13.054	0.90	13	SUSPENSION CYLINDER, REAR ( wheel arm removed on same side)-rem. ref. or replt.	23.241	0.70
3	HP PUMP FEED HOSE ( Engine - Gearbox removed ) - replt.	13.071	0.15		( removed ) recon.	23.258	0.45
	HP PUMP ( Engine-gearbox removed ) - re - move, fit, or replace	13.007	0.50	15	CLUTCH LOCK ( accessible )		
	( removed ) recon.	13.009	3.85		Adj. - Hyd.	08.118	0.20
5	HP PUMP OUTPUT PIPE ( Engine-gearbox removed ) - replt.	13.076	0.50		Repl.- Hyd.	08.122	0.45
	HP PUMP BELTS ( Engine-gearbox removed ) Replacement	13.086	0.45	17 or 18	ROTATING UNION, or STEERING PINION or ASSEMBLY ( Steering removed )-repl.	24.211	1.75
6	PRESSURE REGULATOR ( Engine rem/ref.) replt. incl. check accumulator	13.023	0.50	19	STEERING CYLINDER ( steering removed ) - replt.	24.226	1.70
	( removed ) - recon. incl. check accumulator	13.028	1.20	20	POWER-STEERING ( removed ) - adjust - cross-over pressures on bench	24.275	1.05
9	MAIN ACCUMULATOR ( Engine removed ) replacement incl. check	13.036	0.20		STEERING ( removed ) - power replt.	24.276	0.70
	HEIGHT CORRECTOR, FT. ( Ft. LH wing removed )-repl. incl. adj.	23.187	1.60		manual replt.	24.277	0.45
12	HEIGHT CORRECTOR REAR ( WHEEL ARM LH removed ) - replt.	23.346	0.80		recondition		
	( WHEEL ARM RH removed )- replt.	23.347	1.20		Power-steering, incl. cross-over pressures power	24.278	5.25
13	FRONT SUSPENSION CYLINDER DUST-SHIELD ( Engine or gearbox removed ) replt.				manual	24.256	1.85
	1 side	23.121	0.60	21	CLUTCH SLAVE CYLINDER ( engine-gearbox removed ) rem/ref. or replt.	Hyd.08.208	0.20
13	SUSPENSION CYLINDER FRONT ( Engine or gearbox removed ) - rem/ref. or replace				( removed ) recon.	08.205	0.30
	1 side	23.055	0.80	22	CENTRIFUGAL REGULATOR ( engine-gearbox removed ) -rem/ ref. or replt.	Hyd. 08.111	0.65
	+ Suppl. 1 CYLINDER ( removed )- recon.	23.061	+0.40		( removed )-recon.	Hyd. 08.112	0.45
				24	CLUTCH RE-ENGAGEMENT CONTROL ( engine-GB removed )-repl.	Hyd.08.221	0.45
				26	HYDRAULIC SELECTOR ( removed ) - recon.	Hyd.09.215	2.40

Supplements for AIR-CONDITIONING ( optional extra ) - See page 12

# COMPLEMENTARY MECHANICAL OPERATIONS

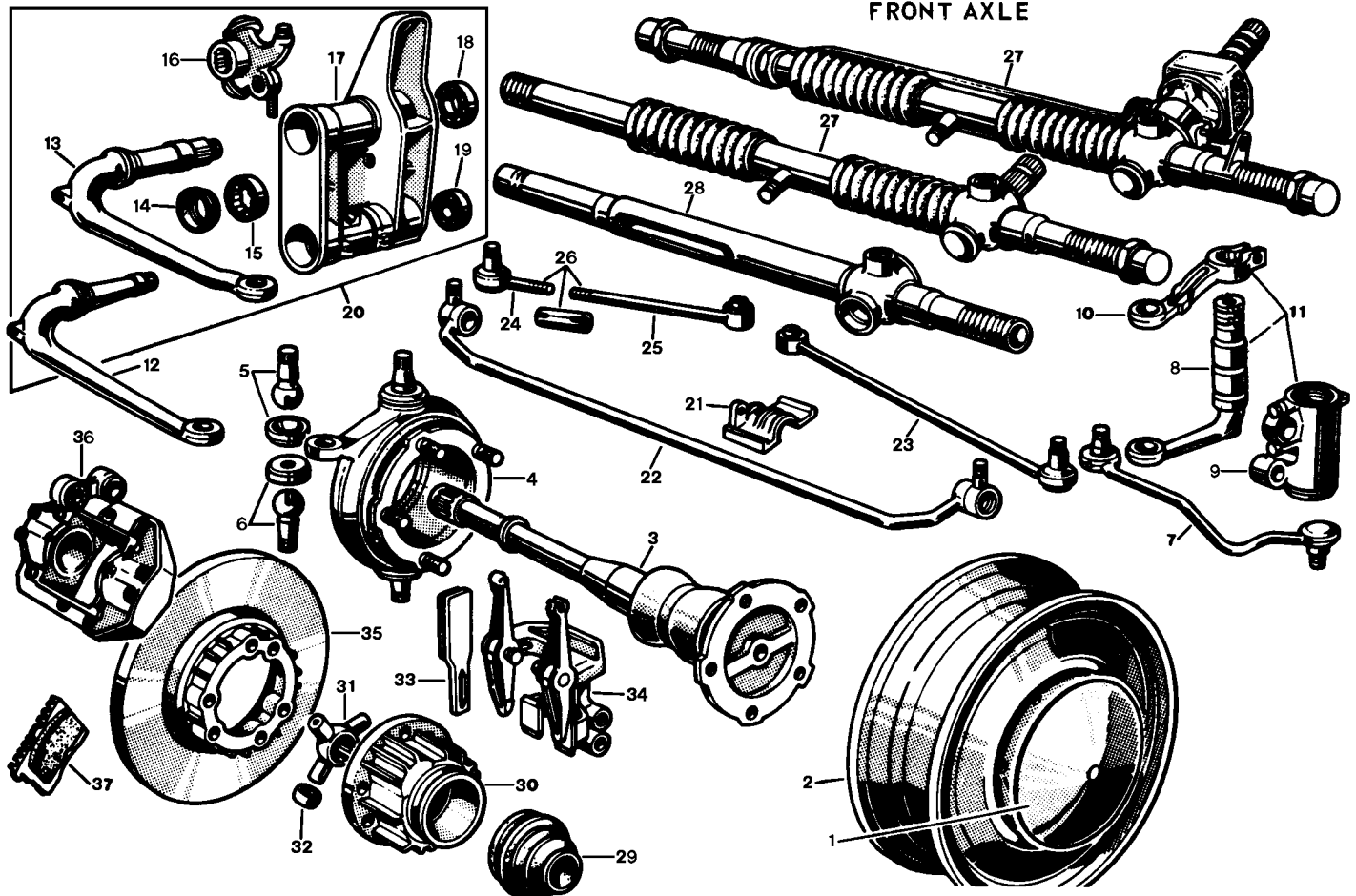
## GEARBOXES



TIMES expressed in hours and hundredths of an hour

Ref.	Operation	Code	Times		Ref.	Operation	Code	Times		
			Mec.	Hyd.				Mec.	Hyd.	
	<b>Engine-gearbox unit removed</b>					<b>Engine-gearbox unit removed</b>				
1	ENGINE-GB ( removed )-disconnect	09.089	2.10	2.75	24-23	BEARINGS, FRONT OF GB (removed)				
	-reconnect					- replacement - on 4-speed GB	09.241	1.20	1.20	
	GEARBOX(removed and disconnected)					on 5-speed GB	09.244	2.05		
	repl. ....	Carb. 09.016	2.75	3.50		46-49	DIFFERENTIAL SHAFT-BEARER -			
		EFI 09.016	2.75	3.90			BEARING, or BUSH (GB removed) -			
	( removed and disconnected ) - recon.						- replt. incl. rem/ref. brake unit and			
		Carb. 09.014	10.70	12.80			disc	09.115	2.95	2.95
		EFI 09.014	12.10	13.20		both sides	09.119	4.80	4.80	
	+ Supplt. MAINSHAFT ( 30 ) - replt.	09.065	+0.65	+0.65		48	SEAL FOR DIFFERENTIAL SHAFT -			
	+ Supplt. DIFFERENTIAL SHAFT						BEARER ( GB removed )-repl.			
BEARER-BEARING or BUSH ( 46 to				1 side	10.376	1.75	1.75			
49 ) - replt. ....	09.178	+1.20	+1.20	both sides	10.377	2.40	2.40			
+ Supplt. GB HOUSING (2)-repl.	09.033	+0.40	+0.40	51	SPEEDO DRIVE PINION on 4-speed -					
+ Supplt. CROWN WHEEL and PINION					GB (removed) - replt. ....	09.171	1.40	1.40		
(41) - replt. ....	09.044	+0.45	+0.45	52	LID FOR 5th GEAR (GB removed)					
+ Supplt. GEARBOX LID (4)-repl.					repl. ....	09.269	0.45			
	09.017	+0.35	+1.35	53	CASING FOR 5th GEAR (GB removed)					
2	GB HOUSING AND BELL HOUSING ( GB					repl. ....	09.268	1.05		
	removed and disconnected)-excl. disas-				54 & 56	PINION + SYNCHRO FOR 5th, or				
	sem. - reassem. shaft and pinion-repl.					SPEEDO DRIVE NUT, on 5-Sp. GB				
	Carb. 09.025	9.40	11.50		( GB removed ) - replt. ....	09.273	0.65			
	EFI 09.025	10.80	11.90							
	● = + Supplt. for 5-speed GB	09.020	+1.40							
4	GEARBOX LID ( GB removed )repl.									
		09.037	2.30	3.30						
	Same op. for replt. set of pistons on									
14	Hyd. GB cover	09.037		3.30						
	PIPE ASSEMBLY, 1st/ 3rd, or SEALS									
15	( engine or GB rem. ) -repl. ....	09.038		0.15						
	PIPE ASSEMBLY, 2nd/ 4th, or SEALS -									
17	( engine or GB rem. )-repl. ....	09.333		0.25						
	PIPE ASSEMBLY between HYD. SELEC-									
23	TOR and GB PIPE-ASSEMBLY ( eng. or									
	GB rem ) - replt. ....	09.325		0.65						
	SELECTOR CABLE ( GB rem: ) -repl.									
		09.173	1.20							

FRONT AXLE

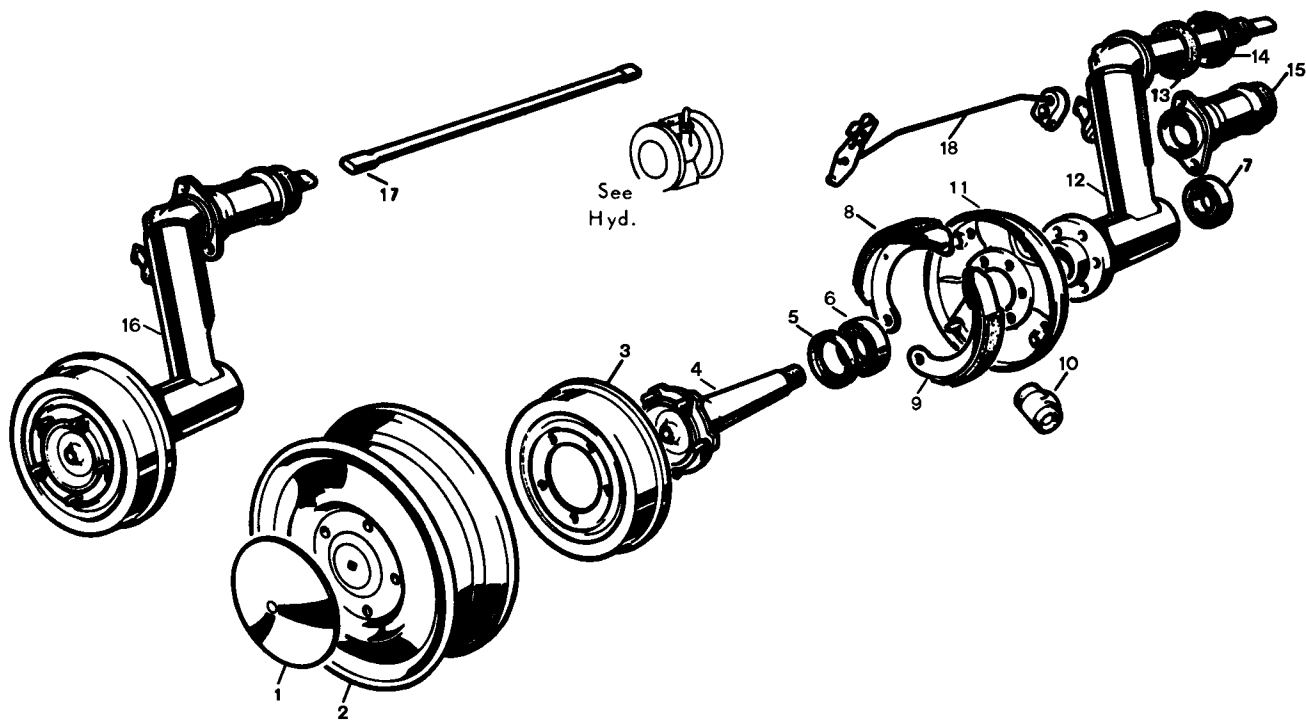


TIMES expressed in hours and hundredths of an hour

Ref.	Operation	Code	Times	Ref.	Operation	Code	Times
1 & 2	EMBELLISHER + WHEEL - rem/ref.				+ Supplt. BRAKE DISC-replt. incl. rem/ref. power brake unit, and part of parking brake caliper.		
	1 side	22.013	0.30		Carb. 1 side	25.195	+3.85
	both sides	22.015	0.40		both sides	25.197	+5.60
2	WHEEL or TYRE (wheel removed) - replt.				EFI 1 side	25.195	+4.15
	with inner tube	22.020	0.25		both sides	25.197	+6.20
	tubeless	22.019	0.65		+ Supplt. DRIVE SHAFT - replt....	10.045	+0.90
	+ Supplt. WHEEL-balancing	22.089	+0.30		+ Supplt. SWIVEL - replt. ....	10.046	+0.30
7	TRACK-ROD (engine-gearbox removed)replt.	24.310	0.50		+ Supplt. SWIVEL BALL-PIN - replt.( 1 side)		
11	STEERING RELAY COMPLETE (steering removed) - rem/ref. or replt.				Upper	20.159	+0.80
	LH or RH	24.290	1.25		Lower	20.171	+0.95
	STEERING RELAY COMPLETE ( removed )				Upper and Lower	20.235	+1.50
	- recon. or replace lower arm	24.139	0.80	22	+ Supplt. TRI-AXLE replt. ....	10.041	+0.60
20	HALF-AXLE COMPLETE (engine-gearbox removed)-rem/ref. or replt.				ANTI-ROLL BAR (engine-gearbox removed)		
	excl. adjustments				adjust	23.145	0.50
	RH	20.120	4.00		replace	23.155	4.40
	LH	20.117	4.75	23	STEERING TRACK-ROD (engine-gearbox removed) - replt. ....	24.069	0.25
	both sides	20.123	7.00	27	STEERING RELAY COMPLETE ( removed )		
	incl. adjustments				recondition	manual 24.256	1.85
	RH	20.119	5.50		incl. adj. cross-over press, power ass.	24.278	5.25
	LH	20.116	6.25		STEERING RELAY COMPLETE ( removed )		
	both sides	20.124	8.50		replacement	manual 24.277	0.45
	( removed ) - recon. 1 side	20.135	2.00		power	24.276	0.70
	both sides	20.137	3.70	33	PARKING BRAKE PADS ( gearbox removed)		
20	HALF-AXLE COMPLETE - rem/ref. or replt. incl. rem/ref. front wings, wheels, drive-shaft, swivel, incl. adj. front geometry, heights, and headlamps				replt.	25.631	0.55
	RH	20.109	7.45	34	PARKING BRAKE CALIPER ( gearbox removed) replt. - manual GB- 1 side	25.188	0.45
	LH	20.111	8.20		both sides	25.189	0.80
	both sides	20.113	10.45		Hyd. GB - 1 side	25.188	0.55
	NOTE : In case of replacement of a wing add adjusting time				both sides	25.189	0.90
	+ Supplt. FRONT BODY UNIT - check incl. rem/ref. tools and alignment bar	31.619	+0.80	35	BRAKE DISC, incl. rem/ref. brake unit ( GB removed)-replt. ....	1 side 25.213	1.15
	+ Supplt. STEERING RELAY-rem/ref.				both sides	25.219	1.70
	Carb.	24.378	+1.90	36	POWER BRAKE UNIT COMPLETE ( gearbox removed) rem/ref. or replt. 1 side	25.162	0.55
	EFI	24.378	+2.15		both sides	25.161	0.85
	+ Supplt. STEERING RELAY COMPLETE - rem/ref. or replt. without removal of steering ( lifting )				POWER BRAKE UNIT ( removed)		
	LH	24.337	+1.85		recon.	25.125	+1.15
	Carb. RH	24.339	+1.50		POWER BRAKE UNIT (GB removed) - recon.		
	EFI LH	24.339	+1.75		1 side	25.139	1.70
					both sides	25.142	3.15
				37	MAIN BRAKE PADS ( GB removed) replt. or rem/ref. and emerying	25.102	0.40



REAR AXLE

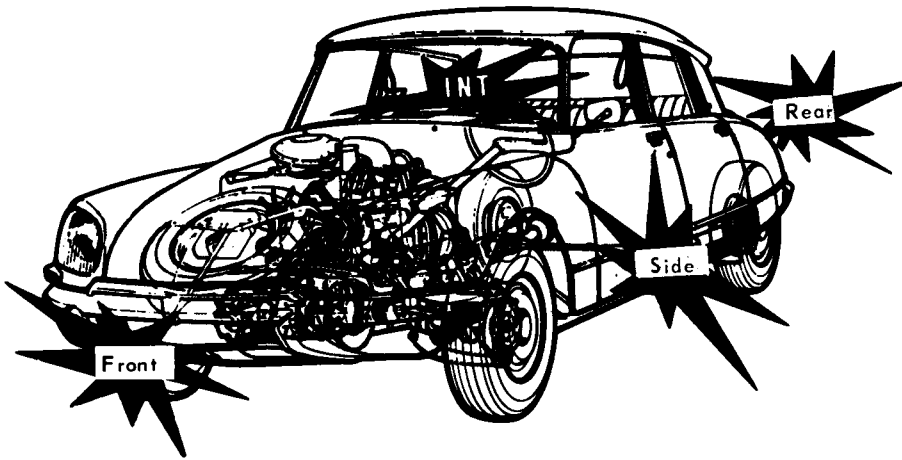


TIMES expressed in hours and hundredths of an hour

Ref.	Operation	Code	Times	Ref.	Operation	Code	Times
	REAR WHEEL ALIGNMENT, check with optical device including alignment of front and rear axles, toe in and rear camber, excluding height check	21.001	0.70	8 & 9	REAR BRAKE SHOES ( wheels removed ) replacement	25.417	1.20
1 & 2	EMBELLISHER AND WHEEL REAR- rem/ ref. incl. rem/ ref. wing	22.014	0.35		+ Supplt. BRAKE CYLINDERS COMPLETE ( 9 ) excl. brake bleed - rem/ ref. or replt.		
		22.016	0.55		2 sides	25.373	+0.80
2	WHEEL and/or TYRE ( wheel removed ) - replacement	22.020	0.25		recon. 2 sides	25.375	+1.10
		22.019	0.65	4	STUB-AXLE ON ARM, or STUB-AXLE BEARINGS ( wheel removed )-replt.	25.134	0.90
3	BRAKE DRUM ( wheel removed )-replacement	25.301	0.15	16	REAR WHEEL-ARM COMPLETE ( wheel removed ) rem/ ref. excl. adj. and bleed		
					1 side	21.023	1.20
					both sides	21.026	2.40
					( removed )-strip/ reassemble 1 arm	21.041	3.85
					both arms	21.043	7.50
					+ Supplt. for ESTATE ( safari ), to operations of removal/ fitting or replt.	21.033	+ 1.90

# IMPACT AREAS

## LOCATION OF IMPACT



### IMPACT, FRONT

Pages 22 to 25 \_\_\_\_\_

### IMPACT, SIDE

Pages 26 to 29 \_\_\_\_\_

### IMPACT, REAR

Pages 30 to 35 \_\_\_\_\_

### IMPACT, INTERNAL

Pages 36 and 37 \_\_\_\_\_

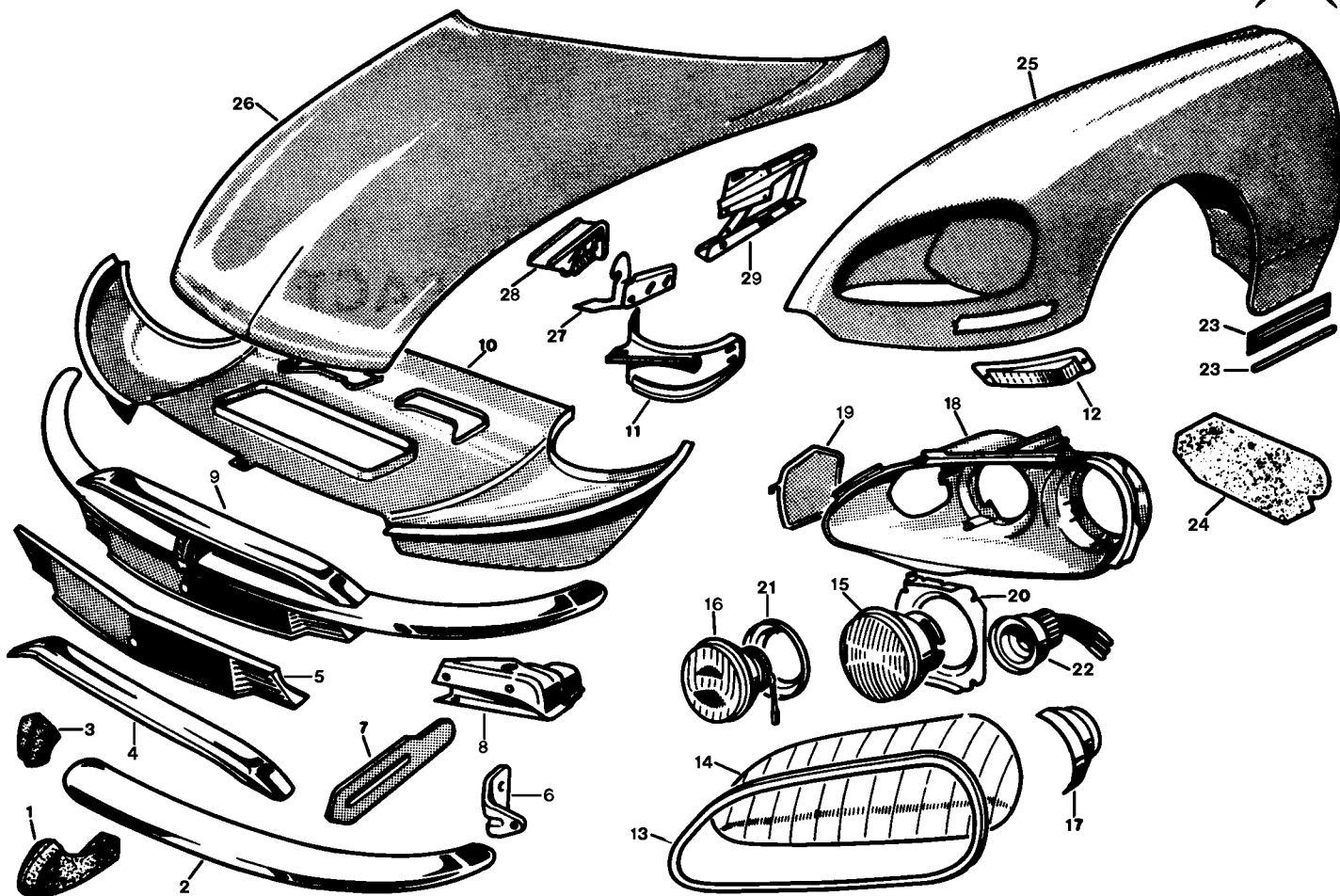
### BODY SHELLS

Page 38 \_\_\_\_\_

### PAINT

Page 39 \_\_\_\_\_

**IMPACT, FRONT**

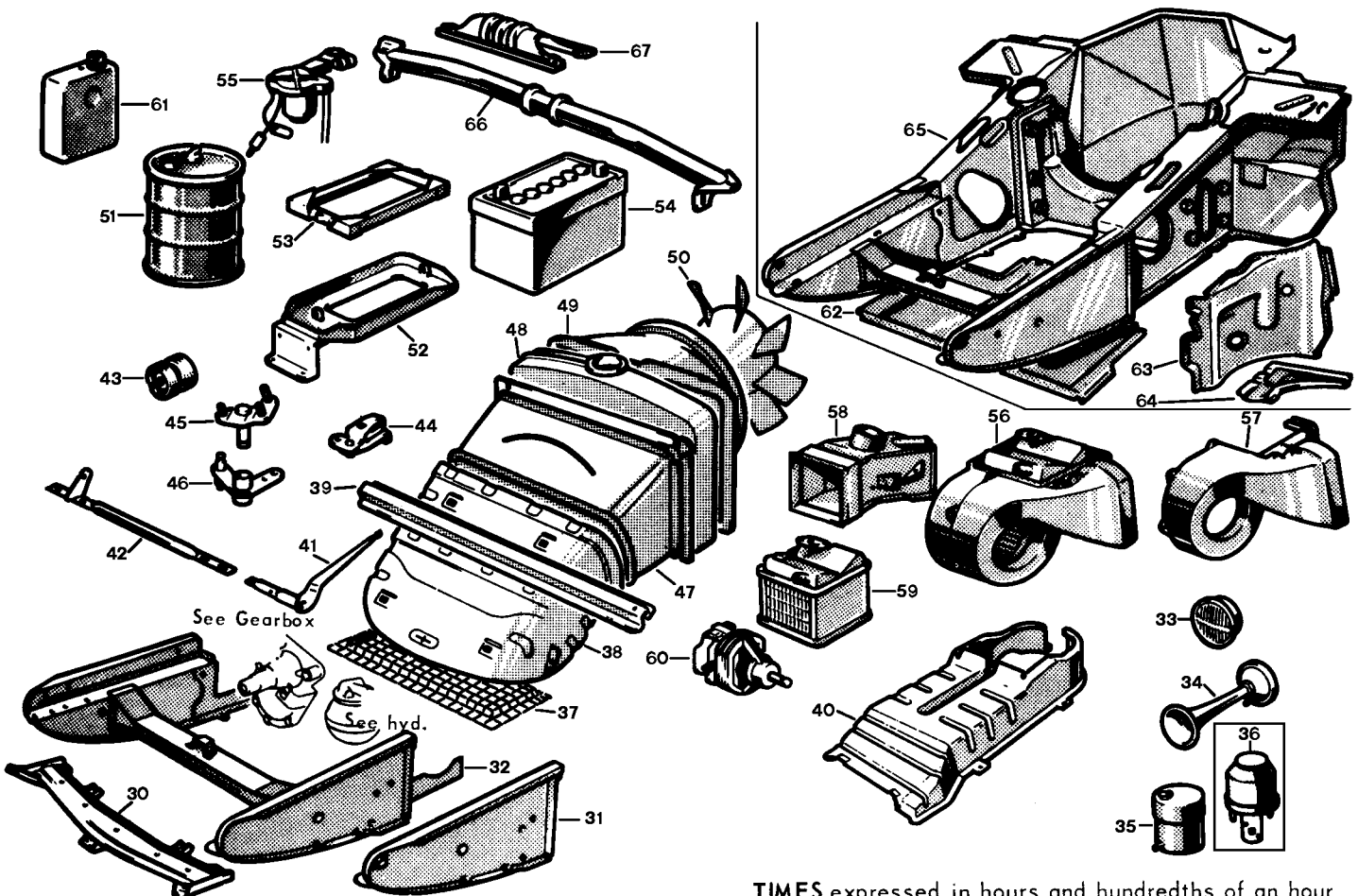


TIMES expressed in hours and hundredths of an hour

Ref.	Operation	Code	Times	Ref.	Operation	Code	Times
1	RUBBER OVER-RIDER ( on vehicle ) - replt. 70.130		0.50	10	FRONT VALANCE ( removed and disconnected ) strip/ressem. for straightening or replacement 60.042		0.30
2	RUBBER OVER-RIDER ( bumper removed ) replt. 70.135		0.15		FRONT VALANCE-repl. incl. adj. headlamps 60.005		3.20
2	HALF-BUMPER, LOWER ( on vehicle ) replt. 70.074		1.90		+ Supplt. SIDE CLOSING PANEL - replt. 60.071		0.30
	HALF-BUMPER, LOWER ( bumpers removed ) replt. 70.072		0.50		+ Supplt. AIR CON ( option ) - rem/ref. necessary units 60.015		+ 0.65
3	CENTRE JOINT RUBBER ( on vehicle ) replt. 70.152		0.50	12	DIRECTION INDICATOR - replt. 53.675		0.25
	CENTRE JOINT RUBBER ( bumpers removed ) - replt. 70.155		0.10	13 &/ or 14	HEADLAMP GLASS- and/or FINISHER - excl. headlamp housing.		
4	BUMPER BLADE, UPPER ( on vehicle ) replt. 70.051		1.20		Replacement incl. rem/ ref. wing and adj. headlamps 53.505		2.45
	BUMPER BLADE, UPPER ( bumpers removed ) - replt. 70.054		0.50		( front wing removed )-replt. 53.503		1.25
5	NO. PLATE SUPPORT PRESSING - replt. incl. rem/ref. front bumper and adjust headlamps 70.167		2.10	25	+ Supplt. MAIN LIGHT UNIT ( 15 ) or LONG RANGE LIGHT-UNIT ( 16 ) - replt. 53.589		+ 0.15
7 or 8	BUMPER BRACKET or AIR INTAKE - replt. 70.107		0.25		WING, FRONT - excl. adj. headlamps rem/ref. 63.003		0.70
	FRONT BUMPER ( wings removed ) - rem/ref. 70.161		1.25		( removed ) strip/ressem. 63.005		2.75
	FRONT BUMPER COMPLETE, incl. adj. headlamps, and raise front wings - rem/ref. 70.005		1.85		Pallas 63.103		3.15
	FRONT BUMPER COMPLETE ( removed ) disassem. reassem. for alignment or replacement of several components 70.007		1.10		repl. incl. adj. headlamps 63.015		4.25
9 & 10	FRONT BUMPER COMPLETE-repl. 70.015		2.30		Pallas 63.105		4.65
	FRONT BUMPER COMPLETE and FRONT VALANCE, incl. adj. headlamps and raise front wings rem/ref. 70.035		2.60	26	+ Supplt. HEADLAMP HOUSING - disassem/reassem. and/or replt. light units 63.066		+ 0.50
	( removed ) disconn/reconn 70.038		0.30		+ Supplt. AIR CON ( option ) - rem/ref. of necessary units 63.032		+ 0.15
	+ Supplt. AIR CONDITIONING ( optional ) rem/ref. necessary units 60.015		+ 0.65		BONNET - rem/ref. 68.005		1.00
					( removed ) strip/ressem. 68.007		2.00
					repl. incl. adj. 68.015		3.40
					+ Supplt. COMPRESSOR HORN - rem/ref. ( option, or standard from 9-73 ) 60.248		+ 0.30

D

IMPACT, FRONT



TIMES expressed in hours and hundredths of an hour

GROUPED OPERATIONS ( including removal/refitting of 2 wings )		Rem/ ref.excl. adj. h/lamps		Strip/ reassem. incl. disc. con.		Replacement incl. adj. h/lamps	
Code	Times	Code	Times	Code	Times	Code	Times
- FRONT BUMPER COMPLETE + FRONT VALANCE	70.032	2.80	■	60.003	0.60	60.209	3.90
- FRONT BUMPER COMPLETE, FRONT VALANCE, 1 SIDE CLOSING PANEL, + 1 FRONT WING	70.032	2.80	■	60.233	● 3.70	60.241	● 7.40
- FRONT BUMPER COMPLETE, FRONT VALANCE, 2 SIDE CLOSING PANELS + 2 FRONT WINGS	70.032	2.80	■	60.246	●● 6.80	60.245	●● 11.00
- FRONT BUMPER COMPLETE, FRONT VALANCE, 1 SIDE CLOSING PANEL, 1 FRONT WING + BONNET	60.253	3.80	■	60.263	● 5.70	60.266	● 10.50
- FRONT BUMPER COMPLETE, FRONT VALANCE, 2 SIDE CLOSING PANELS, 2 SIDE CLOSING PANELS + BONNET	60.253	3.80	■	60.243	●● 8.80	60.267	●● 14.10
● + Supplt. : PALLAS - stripping-assembling a wing	-	-	-	60.270	+ 0.40	-	-
■ + Supplt. : COMPRESSOR HORN - rem. ref. ( option, or std. from 9/73 )	60.248	+0.30	-	-	-	-	-

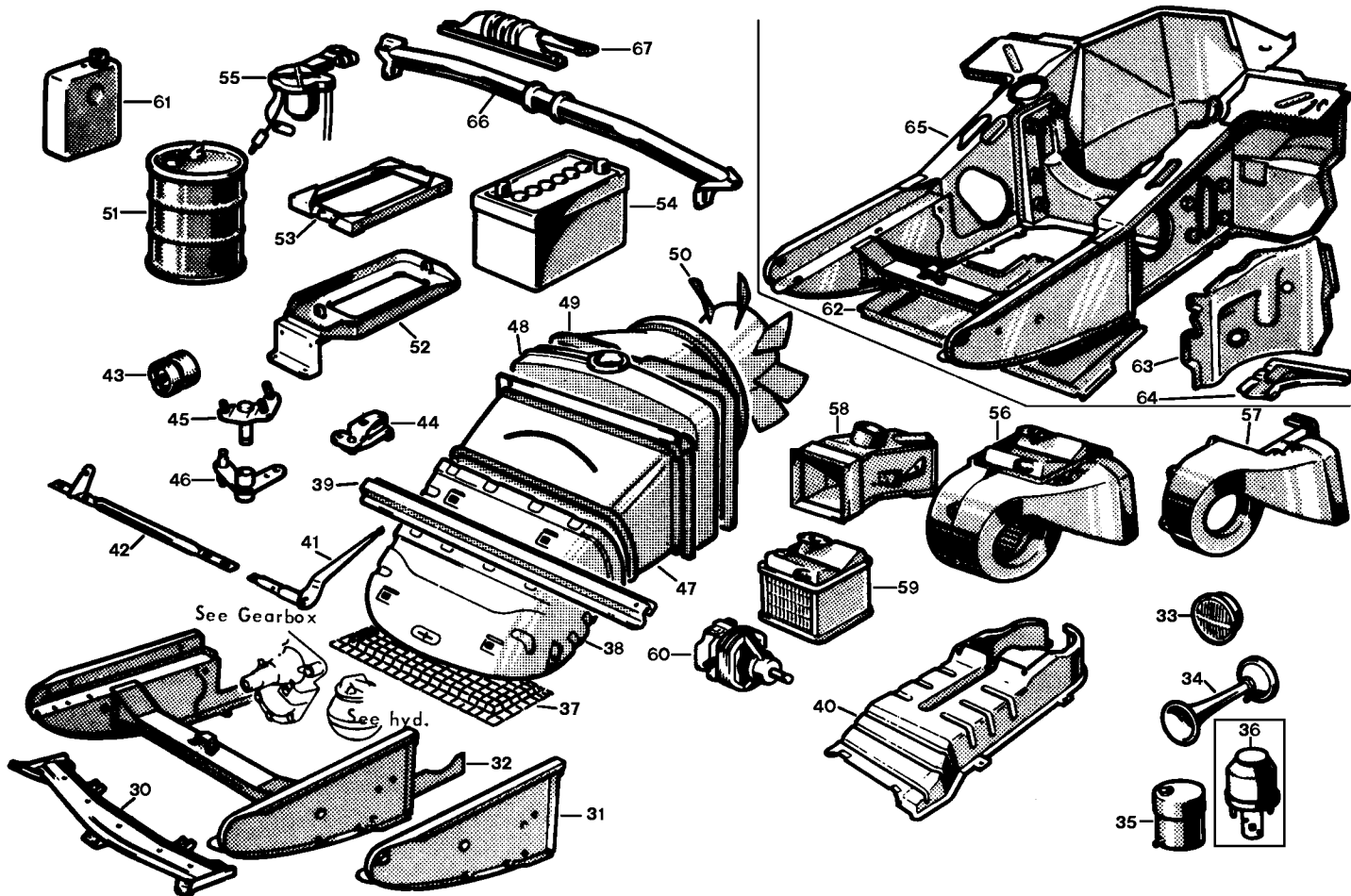
Ref.	Operation	Code	Times
	FRONT AXLE - check geometry with optical device, including : check camber, caster, wheel-alignment, lock-angles - excl. check of heights	24.030	0.85
30	FRONT CROSS MEMBER - replt. incl. : rem/ ref. front wings, bonnet, valance, ft. bumper, horns, air. duct, incl. adj. headlamps	31.038	8.40
	incl. rem/ref. E.C.U. and air filter on EFI	31.038	9.30
	+ Supplt. : AIR CONDITIONING ( option )		
	rem/ ref. of necessary units	31.046	+ 2.75

Ref.	Operation	Code	Times
32	FRONT CAISSON UNIT, FRONT SECTION ( LARGE UNIT not deformed - Ft. geometry correct ) - replt. by de-welding and welding reinforcements on replaced component incl. rem/ ref. front wings, bonnet, valance, bumper, horns air-duct, rad,, brake accumulator, battery and support, panel under gearbox part removal hyd. reservoir, incl. painting, adj. head-lamps and bleed. Excl. check front geometry.		
	M = 3.45 E = 0.50 F = 5.25 T = 7.30	31.025	16.60
	incl. rem/ ref. E.C.U. and air filter for EFI	31.025	17.40
	M = 4.35 E = 0.50 F = 5.25 T = 7.30		
	+ Supplt. GEARBOX (only)-rem/ ref.		
	Mec.	09.185	+6.20
	Hyd.	09.185	+7.30



Other supplements : See page 25 - PAINT - See page 39



# IMPACT, FRONT



TIMES expressed in hours and hundredths of an hour

Ref.	Operation	Code	Times	Ref.	Operation	Code	Times
32	 <b>FRONT CAISSON UNIT, FRONT SECTION</b> ( following impact on FRONT AXLE, cross-bar check correct, LARGE UNIT not deformed ) - Same operation including, in addition rem/ref. front axles for check of LARGE UNIT, insertion of cross bar, incl. adj. heights, front geometry, headlamps, and bleed. M=12.05 E=0.50 F=5.25 T=7.30 31.028 incl. rem/ref. E.C.U. and air filter for EFI M=12.95 E=0.50 F=5.25 T=7.30 31.028 + Supplt. GEARBOX ( only ) - rem/ref. Mec. 09.185 Hyd. 09.185 + Supplt. STEERING RELAY - rem/ref. 24.306 + Supplt. TRACK ROD OUTER - replt. 31.944		25.10 26.00 +6.20 +7.30 +1.55 +0.25	32	 <b>CAISSON FRONT UNIT, FRONT SECTION</b> ( LARGE UNIT deformed in area of relays, cross-bar check correct ) - Same operation as code 31.028 - incl. in addition : rem/ref. engine-gearbox unit ( for body straightening steering relay, heater, hydraulic reservoir, un-clip piping, incl. adj. heights, front geometry, headlamps, bleed, excl. straightening unit. M = 23.60 E=0.50 F=5.25 T=7.30 Carb. Mec 31.026 Carb. Hyd. 31.026 M = 24.40 E=0.50 F=5.25 T=7.30 Incl. rem/ref. E.C.U. with harness, and tester-checking triggering contacts, butterfly spindle switch, and full load switch for EFI M=28.40 E=0.50 F=5.25 T=7.30 EFI Mec. 31.026 M=29.20 E=0.50 F=5.25 T=7.30 EFI Hyd. 31.026 + Supplt. TRACK ROD, OUTER-replt. 31.944		36.65 37.45 41.45 44.05 +0.25

+ Supplt. SWIVEL and/or DRIVE-SHAFT - See COMPLEMENTARY MECHANICAL OPERATIONS

PAINT - See page 39

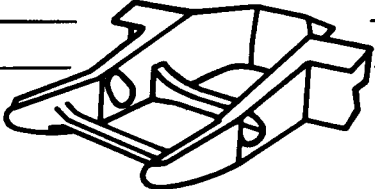
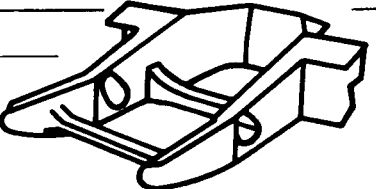
TIMES expressed in hours and hundredths of an hour

Operation	Code	Times	Operation	Code	Times
<b>SUPPLEMENTS COMMON TO OPERATIONS AFFECTING CAISSON FRONT UNIT, FRONT SECTION</b>					
+ Supplt. HORNS ( 33 ) - replt. ....	31.936	+ 0.15	+ Supplt. BATTERY FRAME ( 53 ) - replt.	31.072	+ 0.20
+ Supplt. HORNS 2 - TONE or COMPRESSOR ( 34 or 35 ) - replt. ....	31.934	+ 0.25	+ Supplt. BATTERY, DRY ( 54 ) - replt.	11.062	+ 0.25
+ Supplt. HORNS-COMPRESSOR-RELAYS ( comprising 34,35 and 36 )-replt. ....	31.935	+ 0.70	+ Supplt. STARTER RELAY with CABLE ( 55 ) - replt. ....	31.957	+ 0.20
+ Supplt. AIR DUCT ( 38 ) - replt. ....	31.976	+ 0.70	+ Supplt. MOTOR or 2 HALF-CASINGS ( 56 or 57-heater unit removed ) - replt.	50.303	+ 0.45
+ Supplt. 1 BRAKE DISC COOLING DUCT- ( 40 ) ( disconnected from panel ) - replt.	31.971	+ 0.20	+ Supplt. PANEL under gearbox ( 62 ) incl. disc./con. BRAKE COOLING DUCT-replt.	31.960	+ 0.60
+ Supplt. RADIATOR ( 48 ) - Replacement - except DS 23 and EFI	05.007	+ 0.20	+ Supplt. AIR CON ( option ) - rem/ref. of necessary units	31.029	+ 4.35
Incl. rem/ref. or replt. electric fan DS 23 and EFI	05.009	+ 0.60			

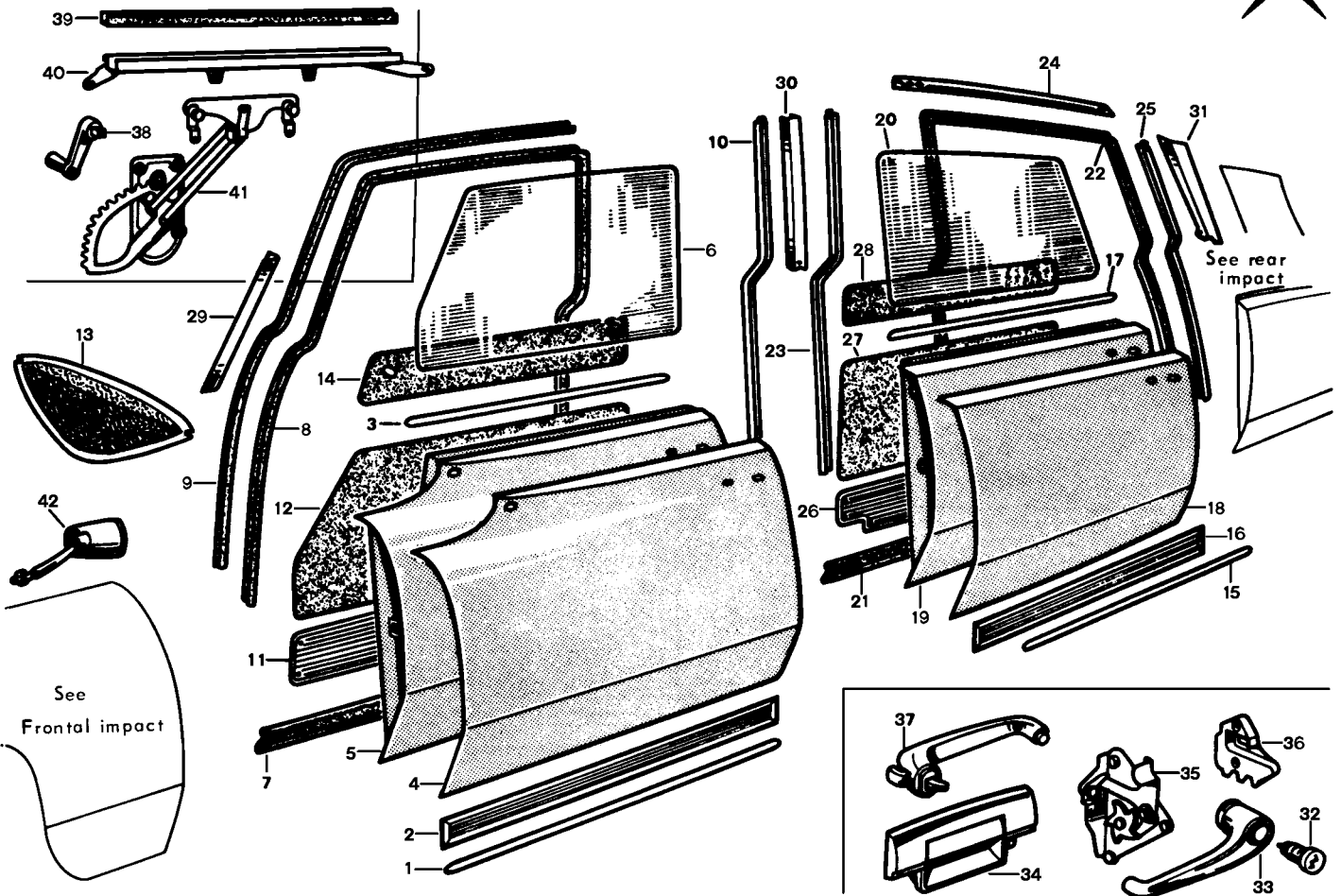
**SUPPLEMENTS TO ANY OPERATION IN WHICH ENGINE-GEARBOX IS REMOVED**

+ Supplt. THERMOSTATIC HEATER VAL - VE - replt. ....	50.332	+ 0.40	+ Supplt. THERMOMETER SENDER - replt.	50.319	+ 0.40
+ Supplt. HEATER TAKE-OFF TUBE-replt.			+ Supplt. CABLE, FT, AUTO HEADLAMP-BEAM CONTROL - replt. ....	53.621	+ 0.50
Carb.	50.359	+ 0.45	+ Supplt. GB SUPPORT X-MEMBER ( 66 ) - replt. ....	07.032	+ 0.40
EFI	50.359	+ 0.65			

Other Supplements : See COMPLEMENTARY OPERATIONS

Ref.	Code	Times	Ref.	Code	Times
65			65		
					
	CAISSON FRONT UNIT COMPLETE ( on body jig ) - putting body on jig for straightening FRONT UNIT incl. : rem/ref. engine gearbox unit, axles front and rear, exhaust assembly under body, rear suspension cylinders, steering relays, panel under GB, fuel tank with piping, Hyd. reservoir and battery support. Incl. rem/ref. bonnet, wings, Ft. and R. front valance, front bumper, doors front and rear, front seats, incl.-complete adj. headlamps and bleed.			CAISSON FRONT UNIT COMPLETE - replt. by de-welding and re-welding incl. : rem/ref. engine/GB, front and rear axles, steering relays, exhaust assem., suspension cylinders, front and rear, fuel tank, hydraulic pipes in side-member, petrol piping, overflow return piping, strip/reassem. complete of FRONT UNIT. Incl. rem/ref. bonnet, wings, front and rear, valance, front bumper, front doors, front seats and rear bench seat,windscreen instrument panel, fascia board, front wiring, harness, incl. complete adj. headlamps and bleed.	
	Put on jig =2.70 M=30.45 E=0.50 F=7.35 Carb. Mec. 31.035	41.00		Put on jig=2.70 M=52.95 E=10.00 S=4.30 F=8.35 T=25.00 ..... Carb. Mec. 31.037	103.30
	Put on jig = 2.70 M=31.25 E=0.50 F=7.35 Carb. Hyd. 31.035	41.80		Put on jig=2.70 M=54.50 E=10.00 S= 4.30 F=8.35 T=25.00 ..... Carb. Hyd. 31.037	104.85
	Incl. rem/ref. E.C.U. with harness, and tester-check of triggering contacts, butterfly spindle switch, and full-load switch for EFI,			Incl. rem/ref. E.C.U. with harness and tester-check of triggering contacts, butterfly spindle switch and full load switch for EFI.	
	Put on jig=2.70 M=35.25 E=0.50 F=7.35 EFI Mec. 31.035	45.80		Put on jig=2.70 M=57.75 E=11.65 S=4.30 F=8.35 T=25.00 ..... EFI Mec. 31.037	109.75
	Put on jig=2.70 M=36.05 E=0.50 F=7.35 EFI Hyd. 31.035	46.60		Put on jig=2.70 M=59,30 E=11.65 S=4.30 F=8.35 T=25.00 ..... EFI Hyd. 31.037	111.30
	CROSS BAR CHECK ( to be subtracted if unit is replaced )	0.80		+ Supplt. PALLAS - S = +0.65	+0.65
	+ Supplt. ENGINE HOUSING - detrim/retrim E = 1.30 S = 1.20	+ 2.50		+ Supplt. JACKING TUBE SUPPORT ( see ref. 45 in SIDE IMPACT - 2nd sect. ) - replt. T = + 3.00	+3.00
	+ Supplt. LH SIDE ( for straightening in area of half-housing fixing ) rem/ref. brake control with pipe assembly, gear change relay, or hyd. select. pipes - M = + 3.60	+ 3.60		+ Supplt. JACKING TUBE SUPPORT, SIDE MEMBER CLOSING PANEL; + SIDE MEMBER EXTENSION WITH REINF. ( see refs. 45, 67 and 73 in SIDE IMPACT; 2nd sect. ) - replt. T = + 5.75	+5.75
	+ Supplt. MAIN PIPING and PRIORITY VALVE with PIPING-rem/ref..	+ 3.40		+ Supplt. SCUTTLE PANEL, SCUTTLE front with X-MEMBER ( see refs 55 and 56 in SIDE IMPACT-2nd sect. ) - replt. T = + 3.00	+3.00
	+ Supplt. CAISSON UNIT, FRONT SECTION replt. - T = + 11.10	+11.10		+ Supplt. AIR CON ( option ) - rem/ref. all the units	+9.10
	+ Supplt. EXHAUST - replt. of one or more components	+ 1.00			
	+ Supplt. AIR CON ( option ) - rem/ref. all the units	+ 9.10			

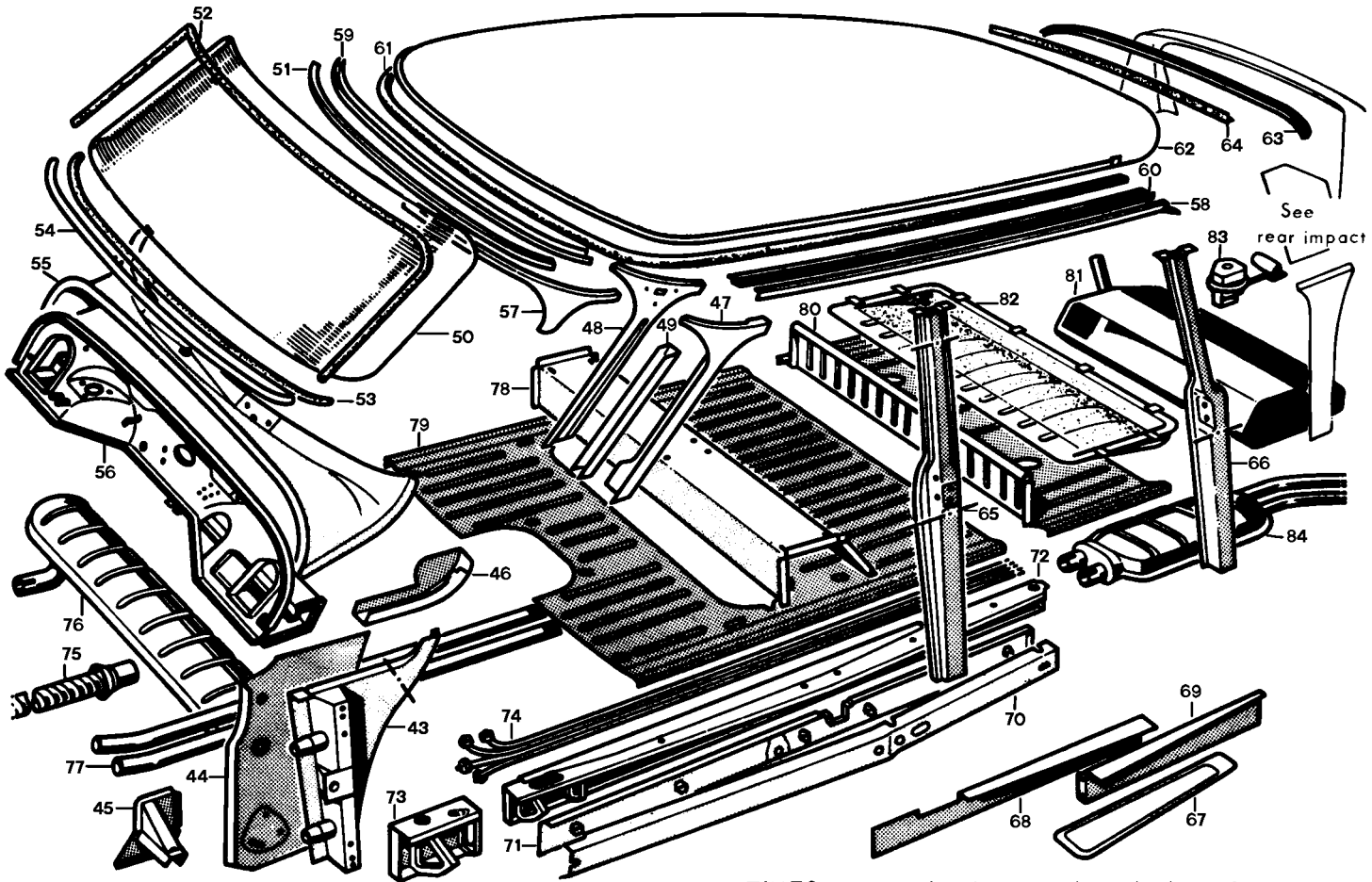
# IMPACT, SIDE



TIMES expressed in hours and hundredths of an hour

PAINT - See page 39

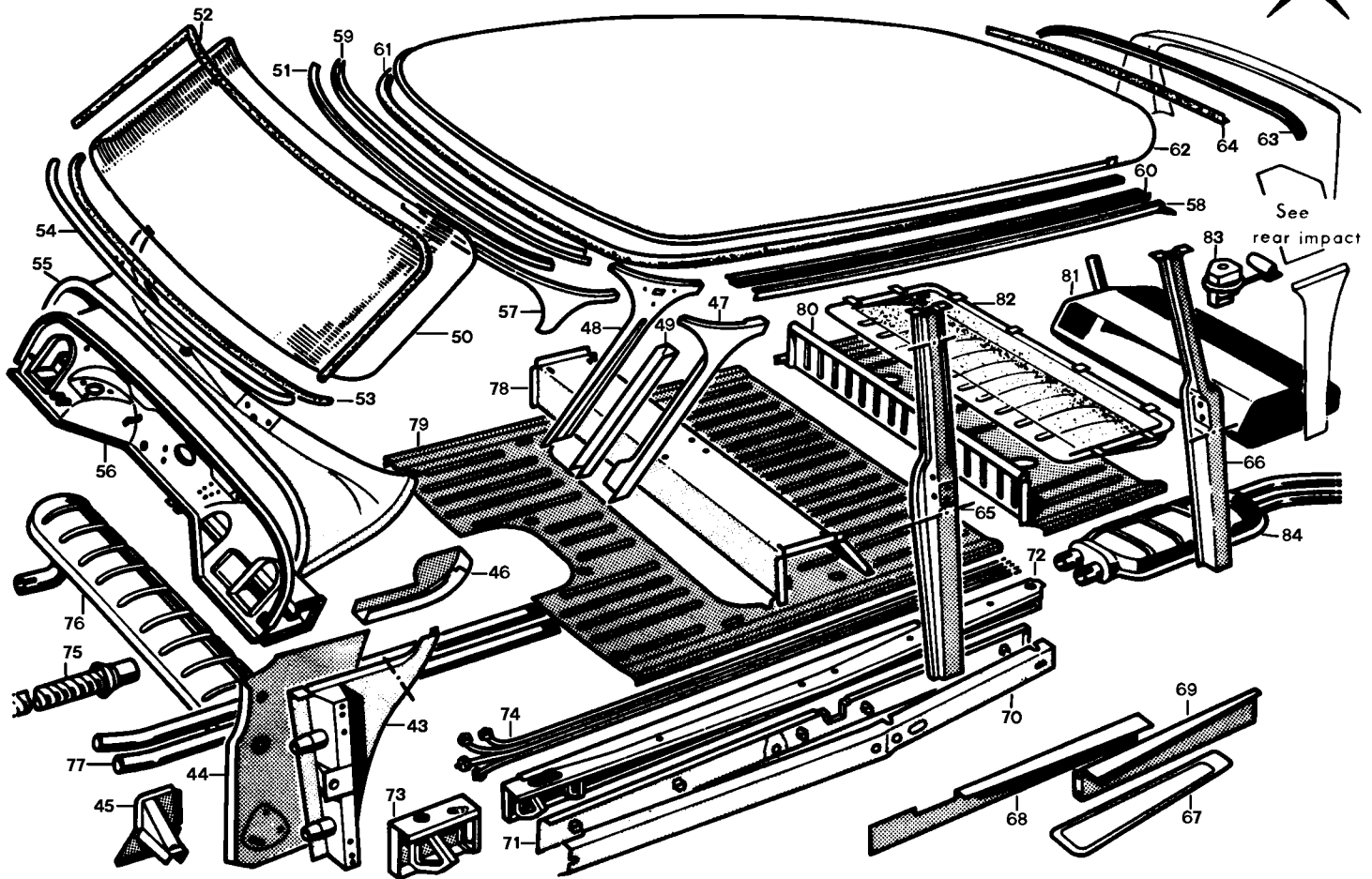
Ref.	Operation	Code	Times	Ref.	Operation	Code	Times
1 or 2 15 or 16	FINISHING STRIPS UPPER OR LOWER ON DOOR FRONT OR REAR - replt. Pallas 65.155		0.20	18	DOOR SKIN, REAR - replt. incl. adj. → 9-71 66.424		■ 3.20
3 or 17	FINISHING STRIP, CENTRE, of FT. DOOR replt. Pallas 65.150		1.20		incl. rem/ref. glass → 9-71 66.433		■ 3.55
—	FINISHING STRIP CENTRAL OF REAR - DOOR - replt. Pallas 66.158		0.80		Pallas → 9-71 66.426		■ 4.25
4	DOOR-SKIN OUTER, FRONT (door removed) replt. → 9-71 65.419	● *	3.15	19	DOOR, REAR - rem/ref. → 9-71 66.003		■ 4.60
—	incl. adj. → 9-71 65.424	● ● *	3.95		(removed)-strip/reassem. → 9-71 66.005		● 3.00
—	Pallas → 9-71 65.421	● ● *	4.25		→ 9-71 66.012		● 3.25
—	incl. rem/ref. glass Pallas 9-71 → 65.436	● ● *	5.05		Pallas → 9-71 66.025		● 4.20
—	DOOR SKIN OUTER, FRONT - replt. incl. adj. → 9-71 65.424	● ● *	3.40		Pallas 9-71 → 66.032		● 4.45
—	incl. rem/ref. glass 9-71 → 65.433	● ● *	4.20		replt. incl. adj. → 9-71 66.015		● 3.80
—	Pallas → 9-71 65.426	● ● *	4.50		→ 9-71 66.020		● 4.05
—	incl. rem/ref. glass Pallas 9-71 → 65.439	● ● *	5.30		Pallas → 9-71 66.028		● 5.00
5	FRONT DOOR - rem/ref. (removed) strip/reassem. → 9-71 65.003	● ● *	0.25		Pallas 9-71 → 66.035		● 5.25
—	→ 9-71 65.005	● ● *	3.00	32	LOCK BARREL - replt. 65.210		● 0.75
—	→ 9-71 65.012	● ● *	3.35	—	LOCK BARRELS (set of 3), front doors and boot lid - replt. 65.212		1.50
—	Pallas → 9-71 65.025	● ● *	4.25	33	HANDLE, OUTER, for front or rear door-replt. → 9-71 65.244		0.75
—	Pallas 9-71 → 65.032	● ● *	4.60	34	HANDLE, OUTER, for front or rear door-replt. 9-71 → 66.244		1.40
—	replt. incl. adj. → 9-71 65.015	● ● *	3.70		(glass removed) - replt. 9-71 → 65.339		0.45
—	→ 9-71 65.020	● ● *	4.05	35	DOOR LOCK, Ft. or rear - → 9-71 65.228		0.50
—	Pallas → 9-71 65.028	● ● *	4.95	—	LOCK (assembly) front or rear - replt. 9-71 → 66.228		1.40
—	Pallas 9-71 → 65.035	● ● *	5.30		(glass removed) - replt. 9-71 → 65.336		0.45
6 or 20	GLASS, DOOR FT. or REAR-replt. 65.325	● ● *	1.30	36	STRIKING PLATE for door front or rear-replt. 65.293		0.25
—	GLASS, DOOR FT. or REAR (broken) - replt. 65.327		2.00	37	DOOR HANDLE INNER, front or rear - replt. 65.278		0.50
8 or 22	DOOR OPENING RUBBER, front or rear - replt. 65.467		2.00	41	WINDOW WINDER, door front or rear - replt. 65.310		1.40
12 or 27	DOOR TRIM PANEL, front or rear - replt. 65.401		0.25	42	DOOR MIRROR - replt. 65.487		0.25
13	DOOR ARM-REST, front or rear-replt. 65.558		0.15	(*) -	+ Supplt. OUTSIDE MIRROR - rem/ref. or replt. On LH door 65.487		+ 0.25
18	DOOR SKIN OUTER, REAR (door removed) replt. → 9-71 66.419	■	2.85		On RH door 65.488		+ 0.40
—	incl. rem/ref. glass 9-71 → 66.430	■	3.20	(●) -	+ Supplt. GLASS or GLASS CHANNEL - replt. 65.097		+ 0.35
—	Pallas → 9-71 66.421	■	3.90	(■) -	+ Supplt. GLASS or GLASS CHANNEL - replt. 65.096		+ 0.60
—	incl. rem/ref. glass Pallas 9-71 → 66.436	■	4.25				



TIMES expressed in hours and hundredths of an hour

Ref.	Operation	Code	Times	Ref.	Operation	Code	Times
43	PILLAR, FRONT, LOWER ( section ) - replt. by cutting away, de-welding and welding including rem/ ref. front wing, front door, seat, carpet, part side member trim, and rear wing-incl. adj. headlamps, and also :-RH side, rem/ ref. petrol pipe and overflow return. M=2.05 E=2.55 S=1.20 F=4.65 T=5.95 RH 31.077 ●16.40 - LH side, rem/ ref. general piping, height control, and brake bleed. M=3.70 E=3.45 S=1.20 F=4.65 T=5.95 LH 31.076 ●18.95			43, 46 47, 48, & 49	FRONT PILLAR, LR, COMPLETE, CLOSING PANEL, UPPER FOR FT, PILLAR, UPPER FRONT PILLAR, INNER PILLAR and CHANNEL for WINDSCREEN - same operation, incl. also rear ref. bonnet, roof seat, and door opening rubbers : M=2.05 E=2.80 S=1.85 F=11.00 T=10.40 RH side 31.090 ●28.10 M=3.70 E 3.90 S=1.85 F=11.00 T=10.40 LH side 31.105 ●30.85		
	+ Supplt. PALLAS-rem/ ref. embell. 31.078 +0.25				+ Supplt. PALLAS-rem. ref. embell. on can-trail, inner roof surround, and for seats. S = + 1.10 ..... 31.194 +1.10		
	+ Supplt. JACKING TUBE SUPP ( 45 ) - replt. .... 31.031 +3.00				+ Supplt. SCUTTLE SIDE PANEL (44)-replt. .... 31.089 +4.35		
	+ Supplt. BODY SIDE MEMBER (70, ft. section) - replt. .... 31.084 +1.00				+ Supplt. JACKING TUBE SUPPORT ( 45 )-replt. .... 31.031 +3.00		
	+ Supplt. BODY SIDE MEMBER (ft. section) FRONT PILLAR GUSSET, and SIDE MEMBER CLOSING PANEL ( 67 and 70 ) replt. .... 31.088 +1.80				+ Supplt. BODY SIDE MEMBER (70, ft. section) - replt. .... 31.084 +1.00		
	+ Supplt. BODY SIDE MEMBER (ft. section) FRONT PILLAR GUSSET, SIDE MEMBER CLOSING PANEL and JACKING TUBE support ( 45, 67 & 70 ) - replt. .... 31.085 +4.80				+ Supplt. BODY SIDE MEMBER (ft. section) FRONT PILLAR GUSSET, SIDE MEMBER CLOSING PANEL ( 67 and 70 ) - replt. .... 31.088 +1.80		
43	PILLAR FT, LR, COMPLETE - same operation including also : rem/ ref. windscreen and part of fascia : M=2.05 E=2.80 S=1.50 F=6.50 T=5.70 RH 31.082 ●18.55 M=3.70 E=3.90 S=1.50 F=6.50 T=5.70 LH 31.080 ●21.30				+ Supplt. ROOF CANTRAIL ( 58, ft. section ) - replt. .... 31.081 +2.90		
	+ Supplt. PALLAS-rem/ ref. embell. 31.078 +0.25				+ Supplt. ROOF CANTRAIL ( 58, ft. section ) and cantrail ( 59, side section, part front centre pillar)-Replt. .... 31.053 +5.00		
	+ Supplt. JACKING TUBE SUPP (45)-replt. .... 31.031 +3.00				+ Supplt. ROOF ( 62 - replt. incl. sticking - head-lining ) all types ..... 69.016 +0.80		
	+ Supplt. BODY SIDE MEMBER (70, ft. section) - replt. .... 31.084 +1.00				+ Supplt. BONDED ROOF - rem/ ref. 31.984 +5.50		
	+ Supplt. BODY SIDE MEMBER (ft. section) FRONT PILLAR GUSSET and SIDE MEMBER CLOSING PANEL ( 67 + 70 ) -replt. .... 31.088 +1.80				● = + Supplt. EFI rem/ ref E.C.U. .... 31.988 +0.65		
	Supplt. BODY SIDE MEMBER (ft. section), FRONT PILLAR GUSSET, SIDE MEMBER CLOSING PANEL and JACKING TUBE SUPPORT ( 45, 67 and 70 ) replt. 31.085 +4.80						

# IMPACT, SIDE



TIMES expressed in hours and hundredths of an hour

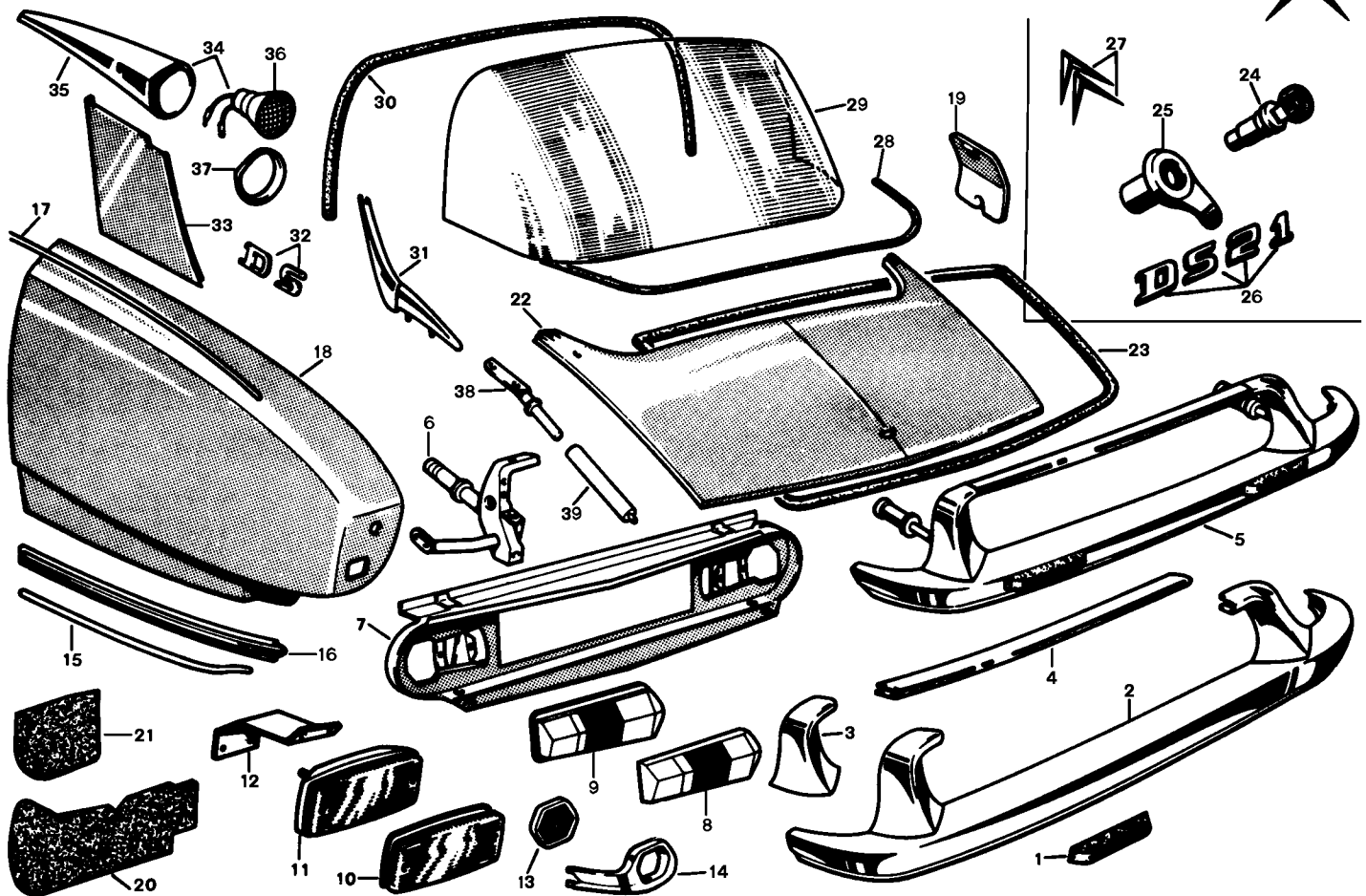
Ref.	Operation	Code	Times	Ref.	Operation	Code	Times		
45	JACKING TUBE SUPPORT, FT. - replt. by de-welding and welding incl. rem/ref. ft. wing, ft. door, and rear wing, - incl. adj. headlamps and also: - for RH SIDE : rem/ ref. fuel and overflow - return pipes M=2.05 F=2.80 T=3.00 RH side 31.098 ● 7.85 - for LH SIDE : rem/ ref. general piping, and brake bleed M=2.65 F=2.80 T=3.00 LH side 31.097 ● 8.45			47, 48 & 49	PILLAR, UPPER, FT. INNER PILLAR and SIDE CHANNEL for SCREEN - replt. by de-welding and welding, incl. rem/ ref. bonnet, wing, ft. door, seats, screen, roof, door opening rubbers, part removal fascia board, incl. adj. headlamps E=3.00 S=1.00 F=9.00 T=6.00 31.050 ● 19.00 + Supplt. PALLAS 31.194 +1.10 + Supplt. ROOF CANTRAIL (58, ft. section) - replt. 31.051 +2.90 + Supplt. ROOF CANTRAIL (58, ft. section) and cantrail (59, side section, part of ft. pillar) - replt. 31.053 +5.00 + Supplt. ROOF (62) - replt. incl. sticking-inner lining ( all types ) 69.016 +0.80 + Supplt. for BONDED ROOF-rem/ ref. 31.984 +5.50			66	REAR PILLAR, PART ( section below striking plate ) - replt. by cutting, de-welding and welding, incl. rem/ ref. rear wing, door bench seat and carpet-de-trim/ trim rear pillar S=1.00 F=2.70 T=4.70 31.190 ● 8.40 + Supplt. PALLAS : S = + 0.25 31.078 +0.25 + Supplt. CLOSING PANELS, FT. of WHEEL ARCH and SIDE of REAR PILLAR - replt. incl. rem/ ref. height corrector, rear, incl. adj. heights M = +1.40 T = +2.10 RH side 31.234 +3.50 M = +3.00 T = +2.10 LH side 31.232 +5.10
50	WINDSCREEN (unbroken) or surround rubbers - rem/ ref. or replt. 60.105 2.10 WINDSCREEN (broken)-replt. incl. cleaning out 60.115 2.60			66	REAR PILLAR COMPLETE - same operation incl. also : rem/ ref. roof and boot lid. E=0.65 S=1.60 F=8.20 T=4.35 31.193 ● 14.80 + Supplt. PALLAS - S = +1.10 31.194 +1.10 + Supplt. CLOSING PANELS, FT. of WHEEL ARCH and SIDE of REAR PILLAR-replt. incl. rem/ ref. height corrector, rear- incl. adj. heights M = +1.40 T = +2.10 RH side 31.234 +3.50 M = +3.00 T = +2.10 LH side 31.232 +5.10 + Supplt. QUARTER PANEL, INNER - replt. incl. rem/ ref. rear window S = +0.20 F = +0.80 T = +1.75 31.235 +2.75 + Supplt. ROOF - replt. incl. sticking head-lining ( all types ) 69.016 +0.80 + Supplt. for BONDED ROOF-rem/ ref. 31.984 +5.50				
62	ROOF : rem/ ref. bolted 69.005 5.20 bonded, std 69.004 11.70 bonded, pallas 69.003 12.40 ROOF : replt. incl. sticking head-lining - bolted 69.015 6.00 bonded, std 69.012 12.50 bonded, pallas 69.019 13.20			70	BODY SIDE MEMBER OUTER PANEL, section under front and rear doors - replt. by cutting, de-welding and welding, incl. rem/ ref. door front or rear, seat front or rear bench seat, carpet, partial de-trim and trim side member. S=1.45 F=2.45 T=2.70 31.242 ● 6.60 + Supplt. PALLAS - rem/ ref. embell. 31.078 +0.25 + Supplt. EFI rem/ ref. E.C.U. 31.988 +0.65				

TIMES expressed in hours and hundredths of an hour

Ref.	Operation	Code	Times	Ref.	Operation	Code	Times
65	CENTRE PILLAR ( part, offset section level with seat belt fixing ) - replt. by cutting de-welding and welding, incl. rem/ref. door front and rear, seat, carpet, and seat belt E=0.45 S=1.40 F=4.75 T=3.50 ..... 31.129		●10.10	65, 70 71 & 72	CENTRE PILLAR ( part or whole ), BODY SIDE MEMBER, SIDE MEMBER INNER PANEL AND SIDE MEMBER ( part or whole ) - replt. by cutting and de-welding and welding incl. rem/ref. axles front and rear for putting on jig ( engine-gearbox remaining in situ ), side doors, seats ft. and rear, petrol tank, panels on side members, seat belts. incl. adj. bleed, and : - for RH side - rem/ref. petrol and overflow return piping - for LH side - rem/ref. general hyd. piping and wiring harness		
	SAME OPERATION PLUS BODY SIDE MEMBER OUTER PANEL, section between front pillar and rear pillar, incl. rem/ref. wings front and rear, and adj. headlamps E=0.95 S=1.40 F=6.00 T=5.85 ..... 31.126 + Supplt. PALLAS - S = + 0.50 ..... 31.113 + Supplt. - for RH side : rem/ref. fuel and overflow return piping Car. RH side ..... 31.240 incl. rem/ref. E.C.U. fuel pump and filter EFI RH side ..... 31.240 - for LH side : rem/ref. general hyd. piping and wiring harness M = + 3.70 E = + 2.40 Carb. or EFI LH side ..... 31.239		●14.20 + 0.50			SIDE MEMBER ( part ) and CENTRE PILLAR ( part )	
65	+ Supplt. SIDE MEMBER INNER PANEL (section between front and rear pillars ) -repl. incl. - for RH SIDE ; rem/ref. fuel and overflow return piping M = + 2.00 T = + 2.80 Carb. RH side ..... 31.248 incl. rem/ref. E.C.U. fuel pump and filter M = + 2.75 T = + 2.80 EFI RH side ..... 31.248 - for LH SIDE : rem/ref. general hyd. piping and wiring harness M = + 3.70 E = + 2.40 T = + 3.10 Carb. or EFI LH side ..... 31.247		+ 2.00 + 2.75 + 6.10	Fit on jig	M E S F T side type Code	RH Sal 31.979 RH Sal 31.981 RH Est 31.979 LH Est 31.981	●55.00 ●59.65 62.70 68.20
	+ Supplt. PALLAS S = + 0.50 ..... 31.113 + Supplt. FRONT PILLAR, LOWER (43 part) - replt. T = + 8.50 ..... 31.982 + Supplt. REAR PILLAR (66 - section under striking plate ) - replt. S = + 0.70 T = + 4.20 ..... 31.983		+ 0.50 + 8.50 + 4.90				
65	CENTRE PILLAR COMPLETE ( deformation of roof or cantrail ) - replt. by de-welding and welding incl. rem/ref. doors ft. and rear, ft. seats, carpet, roof, seat belts, and detrim/retrim ( partial ) body side member. E=0.45 S=1.75 F=9.35 T=2.70 ..... 31.133		●14.25	Fit on jig	M E S F T side type Code	RH Sal 31.114 RH Sal 31.112 RH Est 31.114 LH Est 31.112	●62.00 ●66.65 64.60 70.10
	SAME OPERATION with SIDE MEMBER OUTER PANEL, section between front and rear pillars, incl. rem/ref. wings front and rear and adj. headlamps. E = 0.95 S = 1.75 F = 10.60 T = 5.05 31.131		+ 5.55				
65	+ Supplt. ROOF CANTRAIL ( 60, section - between front and rear pillars ) - replt. by cutting out. T = + 4.30 ..... 31.238		+ 4.30	Fit on jig	M E S F T side type Code	RH Sal 31.986 LH Sal 31.987 RH Est 31.986 LH Est 31.987	●58.80 ●63.85 61.90 67.40
	+ Supplt. ROOF ( 62 ) - replt. incl. sticking head-lining ( all types ) ..... 69.016		+ 0.80				
65	+ Supplt. for BONDED ROOF - rem/ref. 31.984		+ 5.50	Fit on jig	M E S F T side type Code	RH Sal 31.109 RH Sal 31.107 RH Est 31.109 LH Est 31.107	●65.80 ●70.85 68.40 73.90
	+ Supplt. PALLAS - rem/ref. finishing strip on cantrail, interior cantrail padded finisher, and seat S = + 1.40 ..... 31.110		+ 1.40				
65	+ Supplt. : - for RH SIDE : rem/ref. fuel and overflow return piping Carb. RH side ..... 31.240 incl. rem/ref. E.C.U. fuel pump and filter EFI RH side ..... 31.240 - for LH SIDE : rem/ref. general hyd. piping and wiring harness M = + 3.70 E = + 2.40 Carb. or EFI LH side ..... 31.239		+ 2.00 + 2.75 + 6.10	Fit on jig	M E S F T side type Code	RH Sal 31.109 RH Sal 31.107 RH Est 31.109 LH Est 31.107	●65.80 ●70.85 68.40 73.90
	+ Supplt. SIDE MEMBER INNER PANEL (71, section between front and rear pillars ) - replt. incl. : - for RH SIDE : rem/ref. fuel and overflow return piping M = + 2.00 T = + 2.80 Carb. RH side ..... 31.248 incl. rem/ref. E.C.U. fuel pump and filter M = + 2.75 T = + 2.80 EFI RH side ..... 31.248 - for LH SIDE : rem/ref. general hyd. piping and wiring harness M = + 3.70 E = + 2.40 T = + 3.10 Carb. or EFI LH side ..... 31.247		+ 4.80 + 5.55 + 9.20				

**IMPACT, REAR**

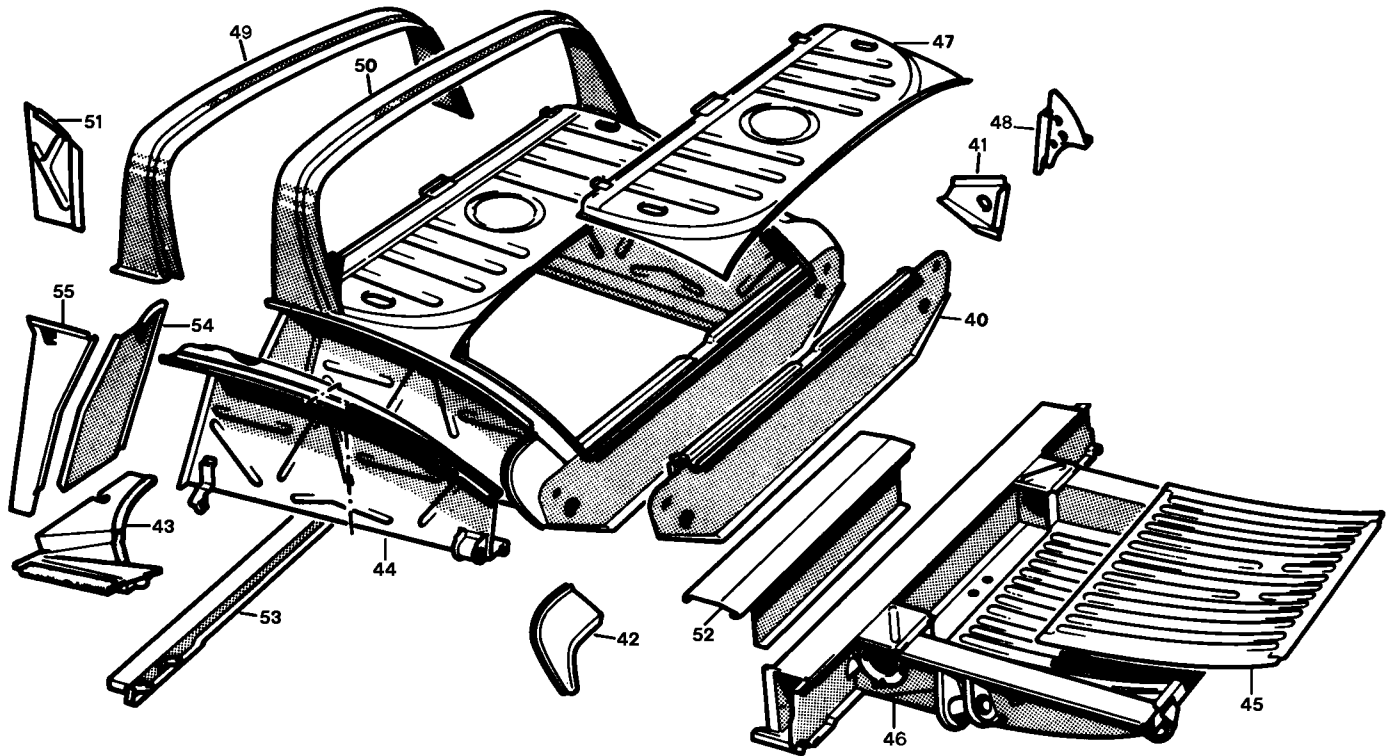
**SALOONS**



TIMES expressed in hours and hundredths of an hour

Ref.	Operation	Code	Times	Ref.	Operation	Code	Times
1	RUBBER BUFFER ( on vehicle ) - replt. 71.125		0.40	20 or 21	MUDFLAP, FRONT OR REAR, FOR REAR WING, incl. rem/ref. wing - replt.	64.162	0.50
2	BUMPER, REAR, LOWER ( bumpers removed ) - replt. → 72	71.085	0.80		Same Op. (wing removed) - replt.	64.170	0.30
		72 → 71.086	1.50	22	BOOT LID rem/ref. ( removed ) strip/ reassem.	67.003	0.40
4	REAR BUMPER UPPER BLADE ( bumpers removed ) - replt.	71.075	0.60		Pallas	67.025	1.60
5	REAR BUMPER COMPLETE - rem/ref.	71.005	0.80		replt. incl. adj...	67.015	1.80
					Pallas	67.028	2.20
—	REAR BUMPER COMPLETE ( removed ) disassem/ reassem. for re-alignment			24	BOOT LID LOCK-BARREL or PUSH-BUTTON HOUSING - replt.	67.428	0.50
	→ 72	71.007	0.80	—	LOCK-BARREL for FRONT DOORS AND BOOT LID - replt.	65.212	1.50
	72 →	71.002	1.50	26	MONOGRAM on boot lid - replt.	67.408	0.25
—	REAR BUMPER COMPLETE - replt.			27	CHEVRONS on boot lid - replt...	67.407	0.30
	→ 72	71.015	0.90	29	REAR WINDOW GLASS ( unbroken ) - rem/ref. or replt.	61.001	1.25
	72 →	71.012	1.60		REAR WINDOW GLASS ( broken ) - replt. incl. cleaning out	61.007	1.75
7	REAR NUMBER PLATE - incl. rem/ref. bumper - excl. painting numbers - replt.	71.220	1.75	33	QUARTER-PANEL or BOOT LID HINGE replt.	62.113	0.75
	( bumper removed ) replt.	71.278	0.95	35	HOUSING FOR REAR DIRECTION INDICATOR - replt.	53.742	0.50
8	GLASS FOR REAR LAMP CLUSTER - replt.	53.728	0.10	37	RIM FOR REAR DIRECTION INDICATOR replt.	53.748	0.15
9	REAR LAMP CLUSTER COMPLETE-replt.	53.705	0.40	38 or 39	STAY FOR BOOT LID - replt.	67.089	0.10
11 or 12	REVERSING LAMP OR BRACKET - replt.	53.724	0.40		TOWING ATTACHMENT - fit	31.377	5.60
15	FINISHER, LOWER, REAR WING-replt.	64.191	0.35				
16	FINISHER, CENTRE, REAR WING-incl. rem/ref. wing - replt.	64.189	0.75				
17	FINISHER, UPPER, REAR WING-replt.	64.187	0.15				
18	REAR WING - rem/ref.....	64.003	0.20				
	( removed ) strip/ reassem. ....	64.005	0.80				
	strip/ reassem. without recovering Pallas	64.103	1.50				
	strip	64.015	1.40				
	Replacement..	64.015	1.40				
	replt. without recovering Pallas strip	64.106	2.10				

PAINT - See Page 39



TIMES expressed in hours and hundredths of an hour

GROUPED OPERATIONS		remove/ fit		Strip/ reassem.		Replacement	
		Code	Times	Code	Times	Code	Times
REAR BUMPER COMPLETE AND BOOT LID .....		—	1.20	71.041	* 1.30	71.043	* 2.70
	Pallas	—	1.20	71.040	* 1.70	71.044	* 3.10
REAR BUMPER COMPLETE - BOOT LID - ONE WING .....		—	1.40	71.019	* 2.10	71.021	* 4.10
	Pallas	—	1.40	71.020	* 3.20	71.059	* 5.20
REAR BUMPER COMPLETE - BOOT LID - TWO WINGS .....		—	1.60	71.024	* 2.90	71.027	* 5.50
	Pallas	—	1.60	71.023	* 4.70	71.028	* 7.30
(*) + Supplt. : REVERSING LAMPS .....		72	—	71.003	+0.70	71.003	+0.70

Ref.	Operation	Code	Times	Ref.	Operation	Code	Times
40	REAR PANEL-replt. incl. rem/ref. bumper, number plate, rear wings, boot lid, detrim/retrim partly, wheel arch and side member of rear unit. E=0.70 S = 0.85 F=3.60 T=3.65	31.320	* 8.80	40,42 44 & 54	REAR PANEL-WHEEL ARCH COMPLETE FRONT CLOSING PANELS FOR WHEEL ARCH-REAR PANEL EXTENSIONS (wheel alignment correct). - Same operation, incl. in addition, rem/ref. rear bench seat, petrol tank, rear window glass, quarter panel, excl. check of geometry, incl. : For RH side : rem/ref. wheels, filler neck, mudshields, rear piping, and bleed E = 0.70 M = 6.10 S = 1.60 F = 5.00 T = 13.30 RH side 31.336		* 26.70
40 & 42	REAR. PANEL AND SIDE EXTENSION PANELS - Same operation, incl. also, RH side : rem/ref. wheel, mudshield, and filler neck. E = 0.70 S = 0.85 F = 4.20 T = 4.65 RH side 31.339		* 10.40		for LH side : rem/ref. wheels, mudshields rear piping, rear connector and control, incl. bleeding and height adj. E = 1.90 M = 7.00 S = 1.60 F = 5.00 T = 13.30 LH side 31.337		* 28.80
	E = 0.70 S = 0.85 F = 3.60 T = 4.65 LH side 31.331		* 9.80				
40,42 & 44	REAR PANEL - EXTENSION PANELS - WHEEL ARCH ( section ) - Same operation E = 0.70 S = 0.85 F = 4.20 T = 7.65 RH side 31.333		* 13.40	40,42 44 & 54	REAR PANEL-WHEEL ARCH COMPLETE FRONT CLOSING PANEL FOR WHEEL ARCH - REAR PANEL EXTENSION, and REAR PILLAR ( section, see ref. 66 in IMPACT, SIDE ) - same operation E = 0.70 M = 6.10 S = 1.60 F = 5.40 T = 14.00 RH side 31.359		* 27.80
	E = 0.70 S = 0.85 F = 3.60 T = 7.65 LH side 31.334		* 12.80		E = 1.90 M = 7.00 S = 1.60 F = 5.40 T = 14.00 LH side 31.361		* 29.90

(\*) - + Supplt. : TOWING ATTACHMENT - Rem/ref. or replt.

31.351

+ 4.50

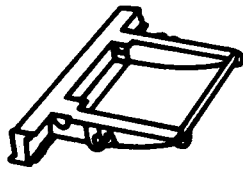
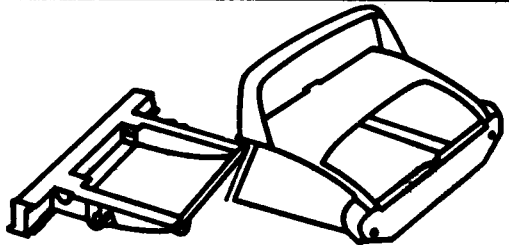


# IMPACT, REAR

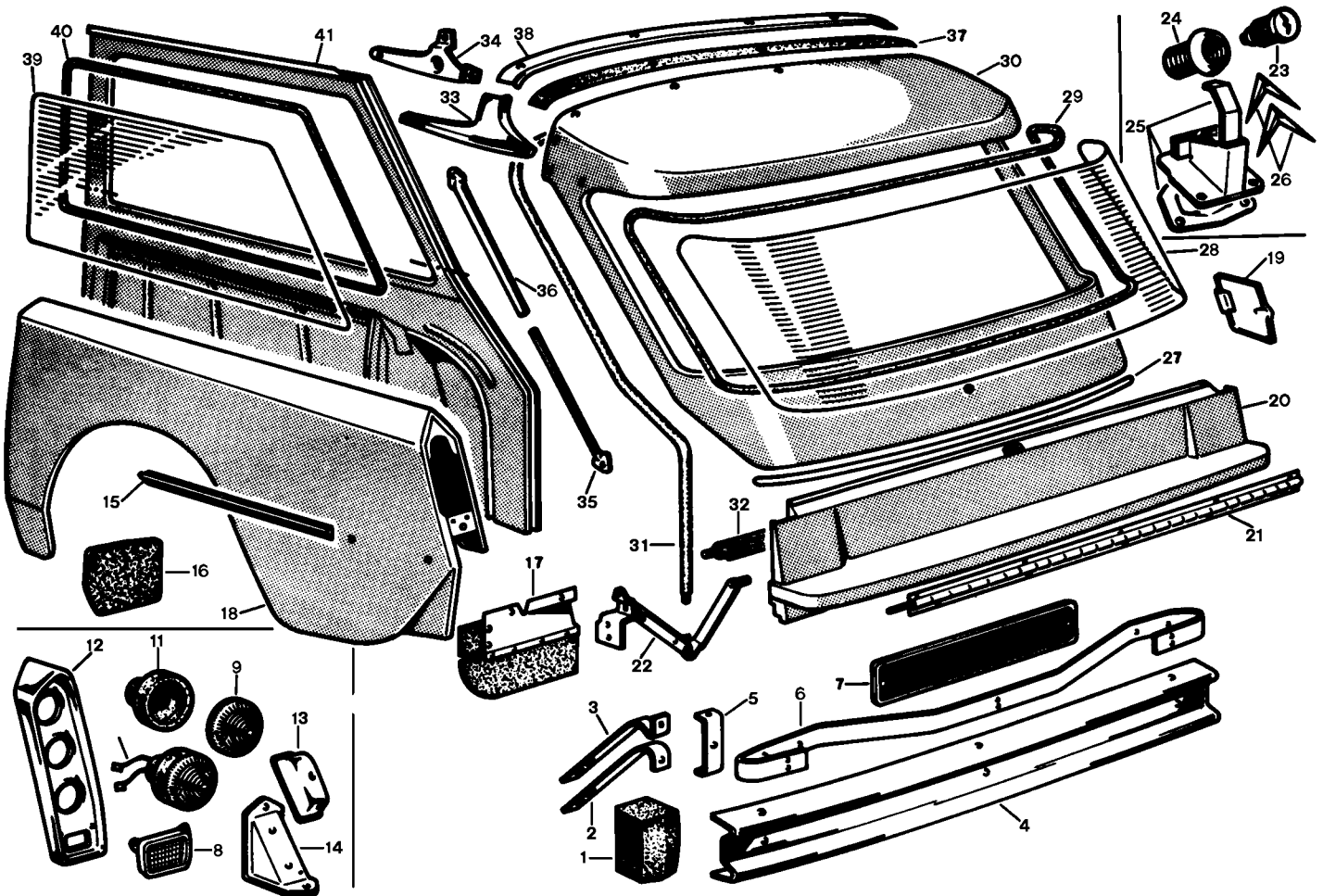
# SALOONS



TIMES expressed in hours and hundredths of an hour

Ref.	Operation	Code	Times	Ref.	Operation	Code	Times
46, 40 & 53	 <p>CAISSON REAR UNIT - REAR PANEL - CROSS MEMBER, LOWER, FRONT (between rear pillars) - replt. by de-welding and re-welding incl. rem/ref. front and rear wings, rear bumper, number plate, doors front and rear boot lid, front and rear axles, petrol tank, piping in body side members, exhaust assembly under body ( engine-GB remaining in situ ) incl. adj. and bleed. Put in jig: 4.90 M = 24.40 E = 2.75 S = 3.00 F = 8.60 T = 22.75 ..... Carb. 31.205 ●66.40 incl. rem/ref. E.C.U., petrol pump and filter for EFI Put in jig: 4.90 M = 25.75 E = 2.75 S = 3.00 F = 8.60 T = 22.75 ..... EFI 31.205 ●67.75 + Supplt. : PALLAS - rear finishers on side member ..... 31.206 + 0.50 + Supplt. : REAR PANEL EXTENSION ( 42 ) replt. .... T = + 1.00 31.332 + 1.00 + Supplt. REAR PANEL EXTENSION-wheel arch and rear shelf gusset ( 42, 44, and 48 ) replt. .... T = + 7.00 31.212 + 7.00 + Supplt. REAR PANEL EXTENSION-wheel arch-rear shelf gusset-front closing panel for wheel arch ( 42, 44, 48 and 54 )-replt. .... 31.222 + 7.60 + Supplt. REAR UNIT ( half-axles removed ) cross-bar check ..... 31.620 + 0.80</p>			46, 47 & 51	 <p>CAISSON REAR UNIT - BODY REAR UNIT AND INNER QUARTER PANEL ( on jig ) Same operation, incl. also : rem/ref. roof and rear window. Put on jig: 4.90 M = 24.40 E = 2.75 S = 4.25 F = 14.50 T = 30.50 ..... Carb. 31.364 ● 81.30 incl. rem/ref. E.C.U., fuel pump and filter for EFI. Put on jig: 4.90 M = 25.75 E = 2.75 S = 4.25 F = 14.50 T = 30.50 ..... EFI 31.364 ● 82.65 + Supplt. For BONDED ROOF - rem/ref. .... 31.984 + 5.50 + Supplt. PALLAS S = + 1.10 ..... 31.194 + 1.10 + Supplt. REAR UNIT ( half-axles removed ) Cross-bar check ..... 31.620 + 0.80</p>		

( ● ) - + Supplt. : TOWING ATTACHMENT - Rem/ ref. or replt. 32.202 + 4.00

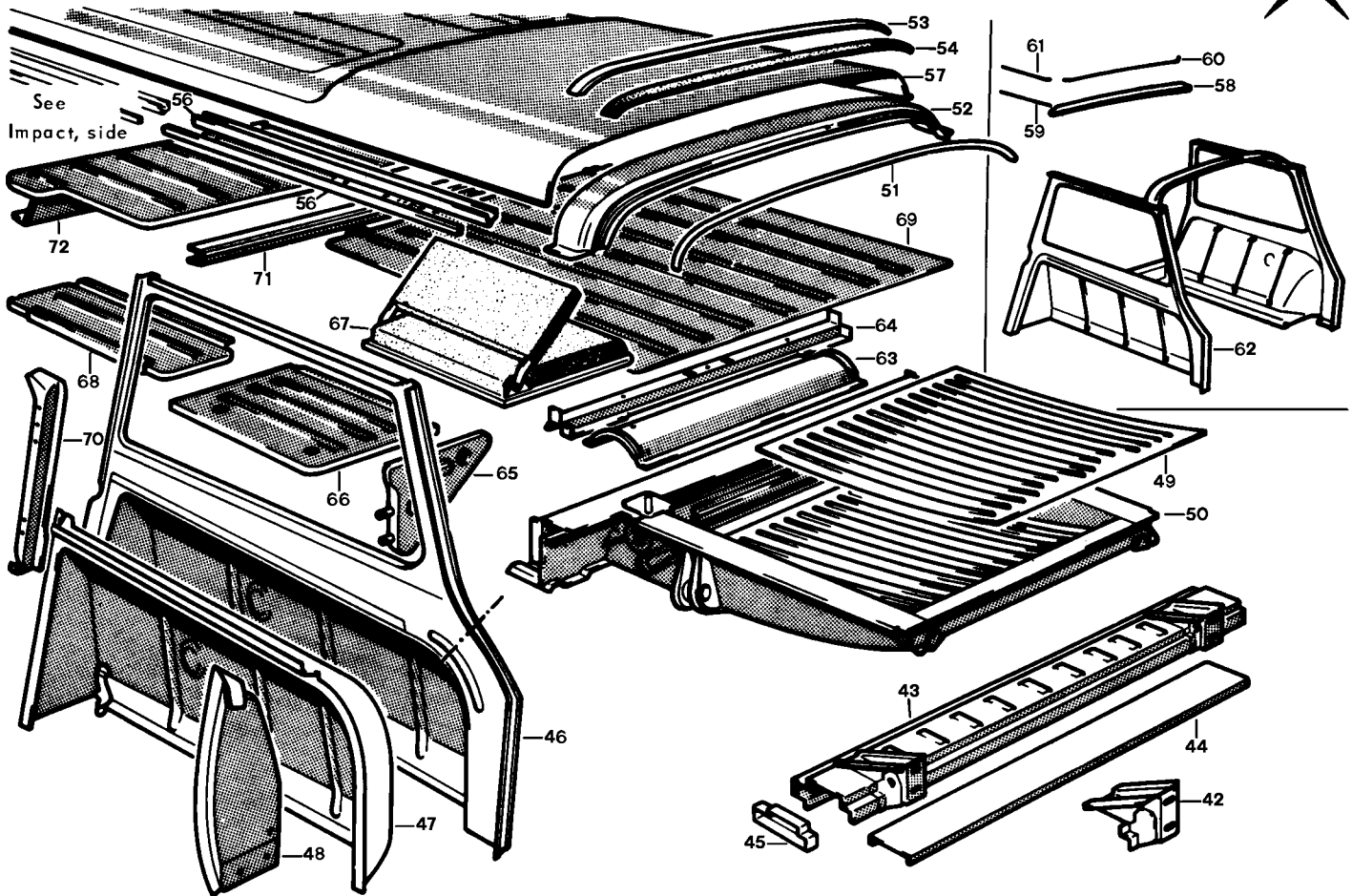


TIMES expressed in hours and hundredths of an hour

Ref.	Operation	Code	Times	Ref.	Operation	Code	Times
1 or 2	BUMPER BUFFER and/or SUPPORTS-repl. ....	71.125	0.30	30	TAIL-GATE, UPPER - rem/ref. ....	67.105	0.70
4 & 5	REAR BUMPER COMPLETE-repl. ....	71.155	1.10		( removed )-strip/reassem. ....	67.107	4.25
4	BUMPER BLADE ( bumpers removed )-repl. ....	71.075	0.45		repl. incl. adj. ....	67.115	5.60
7	NUMBER PLATE-repl. excl. painting numbers	71.220	0.10		TRIMMING FOR TAIL-GATE UPPER ( on		
9	REAR LAMP GLASS - repl. ....	53.782	0.10	31	vehicle ) repl. ....	67.172	2.15
10	REAR LAMP COMPLETE, incl. rem/ref. wing	53.784	0.55		SEALING SECTION FOR TAIL-GATE UPPER		
	repl. ....	53.785	0.25		repl. ....	67.112	0.65
	( wing removed ) repl. ....	53.785	0.25	35 & 36	STAY, MALE AND FEMALE - repl. ....	67.089	0.20
12	REAR LAMP SUPPORT, incl. rem/ref. wing	53.786	0.70	39 or 40	REAR QUARTER GLASS ( unbroken ) or SEA-		
	repl. ....	53.787	0.40		LING RUBBER - repl. ....	62.127	0.70
	( wing removed ) repl. ....	53.787	0.40		REAR QUARTER GLASS ( broken ) - repl.		
13	REAR NUMBER PLATE LAMP - repl. ....	53.788	0.10		incl. cleaning out ....	62.130	1.00
	BRACKET FOR NUMBER PLATE LAMP -	53.789	0.15	41	REAR QUARTER PANEL ( section ) REAR		
16 or 17	MUDFLAP, FT. OR REAR ON WING-repl. ....	64.162	0.60		WHEEL ARCH - repl. by cutting and de-wel-		
	( wing removed ) repl. ....	64.170	0.30		ding and welding incl. : rem/ref. rear wing,		
18	REAR WING - rem/ref. ....	64.003	0.30		quarter glass, tail-gate upper and lower, bum-		
	( removed ) strip/reassem. ....	64.005	1.30		per buffers :		
	repl. incl. adj. ....	64.015	1.80		- RH side, remove and fit wheel		
20	TAIL-GATE, LOWER - rem/ref. ....	67.305	1.25		- LH side, rem/ref. wheel, filler neck, and		
	( removed ) strip/reassem. ....	67.307	1.50		breather tube.		
	( removed ) - assem. without recovering com-	67.323	1.00		Outer section : level with WHEEL ARCH		
	ponents ....	67.323	1.00		PANEL		
	repl. incl. adj. ....	67.315	3.00		M = 1.30 E=0.25 S = 0.55 F = 4.25 T = 6.50		
	repl. without recovering components, incl.	67.312	2.25		RH side 31.346	12.85	
22	STAY FOR TAIL-GATE, LOWER - repl. ....	67.333	0.20		M = 0.30 E = 0.25 S=0.55 F = 4.25 T = 6.50		
		67.333	0.20		LH side 31.344	11.85	
28 or 29	GLASS ( unbroken ) or RUBBER SEAL FOR	61.001	1.50		Outer and inner section :		
	GLASS - repl. ....	61.001	1.50		M = 1.30 E = 0.25 S=0.55 F = 4.25 T = 10.75		
	GLASS ( broken ) - repl. incl. cleaning-out	61.007	1.90		RH side 31.347	17.10	
		61.007	1.90		M = 0.30 E = 0.25 S=0.55 F = 4.25 T = 10.75		
					LH side 31.345	16.10	

# IMPACT, REAR

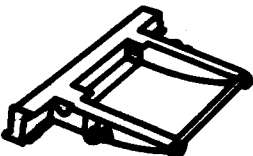
# ESTATES (Safari)



TIMES expressed in hours and hundredths of an hour

Ref.	Operation	Code	Times	Ref.	Operation	Code	Times
42	SUPPORT ( welded ) FOR BUMPER-BUFFER on cross member-Replacement by de-welding and welding, incl. rem/ref. buffer with movable supports, tail-gate lower, rear wing, incl. for RH side : rem/ref. filler neck and breather tube. M = 1.00 E = 0.20 F = 1.50 T = 2.35 RH side 71.174 LH side 71.172		5.05 4.05	43, 46 & 52	Same operation, incl. in addition, CROSS MEMBER, UPPER - incl. rem/ref. quarter glass and de-trimming cross member M = 6.10 E = 3.50 S = 4.10 F = 12.60 T = 19.90 RH side 31.392 LH side 31.325		● 46.20 ● 47.25
43	CROSS MEMBER, REAR, LOWER, replt. by de-welding and welding, incl. rem/ref. tail-gate lower, rear wings, bumper buffers filler neck and breather pipe. M = 1.00 E = 0.70 S = 1.50 F = 3.00 T = 8.35 71.176		* 14.55	46 & 70	ASSEMBLY : QUARTER PANEL - WHEEL ARCH-CANTRAIL EXTENSION and REAR PILLAR-repl. by de-welding and rewelding incl. rem/ref. petrol tank, rear piping, axle protection panel, rear wing, tail-gates upper and lower, quarter glass, roof, rear side doors, rear wheels, incl. for LH side rem/ref. rear height corrector and control, adj. rear heights and bleed. M = 6.10 E = 1.30 S = 3.00 F = 11.90 T = 9.10 RH side 31.834 LH side 31.832		31.40 34.65
43 & 48	Same operation, with, in addition, REAR QUARTER PANEL ( inner and outer sections )-WHEEL ARCH PANEL-repl. incl. rem/ref. wheel, tail-gate lower, quarter glass. M = 1.30 E = 0.70 S = 2.05 F = 5.40 T = 18.00 31.396		* 27.45	48	REAR WHEEL ARCH PANEL - replt. incl. rem/ref. rear wing, mudflaps, wheel, incl. for RH side, filler neck and breather pipe. M = 1.15 E = 0.25 S = 1.25 F = 0.70 T = 3.00 RH side 31.302 LH side 31.303		6.35 5.45
43 & 46	CROSS MEMBER, REAR, LOWER, FOR BODY-QUARTER-PANEL - WHEEL ARCH CANTRAIL EXTENSION - replt. by de-welding and re-welding, incl. rem/ref. petrol tank, rear piping, rear axle protection panel, rear wing, upper and lower tail-gate quarter glass, roof, rear side door, wheels, and incl. for LH side : rem/ref. height corrector and control, adj. rear height, and bleed. M = 6.10 E = 1.30 S = 3.00 F = 11.90 T = 18.80 RH side 31.393 LH side 31.394		● 41.10 ● 44.35	* =	+ Suppl. : TOWING ATTACHMENT - rem/ref. or replt. .... 31.203		5.90
				● =	+ Suppl. : TOWING ATTACHMENT - rem/ref. or replt. .... 31.202		4.00

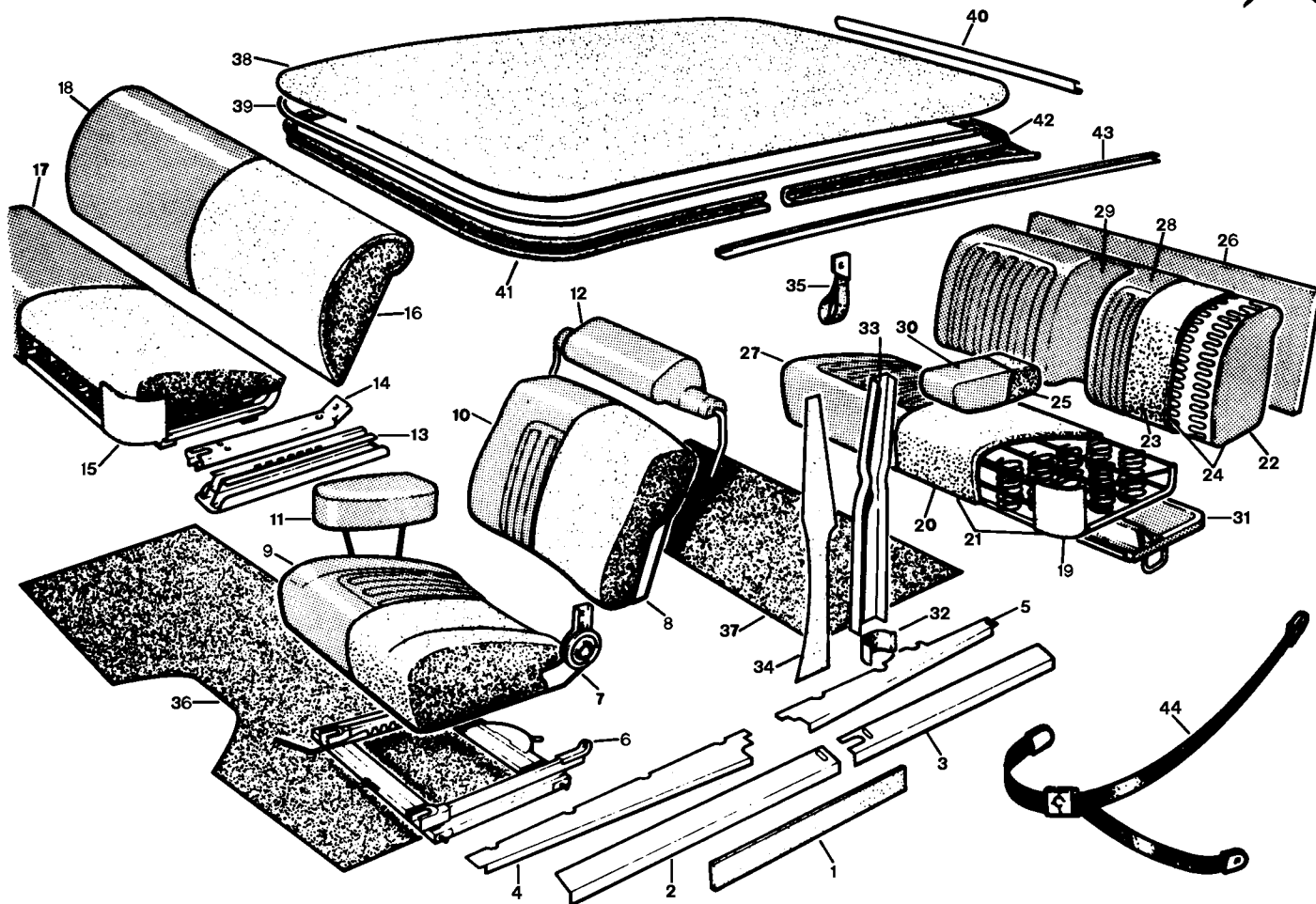
TIMES expressed in hours and hundredths of an hour

Ref.	Operation	Code	Times	Ref.	Operation	Code	Times
							
50 & 64	CAISSON REAR UNIT- CROSS MEMBER, FT, LOWER ( between rear pillars ) - replt. on jig, incl. rem/ref. front and rear wings, rear bumper, N° plate, doors front and rear, tail-gate, lower, axles , front and rear, petrol tank piping in side members, exhaust line under body ( engine-GB remaining in situ ) incl. adj. bleed, and replt. LOWER CLOSING PANEL FOR REAR CROSSMEMBER (44) -			52	CROSS MEMBER, UPPER, REAR - replt. by de-welding and welding incl. rem/ref. roof, tail-gate, upper, and quarter glass. E = 0.80 S = 1.70 F = 7.40 T = 3.70	31.260	13.60
	Put on jig = 4.90 M = 24.40 E = 4.50 S = 4.60 F = 8.60 T = 23.10		● 70.10	57	ROOF - rem/ref. .... 69.005 replt. incl. rem/ref., roof-rack, and fitting new headlight ..... 69.015 HEADLINING ( roof removed ) - replt. .... 69.009 ROOF-RACK ..... rem/ref. 69.039 replt. 69.040		6.00 8.80 3.65 1.20 1.50
50,64 & 43	Same operation, incl. also REAR CROSS MEMBER and CLOSING PANEL Put on jig = 4.90 M = 24.40 E = 4.50 S = 4.60 F = 8.60 T = 26.75		● 73.75	67	MOVABLE FLOORS FOR CUSHION and REAR SEAT BACK - replt. .... 82.214		1.30
				70	OCCASIONAL SEAT, REAR - replt. .... 82.210 REAR PILLAR COMPLETE - replt. by D-welding, cutting, and welding, incl. rem/ref. rear wing, rear doors, rear bench seat, and floor. S = 2.10 F = 2.85 T = 4.35 RH side 31.193 E = 3.50 S = 2.10 F = 2.35 T = 4.35 LH side 31.283		0.65 9.30 12.80

( ● ) = + Suppl. : TOWING ATTACHMENT - rem/ ref. or replt. 31.202 + 4.00

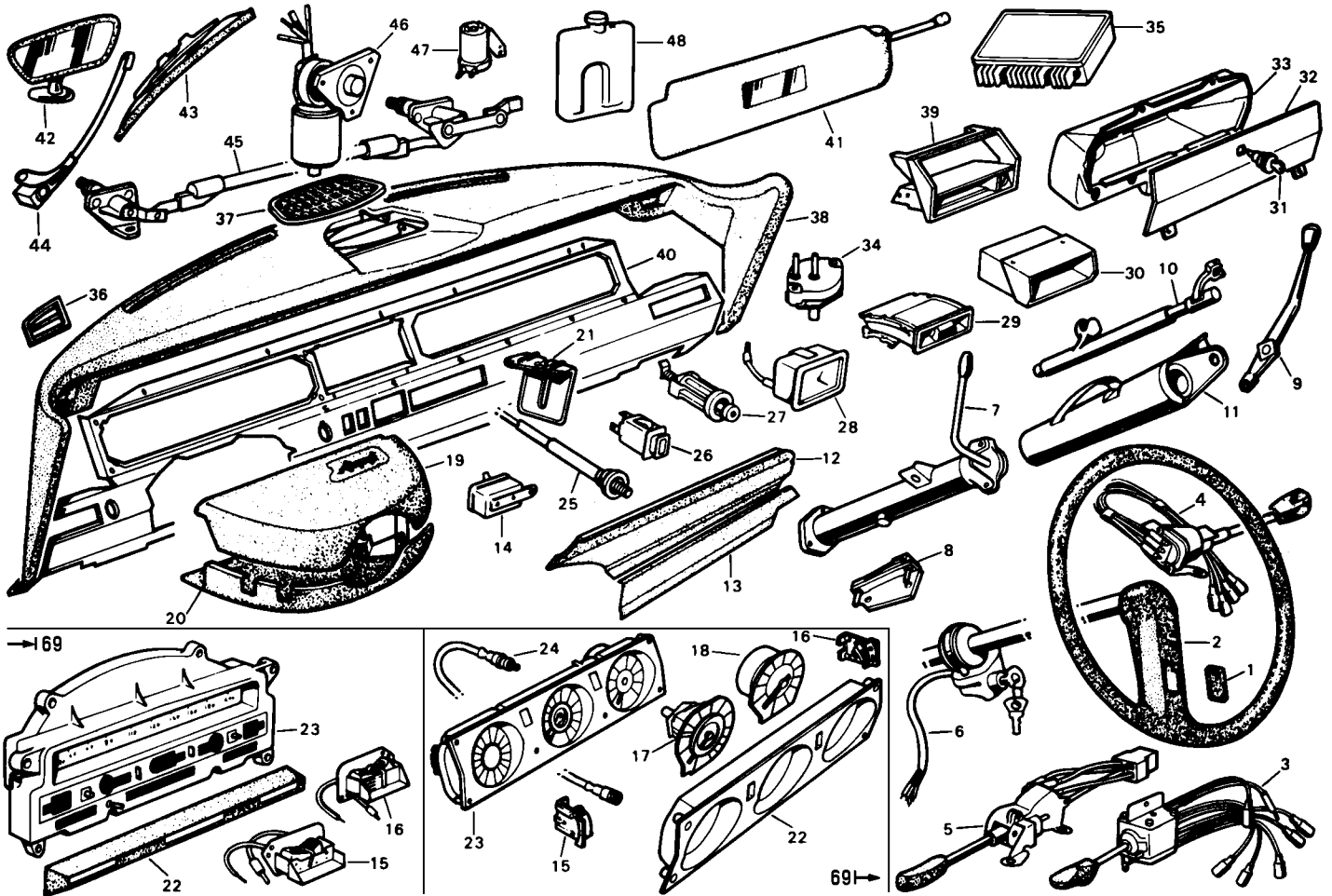
# IMPACT, INTERIOR

# TRIMMING



**TIMES** expressed in hours and hundredths of an hour

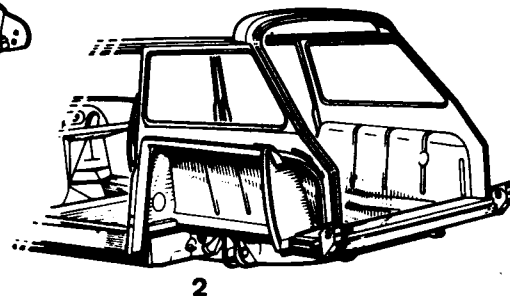
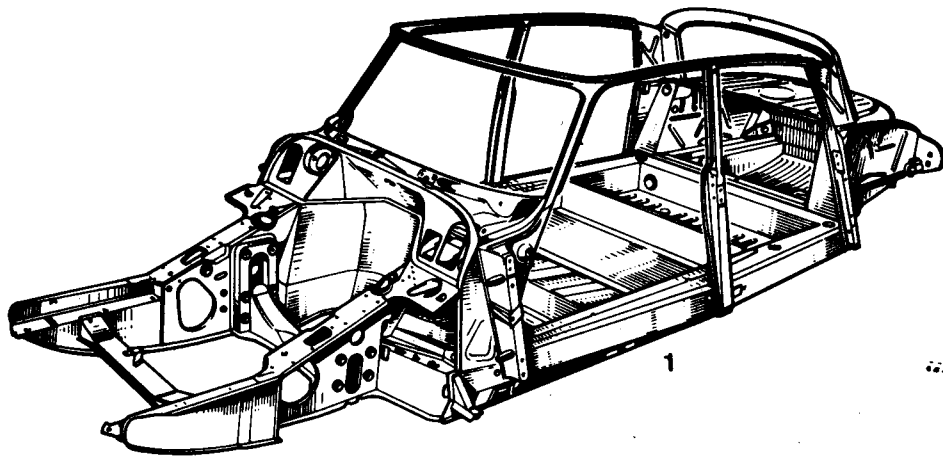
Ref.	Operation	Code	Times	Ref.	Operation	Code	Times
7-8	SEAT, FRONT - rem/ref. ....	81.001	0.40				
	Pallas	81.002	0.50				
21 - 24	REAR BENCH SEAT-rem/ ref. ....	82.001	0.25				
44	SEAT BELTS, SET - fit .....	81.031	1.25				
	<b>seats removed</b>						
9 & 10	FRONT SEAT TRIMMING, replt.....	81.278	2.80				
27	TRIM FOR REAR BENCH SEAT CUSHION Replacement .....	82.115	1.25	28 & 30	TRIM FOR BACK-REST AND ARM REST Replacement .....	82.130	3.10
28	TRIMMING FOR REAR BENCH SEAT BACK Replacement .....	82.125	1.70	9 - 10	SEAT TRIMS, ARM-REST - Repl. ....	82.172	9.95
30	TRIM FOR ARM-RESTS - Replacement	82.155	0.80	28 & 30			
				38	HEADLINING ( on vehicle ) Replacement cloth trim on bonded roof .....	Std. 69.032	4.60
						Pallas 69.033	5.30
				—	HEADLINING, CLOTH ( roof removed ) Replacement .....	69.007	2.40
				44	SEAT BELT - ( ONE ) Replacement ..	81.029	0.35



TIMES expressed in hours and hundredths of an hour

Ref.	Operation	Code	Times	Ref.	Operation	Code	Times
2	STEERING WHEEL ( with anti-theft )-repl.	40.004	1.55	26	SWITCH FOR INT. LAMP - repl.	41.280	0.15
	STEERING WHEEL - adj. end float	40.035	0.20		SWITCH FOR HEATED REAR WINDOW - repl.	41.275	0.15
3	DIRECTION INDICATOR SWITCH - repl.	41.265	0.45		SWITCH FOR PARKING LAMPS repl.	41.260	0.10
4	LIGHTING SWITCH - repl.	41.305	0.65		SWITCH FOR HEATING AND VENTILATION		
5	SWITCH, SCREEN WIPE AND WASH- repl.	41.290	0.55		repl.	41.307	0.10
6	ANTI-THEFT - repl.	40.057	2.35	27	CIGAR-LIGHTER COMPLETE - repl.	41.230	0.60
7 or 9	GEAR LEVER - repl.	Mec. 42.110	1.00		CLOCK - repl.	41.232	0.10
		Hyd. 42.110	2.30	34	PANEL LIGHTING RHEOSTAT - repl.	41.270	0.20
8	STARTER MOTOR SWITCH ( on selector )			35	E.C.U. (following check) repl.	EFI 03.169	0.75
	repl.	Hyd. 41.255	2.80	38	FACIA BOARD ( upper part ) - repl. incl. rem/		
14	FLASHER UNIT - repl.	53.745	0.60		ref. inst. cluster	41.008	2.40
17	SPEEDOMETER - repl.	41.205	0.70	42	DRIVING-MIRROR, INTERIOR - repl.	41.480	0.30
	( warning lamp cluster removed ) - repl.	41.419	0.35	44	WIPER-ARM - repl.	53.230	0.15
18	TACHOMETER	9-69 → 41.470	0.70	45	SCREEN-WIPER MECHANISM - repl.		
	( warning lamp cluster removed )	41.417	0.35		→ 9-69	53.141	3.00
23	WARNING LAMP CLUSTER, OR INSTRUMENT				( facia board removed ) - repl.	53.140	1.00
	CLUSTER	→ 9-69 41.403	0.55	46	SCREEN-WIPER MOTOR - repl.		
		9-69 → 41.401	0.35		→ 9-69	53.128	1.30
24	SPEEDO CABLE - repl.	Carb. 09.175	1.25		→ 9-69	53.130	2.30
		EFI 09.175	1.40		( facia board removed ) - repl.	53.126	0.30
25	CHOKE CONTROL - repl.	Carb. 03.015	0.80	47	PUMP, ELECTRIC, FOR SCREEN-WASH		
					repl.	53.310	0.35

# BODY SHELLS



**TIMES** expressed in hours and hundredths of an hour

Ref.	Operation	Code	Times	Ref.	Operation	Code	Times
1	<b>BODY SHELL - replt. incl. rem/ref. all mechanical units, hydraulic, electrical, removable items, de-trimming and re-trimming complete, incl. adj. of body panel, adj. wheel geometry and bleeding.</b> Saloons - Carb. M = 54.65 E = 15.95 S = 14.55 F = 27.80 Mec. 31.010 112.95 M = 56.20 E = 15.95 S = 14.55 F = 27.80 Hyd. 31.010 114.50			1 or 2	<b>BODY SHELL - check on jig, incl. rem/ref. wings front and rear, axles front and rear, rear suspension cylinders, rear height corrector, exhaust line under body, doors front and rear ( engine-GB remaining in situ).incl. adj. and bleed.</b> M = 17.50 F = 4.40 Put on jig = 4.90 31.005 26.80		
	Saloons - EFI M = 59.45 E = 17.60 S = 14.55 F = 27.80 Mec. 31.010 119.40 M = 61.00 E = 17.60 S = 14.55 F = 27.80 Hyd. 31.010 120.95						
	+ Supplt. for rem/ref. ROOF bonded 31.984 +5.50 Pallas 31.011 +1.90						
	+ Supplt. TOWING ATTACHMENT-rem/ref. or replt. 31.202 +4.00						
	+ Supplt. AIR CON ( option )-rem/ref. for all units 31.009 +9.10						
2	<b>BODY SHELL ( estate ) - same operation</b> M = 54.65 E = 18.90 S = 19.50 F = 27.15 Estate 31.010 120.20						
	+ Supplt. TOWING ATTACHMENT-rem/ref. or replt. 31.202 +4.00						



**TIMES** expressed in hours and hundredths of an hour

Operation	Code	Times	
		Saloon	Estate
<b>FRONT COMPONENTS</b>			
WING, FRONT .....	63.125	2.50	2.50
WING, REAR .....	64.125	2.00	2.20
BONNET .....	68.024	3.75	3.75
FRONT VALANCE .....	60.016	2.20	2.20
<b>SIDE COMPONENTS</b>			
DOOR, FRONT ..... 1 side	65.038	2.40	2.40
DOOR, FRONT ..... 2 sides	65.040	3.15	3.15
DOOR, REAR ..... 1 side	66.038	2.20	2.20
DOOR, REAR ..... 2 sides	66.040	2.90	2.90
ROOF .....	69.023	5.30	6.75
<b>REAR COMPONENTS</b>			
BOOT LID .....	67.038	2.30	
TAIL-GATE, LOWER .....	67.320		2.30
TAIL-GATE, UPPER .....	67.122		3.10
REAR QUARTER-PANEL + WHEEL ARCH	31.577		2.20
PAINT COMPLETE-external only ( flat and respray ) ..... incl. roof	31.689	15.80	18.80
..... excl. roof	31.708		15.50
PAINT COMPLETE - exterior and interior ..... incl. roof	31.682	35.50	41.25
..... excl. roof	31.425	30.10	34.50
1 ROAD -WHEEL .....	22.093	* 0.65	*0.65
- per ROAD-WHEEL in addition .....	22.096	* 0.45	* 0.45
NUMBER PLATE - black background and number ..... 1 plate	31.723	* 0.75	*0.75
..... 2 plates	31.725	* 1.00	*1.00
PUTTING WORK IN HAND for preparation of paint and cleaning of spray gun, except for operations marked with a star ( * ) .....	31.501	+ 0.70	+0.70

N.B. : - Apart from the components above, the application of protective material is included in the operations.



**CHECKS, ADJUSTMENTS AND TESTS**

Page 6

**ROUTINE MAINTENANCE and RUNNING REPAIRS**

Pages 7-12

**ENGINE OPERATIONS  
ENGINE ACCESSORIES**

Pages 14-16

Complementary mechanical operations

**HYDRAULIC EQUIPMENT  
GEARBOXES**

Pages 17-18

**AXLE, FRONT  
AXLE, REAR**

Pages 19-20

**IMPACT, FRONT**

Pages 22-25

**IMPACT AREAS**

**IMPACT, SIDE**

Pages 26-29

**IMPACT, REAR**

Pages 30-35

**IMPACT, INTERNAL**

Pages 36-37

**BODY SHELLS**

Page 38

**PAINT**

Page 39

**PUBLISHED OCTOBER 1975**

*Reproduction or translation, even if only partial, forbidden without previous written authorisation from Citroën Company.*

**CITROEN**

Société Anonyme régie par les articles 118 à 150, de la loi sur les Sociétés Commerciales

117 à 167, quai André Citroën, 75747 Paris Cédex 15

R.C. PARIS B 642 050 199

SIRET 642 050 199 00016

Département Méthodes et Promotion Après-Vente

194, rue de Lourmel 75015 PARIS - Tél. 533-74-50

Printed in France by Citroën