

SCHEDULE OF REPAIR CHARGES

Ford

MODEL "T"
CARS AND TRUCKS

Ford Motor Company

DETROIT, MICHIGAN

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MODEL "T"
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Suggested for the Use of Dealers, Service Dealers and Garages

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Foreword

THE practice of charging a flat rate for labor required in handling the various repair operations was established by this Company several years ago, after we had demonstrated its practicability in our branch service stations. The fact that this method of determining labor charges has since been adopted by automobile manufacturers generally is convincing proof that the flat rate system had proven most satisfactory to the customer as well as the service station.

Our experience has proven that the greatest point of dissatisfaction in handling service work is eliminated when the customer understands in advance exactly what the labor cost will amount to on a certain repair job. In all well organized service stations the repair order which the customer signs clearly specifies the labor cost of the work to be performed. This precludes the possibility of any misunderstanding or argument with a customer when a job is completed and the bill presented for payment. The customer is entitled to an estimate of the labor charges before the work is undertaken, and on the other hand the dealer must have the assurance that the labor bill will be paid when the work is finished.

The various labor charges suggested within are the result of a careful study of these operations conducted for the guidance of Dealers, Service Dealers and Garages.

Engine Division

The following charges cover work on cars driven into the service station

Operation Number		Labor Charges
1.	Overhaul motor and transmission.....	\$25.00
2.	Overhaul motor only.....	20.00
3.	Overhaul transmission only, or repair or replace magneto.....	14.00
4.	Rebraz crankcase arms or support or repair leak in case by taking out the motor.....	12.00
5.	Install or refit one piston or one connecting rod.....	4.50
6.	Install or refit two or more pistons or connecting rods.....	6.00
7.	Tighten one connecting rod bearing.....	2.50
8.	Tighten two or more connecting rod bearings.....	4.50
9.	Replace transmission bands (sedans and coupes \$1.00 extra) \$2.75; 60c extra for starter.....	4.35
10.	Replace transmission cover gasket \$2.50; closed car and with starter.....	3.00
11.	Change motor.....	6.50
12.	Replace camshaft, and refit bearings.....	5.00
13.	Replace cam gear—large.....	3.00
14.	Replace cylinder front cover.....	3.00
15.	Grind valves and clean carbon.....	3.75
16.	Remove carbon only (This operation to be used only when customer will not permit grinding of valves).....	1.75
17.	Repair cylinder head bolts stripped—one or two.....	3.00
18.	Repair cylinder head bolts stripped under dash.....	5.00
19.	Clean out oil feed pipe.....	3.25
20.	Replace cylinder head gasket.....	1.00
21.	Replace radiator or all three hose connections.....	.75

Engine Division—Continued

Operation Number	Labor Charges
22. Replace one hose connection only.....	\$ 0.40
23. Replace crankshaft starting pin, or pulley.....	1.50
24. Tighten motor to frame.....	1.00
25. Clean crankcase or install gasket under lower cover.....	.75
26. Replace carburetor or manifold—or repair leak in manifold.....	.75
27. Install new butterfly spring.....	.75
28. Overhaul carburetor.....	1.50
29. Repair leaky carburetor.....	1.00
30. Replace commutator wire loom.....	.75
31. Replace commutator case or brush.....	.50
32. Replace commutator pull rod joint.....	.60
33. Replace or rebush fan pulley assembly.....	.60
34. Adjust clutch fingers and transmission bands.....	.60
35. Adjust transmission bands only.....	.40
36. Stop oil leak in valve doors.....	.50
37. Install transmission band springs—each.....	.50
38. Replace cylinder water jacket plug—one or more.....	.40
39. Install new starting crank handle.....	.50
40. Replace flywheel ring gear.....	12.00
Operations 5 and 15 combined on one order.....	6.50
Operations 6 and 15 combined on one order.....	8.00
Operations 12 and 15 combined on one order.....	6.50
Operations 15 and 17 combined on one order.....	4.50
Operations 9 and 19 combined on one order.....	5.00
Operations 10 and 19 combined on one order.....	3.50

Engine Division—Continued

Operation Number	Labor Charges
Operations 30 and 31 combined on one order.....	\$ 0.75
No charge for operation 10 when combined with operation 9.	
No charge for operation 16 when combined with operations 5, 6, or 12.	
No charge for operation 21 when combined with operations 228 or 238.	
No charge for operation 34 when combined with operation 9.	
No charge for operation 21 when combined with operation 14.	
Parts brought in or shipped in for repairs	
55B. Overhaul motor and transmission.....	20.00
56B. Overhaul motor only.....	14.00
57B. Overhaul transmission only.....	4.00
58B. Rebore cylinder only.....	3.50
59B. Rebore cylinder only including fitting of pistons.....	4.50
60B. Rebore and rebabbitt cylinder including fitting of pistons.....	6.50
61B. Rebabbitt cylinder only.....	2.50
62B. Rebabbitt cylinder, fit crankshaft, and run-in.....	4.50
63B. Rebore and rebabbitt cylinder including fitting of pistons, crankshaft, connecting rods, and running-in.....	8.00
64B. Rebore and rebabbitt cylinder, fit pistons, valves, push rods, camshaft, crankshaft, connecting rods and run-in.....	10.00
65B. Rebore and fit pistons and valves.....	4.50
66B. Rebore and fit pistons, valves and push rods and straighten and fit camshaft.....	6.50
67B. Fit pistons, crankshaft and run-in (rebored block).....	2.50
68B. Rebush three transmission drums.....	1.50

Engine Division—Continued

Operation Number	Labor Charges
69B. Rebush transmission drums—each	0.60
70B. Rebush triple gear assemblies	1.50
71B. Braze crankcase arms and supports	4.00
72B. Repair crankcase drain plug housing	2.50
73B. Overhaul and repair carburetor	1.00
74B. Disassemble $\frac{5}{8}$ ", $\frac{9}{16}$ " or $\frac{3}{4}$ " magnets from flywheel and install new set	1.00
75B. Straighten crankshaft	1.00
76B. Straighten camshaft	.60
77B. Straighten camshaft and fit bearings	1.00
Operations 71B and 72B combined on one order	3.75

Rear System Division

The following charges cover work on cars driven into the service station:

96. Overhaul complete rear axle assembly	\$ 7.00
97. Replace rear axle assembly	2.50
98. Replace rear axle shaft, drive shaft pinion, or drive gear (No other work necessary)	5.00
99. Repair or replace drive shaft tube	4.00
100. Repair or replace one rear radius rod	1.50
101. Tighten rear radius rod	.60
102. Straighten rear radius rod (in car)	.60

Rear System Division—Continued

Operation Number	Labor Charges
103. Install universal joint.....	\$ 3.00
104. Straighten axle shaft (without removing from car).....	1.50
105. Tighten universal ball cap bolts.....	.60
106. Install felt and steel washers—one side 75c; both sides.....	1.25
107. Install brake shoes and equalize emergency brakes—one shoe 75c; both.....	1.25
108. Tighten rear hub lock nut—one side 40c; both sides.....	.60
109. Fit new hub keys—one side 50c; both sides.....	.75
110. Install outer roller bearing—each.....	1.25
111. Replace pull rod supports—one support 40c; both supports.....	.60
112. Adjust pull rods or replace one.....	.60
113. Replace or rebush hub brake cam—each side.....	1.50

Springs

114. Replace spring perches—one 75c; both.....	1.25
115. Rebush spring and perches.....	1.75
116. Install or tighten rear spring clips.....	.60
117. Pad rear spring to line up body or replace rear spring tie bolt only.....	2.00
118. Remove front and rear springs, polish and graphite leaves only—one \$2.50; both.....	4.50
119. Replace rear spring tie bolt or new leaf including polishing and graphiting of leaves and lining up of body.....	3.00
Operations 98 and 119 combined on one order.....	8.50
Operations 98 and 117 combined on one order.....	8.00
Operations 98 and 116 combined on one order.....	7.00

Rear System Division—*Continued*

Operation Number	Labor Charges
Axle overhaul, when car has shock absorbers and owner will not permit removal—extra	\$ 1.00
Axle overhaul, when car is equipped with special hub brakes—extra	1.50
Parts brought in or shipped in for repairs:	
140B. Overhaul rear axle	4.50
141B. Straighten or repair rear radius rod	.60
142B. Overhaul differential assembly with shafts	1.50
143B. Remove old and press new gear on axle shaft—each	.40

Front System Division

The following charges cover work on cars driven into the service station:

167. Overhaul front axle, straightening and aligning up and adjusting of wheels	5.00
168. Rebush spindle bodies and arms—one side \$1.50; both sides	2.50
169. Rebush spindle body—one side \$1.00; both sides	1.75
170. Rebush spindle arm—one side 75c; both sides	1.25
171. Replace spindle arm or body and line up assembly	1.00
172. Replace or straighten spindle connecting rod	.60
173. Replace or straighten steering connecting rod	.60
174. Replace or straighten front axle (no other repairs)	3.00
175. Replace broken off radius rod ball cap stud	2.50
176. Tighten radius rod or steering gear ball cap	.60
177. Replace radius rod	.75

Front System Division—*Continued*

Operation Number	Labor Charges
178. Straighten front radius rod and line up front assembly.....	\$ 1.00
179. Replace radius rod ball cap with new style.....	.60
180. Tighten all sockets and joints of front end.....	1.25

Springs

181. Replace front spring tire bolt or new leaf, including polishing and graphiting of leaves.....	2.50
182. Replace front spring or tie bolt only.....	1.50
183. Install or tighten front spring clips—40c; both.....	.60
Operations 167 and 175 combined on one order.....	6.50
Operations 167 and 181 combined on one order.....	6.50
Operations 167 and 203B combined on one order.....	6.50

The following extra charges should be made for special equipment.

Overhauling front axle when bumpers, special radius rods, "Little Steersmen," shock absorbers and such devices are used.....	1.50
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Parts brought in or shipped in for repairs

202B. Straighten front axle.....	1.50
203B. Rethread front axle by drilling out and bushing.....	2.00
204B. Straighten radius rod.....	.60
205B. Install stud in radius rod.....	.60
206B. Rebush spindle body and arm.....	.75
207B. Rebush spindle body.....	.50
208B. Rebush spindle arm.....	.40

Chassis Division

The following charges cover work on cars driven into the service station:

Front End and Frame

Operation Number		Labor Charges
228.	Replace front cross member.....	\$ 6.00
229.	Replace front cross member when radiator is off.....	5.00
230.	Straighten front cross member (without removing from car).....	2.00
231.	Replace rear cross member.....	7.50
232.	Replace side member or frame.....	20.00
233.	Install engine pans—both.....	1.00
234.	Tighten engine pan.....	.60
235.	Tighten crankcase front end bearing cap \$1.00—1923.....	1.75
236.	Install hood clips or springs on hood board one side.....	.60
237.	Free up hand brake lever 75c; when necessary to remove wheel to free up cam or remove quadrant to free bracket.....	2.00
238.	Remove radiator to replace radiator stud or tighten fender brackets—each or both.....	1.50
239.	Replace starting crank ratchet pin—old style 60c; new style.....	.40
240.	Replace starting crank or sleeve.....	1.00
241.	Install running board bracket—one \$2.50; both.....	4.50
242.	Repair hand brake lever assembly including replacing of pawl.....	1.50
243.	Replace hand brake lever quadrant without removing running board shield.....	1.00
244.	Tighten all bolts and nuts on car.....	3.00
245.	Tighten body bracket bolts.....	.60
246.	Install tail lamp bracket.....	.40

Fenders and Running Boards

Operation Number		Labor Charges
258.	Replace one fender or running board (25c extra when necessary to straighten iron or bracket).\$	1.00
259.	Tighten all fenders, running boards, shields and truss rods—one only 40c; all	1.75
260.	Remove fender or running board and straighten	1.00
261.	Replace running board shield—one \$1.25; two	2.00
262.	Install fender to shield bracket—each	.60
263.	Replace rear fender iron	.75
264.	Replace truss rods—one rod 40c; both rods	.60

Dash

276.	Replace dash	5.00
277.	Replace dash when motor is out	1.50
278.	Tighten dash bracket to body and dash	1.00
279.	Replace coil, install new switch on coil box or repair the box	.60

Steering Gear

291.	Overhaul steering gear including replacing of quadrant or gear case and rebushing of bracket ..	3.50
292.	Overhaul steering gear when motor is out	2.50
293.	Tighten rivets of internal gear case	1.00
294.	Tighten at dash and rebush bracket	1.25
295.	Replace wheel or spider	.60
296.	Tighten at dash and post	.50
297.	Replace steering gear assembly	3.00
298.	Replace steering gear ball arm	1.00

Steering Gear—Continued

Operation Number	Labor Charges
299. Tighten steering gear case cover.....	\$.75
300. Oil and grease car.....	1.00

Muffler

310. Change long exhaust pipe—new style.....	1.25
311. Replace muffler (old style).....	.60
312. Repair muffler.....	1.00
313. Repack exhaust pipe pack nut.....	.60

Gas Tank and Line

323. Repair leak in touring or sedan gas tank.....	2.50
324. Repair leak in touring car gas tank (when necessary to remove body).....	6.00
325. Clean sediment bulb, gasoline feed line and drain carburetor.....	.75
326. Repair leak in gas line or replace gas line.....	.60

Hood

337. Install hood leather.....	.60
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Radiator

348. Overhaul radiator (requiring 4 to 7 hours time).....	7.50
349. Install new core in radiator.....	6.00
350. Repair radiator, solder one or two tubes and replace one or both sides.....	4.00

Radiator—Continued

Operation Number	Labor Charges
351. Solder neck or top tank or repair without removing from car.....	\$ 1.00
352. Solder casting to lower or top tank when necessary to remove radiator.....	1.50
353. Replace broken pet cock.....	.60

Wheels

365. Change hub, rear or front.....	1.25
366. Replace wheel and tire—each.....	.75
367. Adjust and dope front wheels.....	.60
368. Remove front wheels and replace bearing parts—1 wheel 75c; both.....	1.25
369. Replace spindle arm.....	.60

Paint Division

391. Repaint and revarnish chassis only.....	12.00
392. Repaint and revarnish car—touring or runabout.....	25.00
393. Repaint and revarnish coupelet.....	35.00
394. Repaint and revarnish sedan.....	45.00
395. Repaint and revarnish body only—touring and runabout.....	15.00
396. Revarnish body only—touring or runabout (on chassis).....	5.00
397. Revarnish body only—sedan or coupelet (on chassis).....	12.00
398. Refinish deck on torpedo runabout.....	1.50
399. Refinish fenders, dust shields, running boards, wheels, or hood, off car, each.....	.75

Body Division

Operation Number	Labor Charges
411. Tighten all doors—all cars.....	\$ 1.25
412. Install new lock—touring or runabout—each.....	1.00
413. Replace town car or sedan door lock.....	1.50
414. Replace top irons—each (old style).....	1.00
415. Install new leather on door panel—one 60c; two.....	.75
416. Install new leather on arm rest.....	1.00
417. Patch section of upholstering.....	1.00
418. Re-upholster touring body (using new material).....	15.00
419. Re-upholster runabout body (using new material).....	8.00
420. Change closed body.....	9.00
421. Change touring or runabout body.....	5.00
422. Take dent out of any side panel.....	4.00
423. Take dent out of any side panel and refinish.....	6.00
424. Take dent out of door.....	3.00
425. Take dent out of door and refinish.....	4.00
426. Take dent out of rear or corner panel (without removing from car).....	8.00
427. Take dent out of rear or corner panel and refinish (without removing from car).....	10.00
428. Take dent out of rear or corner panel (when removed from car).....	13.00
429. Take dent out of rear or corner panel and refinish (when removed from car).....	16.00
430. Take dent out of torpedo deck and refinish.....	2.00
431. Repair front or rear seat cushion.....	2.50
432. Replace binding on one or more doors.....	.75
433. Put on new trim rail.....	2.50
434. Replace door hinge.....	.75
434A. Install new window lift rod or spring.....	1.50

Top and Windshield Division

Operation Number	Labor Charges
455. Overhaul touring car or torpedo top (including re-covering, lining up and fitting of curtains)	\$ 8.00
456. Replace top deck or side quarters—each or both	5.00
457. Line up and dress top	3.00
458. Install and fit top and curtains	3.00
459. Repair tear in top up to 4"	1.00
460. Replace front or rear bow touring or runabout	3.00
461. Replace center bow—touring or runabout—each	1.25
462. Patch small pin holes	.60
463. Patch hole in curtain or replace celluloid	.60
464. Replace back curtain—old style \$1.50; new style	2.00
465. Replace celluloid in back curtain—old style \$1.75; new style	2.50
466. Refit complete set of side curtains	2.00
467. Refit one side curtain 60c; two	.75
468. Replace top bow socket—touring or runabout	1.25
469. Replace windshield—and line up windshield frame	1.00
470. Replace windshield glass—upper	1.00
471. Replace windshield glass—lower	1.00
472. Replace hinge	.60
473. Replace or tighten dash clips and hinge screws	.50
474. Pack windshield glass to take out rattle—each	1.00
475. Replace windshield bracket	1.00
476. Repair windshield lower frame and install glass	1.75

Lamp and Horn Division

Operation Number	Labor Charges
502. Replace or repair electric headlight switch.....	\$ 0.60
503. Straighten damaged headlamp.....	1.25
504. Take dent out of headlamp door frame and replace glass.....	.75
505. Clean up and repair set of oil lamps.....	1.00
506. Install electric horn and wire.....	1.00
507. Install electric headlights and wire.....	1.50
508. Install new parts in oil lamp—each.....	.60
509. Take short-circuit from switch or lamp.....	1.00

Truck Chassis

95A. Install new frame (when necessary to remove body and cab)	25.00
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Truck Rear System Division

The following time covers work on trucks driven into the service station:

96A. Overhaul complete rear axle assembly.....	12.00
97A. Repair or replace drive shaft tube.....	7.00
98A. Repair or replace one rear radius rod.....	3.00
99A. Replace rear spring—one \$3.50; both.....	5.00
100A. Remove front and rear springs, polish and graphite leaves.....	7.00
101A. Replace spring perches—one \$1.50; both.....	2.75
102A. Rebush springs and perches.....	4.00
103A. Install universal joint.....	5.50

Truck Rear System Division—Continued

Operation Number	Labor Charges
104A. Tighten rear radius rod	\$1.75
105A. Install felt and steel washer, one side—one \$1.25; both	2.25
106A. Install brake shoe and equalize brakes—one \$1.25; both	2.25
107A. Tighten universal ball cap bolts	.75
108A. Install or tighten rear spring clips	1.50
109A. Tighten rear hub lock nut	.50
110A. Fit new key in taper—each	.50
111A. Replace pull rod support—one 50c; both	.75
112A. Replace or rebush hub brake cam—each	2.50
113A. Replace rear axle assembly	5.00
115A. Adjust pull rods or replace one	1.25
116A. Straighten rear radius rod in truck	1.50
117A. Install outer roller bearing—each	1.50
119A. Replace rear axle shaft, drive shaft, worm or worm gear, (no other work necessary)	8.00
Parts brought in or shipped in for repair:	
140B. Overhaul rear axle complete	8.00
141B. Overhaul differential and housing assy	3.75
142B. Overhaul drive shaft and tube assy	2.00
143B. Replace worm or shaft	.75
144B. Replace ball bearing or differential case	.75
145B. Rebush drive shaft housing	.75
146B. Tighten or replace parts on universal joint	.75
147B. Replace differential gear or axle shaft each	.40
148B. Repair or straighten rear radius rod	.75

Starting, Lighting and Ignition Division

The following charges cover work on cars driven into the Service Station:

Operation Number		Labor Charges
520.	Install starting and lighting system.....	\$7.00
521.	Replace instrument board open jobs.....	1.25
522.	Replace battery bracket.....	1.00
523.	Replace starting motor.....	1.00
524.	Replace generator.....	.60
525.	Replace cutout.....	No Charge
526.	Replace ammeter.....	.60
527.	Replace ignition switch.....	.60
528.	Replace foot switch.....	.75
529.	Replace bendix drive.....	.75
530.	Replace ignition wire loom.....	.60
531.	Replace switch to terminal block loom.....	.60
532.	Replace terminal block to head and tail light loom.....	.60
533.	Replace switch to motor cable.....	.40
534.	Replace battery to switch or ground cable each.....	.60
535.	Replace ammeter to switch or cutout wire (one or both).....	.50
536.	Overhaul starting motor.....	3.00
537.	Overhaul generator.....	3.00
538.	Repair and adjust cutout.....	.40
539.	Set or replace third brush.....	No Charge
540.	Clean motor or generator commutator.....	No Charge
541.	Replace commutator case or brush.....	.50

Starting, Lighting and Ignition Division—Continued

Operation Number	Labor Charges
542. Coil units, test, adjust and replace points when necessary—each.....	\$0.25
543. Replace commutator pull rod.....	.40
544. Replace head lamp.....	.60
545. Adjust head lamp (installing bulbs when necessary).....	No Charge
546. Straighten damaged head lamp.....	.60
547. Install lens or reflector (one or both).....	No Charge
548. Replace and adjust horn.....	.60
549. Clean and repair set of oil lamps.....	.60
549A. Repair Bendix.....	1.00
550. Stop oil leaks around generator or starting motor.....	1.00
551. Replace starter or battery cable.....	.75
552. Install dash lamp.....	.60
553. Install stop light.....	1.25
Parts brought in or shipped in for repairs:	
560. Overhaul starting motor.....	2.00
561. Overhaul generator.....	2.00
562. Repair and adjust cutout.....	.40
563. Install field coils in motor or generator yoke.....	.40
564. Adjust or replace third brush.....	No Charge
565. Replace bushing in motor brush end bracket or in mounting bracket.....	.75
566. Replace gear or generator.....	.40
567. Replace bearing (1 or 2) on generator armature.....	.60
568. Install spacer or motor shaft (old style).....	.40
569. Remove ball bearing stuck in bracket.....	.40
570. Remove dents from head lamp, door or body.....	Make Proper Charge

Starting, Lighting and Ignition Division— <i>Continued</i>		Labor Charges
Operation Number		
571.	Install lens or reflector (1 or 2).....	No Charge
572.	Coil units, test, adjust and replace points when necessary—each.....	\$.25
573.	Tighten or remove dent from horn.....	.25

Ford Battery

580.	Install new separators, 1 cell (including material and recharging).....	3.00
581.	Install new separators, 3 cells (including material and recharging).....	5.00
582.	Positive group renewal, 3 cells (including material and recharging).....	11.00
583.	Positive group renewal, 1 cell (including material and recharging).....	5.00
584.	Positive group renewal, 1 cell (including new separators in all 3 cells and recharging).....	6.00
585.	Install new case in battery (including material and recharging).....	2.25
586.	Reseal battery.....	1.25
587.	Change cracked jar (including material).....	2.75
588.	Change two cracked jars (including material).....	4.00
589.	Change three cracked jars (including material).....	5.25
590.	Change cracked cover (including material).....	1.75
591.	Rebuild terminal post.....	.75
592.	Clean corroded terminals and apply vaseline.....	.50
593.	Recharge battery.....	.50
594.	Remove and install loaner.....	.25
595.	Loaner battery—per day.....	.25

Special

600.	Tow-in per mile (each way).....	.50
601.	Start-up (add for each additional mile 15c)	.60

