



AUTHORISED
FLAT RATE MANUAL

for

BODY REPAIRS
TO CARS AND UTILITIES

This Manual is designed to aid motor-body repairers in costing and in estimating time for repair work on all popular makes and models of cars and utilities from 1954 to 1965.

It includes such vital information as:

- Labour Charges and Times
- Panel Work
- Duco Spray Work
- Trimming
- Front Wheel Alignment Figures

1965-1966 edition

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PREFACE

The S.S.A. Authorised Flat Rate Manual for Body Repairs to Cars and Utilities has been compiled in response to a wide demand from the trade throughout Australia for a comprehensive guide to assist motor body repairers in estimating times and the cost for body repairs to motor vehicles.

The Manual includes the majority of the popular makes and models of cars and utilities from 1954 to 1965.

All times and charges listed are based on conditions applying in the average workshop equipped with appropriate tools. The charges are for labour only. The cost of all materials and parts used must be added to the prices shown. Where a vehicle has been involved in an accident the cost of reclaiming or reforming the damaged part must also be added. The charges listed for the various operations are computed on the basis of \$3.28 an hour. However, any other hourly rate may be used by calculating the times as listed and referring to the Labour Charge Calculator on pages 17 to 21.

All vehicles for which repair operations are given are in alphabetical order as are the operations. This has been done for quick reference and simplicity.

Although the publisher cannot accept responsibility for errors or omissions it has made every effort to ensure the accuracy of the contents of the Manual and to facilitate the important complex task of costing automotive body repair work.

The Association takes this opportunity to express thanks and appreciation to the many motor firms and their personnel for their valuable assistance and advice in the preparation of this publication.

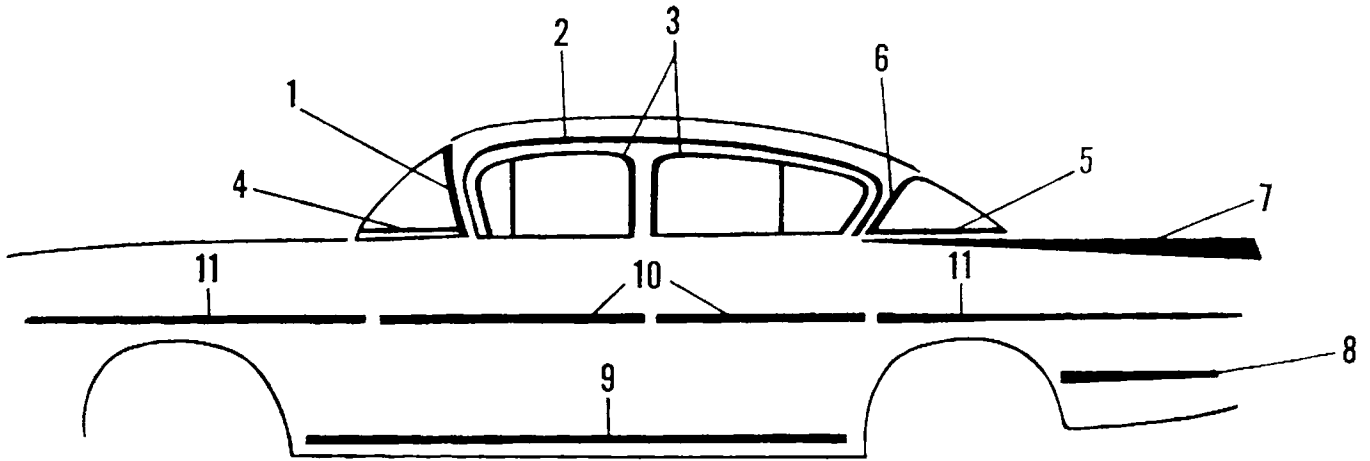
HOW TO USE THIS BOOK

Look for the vehicle in the index on pages 15 and 16. The pages shown for that vehicle will give the whole of the listed operations.

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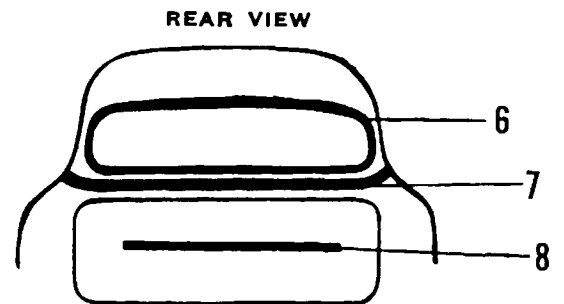
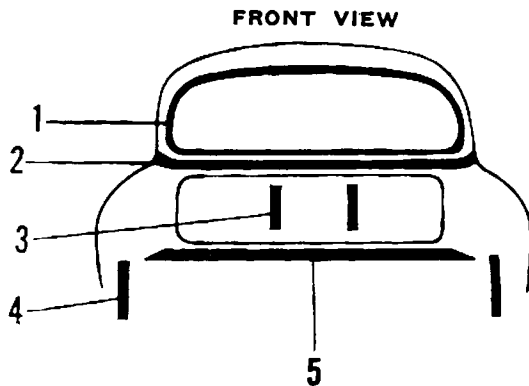
TERMINOLOGY



EXTERIOR MOULDINGS

- | | |
|--------------------------|--------------------------------------|
| 1. Windscreen Moulding. | 7. Rear Quarter Panel Cap Moulding. |
| 2. Door Frame Moulding. | 8. Rear Quarter Panel Tail Moulding. |
| 3. Door Window Moulding. | 9. Rocker Panel Moulding. |
| 4. Front Belt Moulding. | 10. Door Panel Mouldings. |
| 5. Rear Belt Moulding. | 11. Front and Rear Guard Mouldings. |
| 6. Rear Window Moulding. | |

HEAVY LINES SHOW MOULDINGS ITEMS DO NOT REFER TO ANY MAKE OF VEHICLE

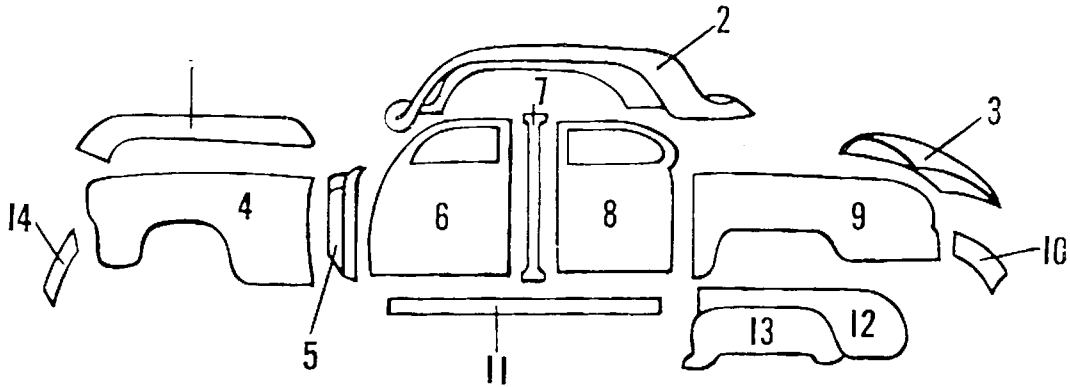


EXTERIOR MOULDINGS

- | | |
|-------------------------|--------------------------|
| 1. Windscreen Moulding. | 5. Front Panel Moulding. |
| 2. Front Belt Moulding. | 6. Rear Window Moulding. |
| 3. Bonnet Moulding. | 7. Rear Belt Moulding. |
| 4. Guard Moulding. | 8. Boot Panel Moulding. |

HEAVY LINES SHOW MOULDINGS ITEMS DO NOT REFER TO ANY PARTICULAR MAKE OF VEHICLE

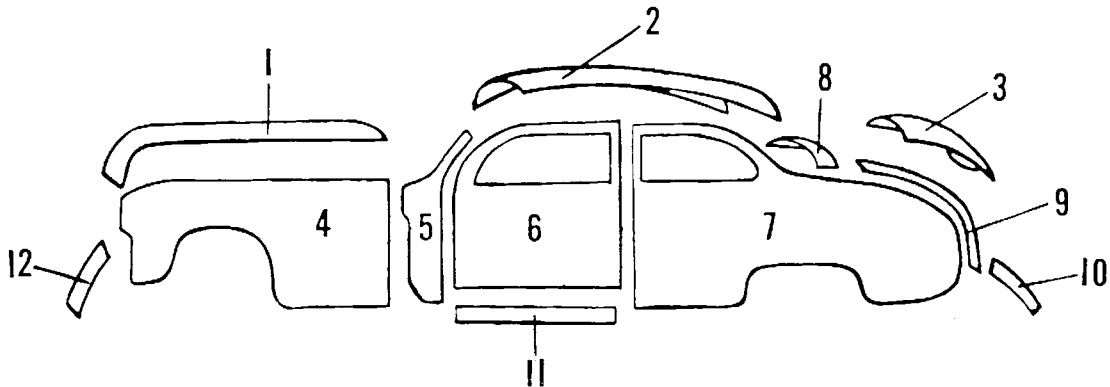
TERMINOLOGY



SEDAN CAR PANELS

- | | |
|-------------------|-------------------|
| 1. Bonnet. | 8. Rear Door. |
| 2. Turret Top. | 9. Quarter Panel. |
| 3. Boot Lid. | 10. Rear Apron. |
| 4. Front Guard. | 11. Rocker Panel. |
| 5. Cowl or Dash. | 12. Rear Guard. |
| 6. Front Door. | 13. Wheel Shield. |
| 7. Centre Pillar. | 14. Front Apron. |

ITEMS DO NOT REFER TO ANY MAKE OF VEHICLE



TWO-DOOR SEDAN PANELS

- | | |
|-----------------|---------------------|
| 1. Bonnet. | 7. Quarter Panel. |
| 2. Turret Top. | 8. Upper Panel. |
| 3. Boot Lid. | 9. Extension Panel. |
| 4. Front Guard. | 10. Rear Apron. |
| 5. Cowl. | 11. Rocker Panel. |
| 6. Door. | 12. Front Apron. |

ITEMS DO NOT REFER TO ANY PARTICULAR MAKE OF VEHICLE

VEHICLES AND OPERATIONS

TIMES AND LABOUR CHARGES 37

OPERATION		CITROEN:	
		DS19 & ID 19 Hrs.	Price \$
BODY			
1	Body Shell, Renew and Transfer All Parts (Not Including Mechanical or Electrical)	35	144.80
BONNET			
2	Remove and Replace	2	6.56
3.	Fittings, Remove and Replace	1.5	4.10
4.	Hinges, Remove, Replace and Align	1.75	4.92
5.	Remote Control, Adjust	.75	2.46
BOOT-LID & FLOOR			
6.	Boot Lid, Remove and Replace as a Unit	2.5	8.20
7.	Weatherseal, Remove and Replace	1	3.28
8.	Check Arm, Renew		
9.	Handle and Lock Assembly, Remove and Replace	.75	2.46
10.	Hinges, Remove and Replace	2.5	8.20
11.	Spring Loader, Remove and Replace	.75	2.46
12.	Handle Gasket Renew	.5	1.64
13.	Floor, Remove and Replace	7	22.96
BUMPER BARS			
14.	Front, Remove and Replace	1.25	4.10
15.	Front with Brackets, Remove and Replace	1.5	4.92
16.	Rear, Remove and Replace	1.25	4.10
17.	Rear with Brackets, Remove and Replace		
18.	Front Front Bracket, Remove and Replace One	1	3.28
19.	Front Brackets, Remove and Replace Both	1.5	4.92
20.	Rear Bracket, Remove and Replace One	1.25	4.10
21.	Rear Brackets, Remove and Replace Both	2	6.56
DOORS			
27.	Remove and Replace as a Unit	1.75	5.74
23.	Door Check, Renew	1	3.28
24.	Fittings, Complete, Remove and Replace	5	16.40
25.	Hinges, Reset		
26.	Panel Skin, Remove and Replace	7.5	24.60
27.	Weatherseal, Remove and Replace	1.5	4.92
28.	Handle, Remove and Replace	1	3.28
29.	Handle and Lock Assembly Remove and Replace	1.5	4.92
30.	Window Winder, Remove and Replace	3	9.84
31.	Glass, Remove and Replace	3	9.84
32.	Front Windlace Remove and Replace	2	6.56
33.	Rear Windlace, Remove and Replace	2	6.56
DUCO			
34.	Complete	40	131.20
35.	Turret Top Panel	9	29.52
36.	Body Door, One	6	19.68
37.	Sill Panel	2.5	8.20
38.	Centre Pillar	1	3.28
39.	Boot Lid	3	9.84
40.	Front Guard in Position	4.5	14.76
41.	Rear Guard or Quarter Panel in Position	3	9.84
42.	Bonnet	4	13.12

VEHICLES AND OPERATIONS**TIMES AND LABOUR CHARGES 38**

OPERATION	CITROEN: DS19 & ID 19	
	Hrs.	Price \$
GLASS		
48. Rear Window Glass Remove and Replace	4	13.12
49. Vent or Flipper Glass, Remove and Replace One	1.75	5.74
51. Windscreen Glass, Remove and Replace	4	13.12
52. Fixed Body Glass, Remove and Replace One	2	6.56
53. Weatherseal Windscreen	4	13.12
54. Weatherseal Rear Window	4	13.12
GRILLE		
55. Remove and Replace	1.5	4.92
INSTRUMENT PANEL		
60. Panel, Remove and Replace, No Radio	1.5	4.92
61. Panel, Remove and Replace, With Radio	2.5	8.20
62. Glove Box, Remove and Replace	.75	2.46
LAMPS		
63. Head, Remove and Replace One, as a Unit	.75	2.46
64. Head, Install New Sealed Unit, One	.5	1.64
65. Head, Refocus	1	3.28
66. Number Plate, Remove and Replace	1.5	4.10
67. Stop, Remove and Replace One	.75	2.46
68. Indicator, Rear, Remove and Replace One	.75	2.46
69. Dome or Door, Remove and Replace One	1	3.28
70. Dome or Door, Renew Switch	1	3.28
71. Dip Switch, Remove and Replace	1.25	4.10
MATS		
72. Front Floor Mat Remove and Replace	.75	2.46
73. Rear Floor Mat, Remove and Replace	.5	1.64

VEHICLES AND OPERATIONS**TIMES AND LABOUR CHARGES 39**

OPERATION	CITROEN: DS19 & ID 19	
	Hrs.	Price \$
MUDGUARDS		
80 Front Guard, Remove and Replace	4	13.12
81 Rear Guard, Remove and Replace	2.5	8.20
PANELS		
85. Rear Upper Beaver Panel, Remove and Replace	2	6.55
86. Rear Lower Beaver Panel, Remove and Replace	3	9.84
87. Rear Quarter Panel, Remove and Replace	20	65.50
88. Rear Wheel Arch, Remove and Replace	2.75	9.02
89. Turret, Remove and Replace	29	95.12
91. Front Body Pillar, Remove and Replace	8	26.24
92 Centre Pillar, Remove and Replace	7	22.96
93. Rocker or Sill Panel, Remove and Replace	7	22.35
SEATS		
94. Remove and Replace Seat Squab	4	13.12
95. Remove and Replace Seat Runners	2.5	8.20
96. Remove and Replace Rear Spring or Rubber Assembly	3.75	12.30
TRIM		
97. Turret Head Lining, Remove and Replace	8	26.24
98. Trim Complete	48	157.44
99. Front Door, Trim	1.75	5.74
100. Rear Door, Trim	1.75	5.74
101. Arm Rest, Trim	1.75	5.74
102. Arm Rest, Trim and Rubber Pack	2.25	7.38
103. Cowl Side Quarter Panel, Trim	1.5	4.10
104. Rear Shelf Panel, Trim.	2.5	8.20
105. Front Seat, Recover, Including Padding.	7.5	24.60
105. Rear Seat, Recover, Including Padding	7.5	24.60
107. Front Seat Squab, Recover, Including Padding	7	22.96
108. Rear Seat Squab, Recover, Including Padding	6.5	21.32
109. Panel Rear of Front Seat. Recover	3	9.84
WINDOW, DOOR		
115. Front Bailey Channel, Remove and Replace	2.5	8.20
116. Rear Bailey Channel, Remove and Replace	2.5	8.20

FRONT WHEEL ALIGNMENT FIGURES — CARS AND UTILITIES

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Year	Model	Caster Angle (Degrees)	Camber Angle (Degrees)	King Pin Inclination (Degrees)	Toe-in (Inches)
CITROEN					
1936—55	15 H.P. "Fifteen" 4 cyl.	1.5	1	9	1/16 out
1936—55	22.6 H.P. "B166", 6 cyl.	0	1		1/16 out
1955—57	2CV	1/4	1.5		1/8 out
1956—58	DSI9	1.75	-1/4	0	3/32
1960-64	DS-19, 1D-19.	1.5	0	5.75	3/32 to 1/8
Tolerances: Caster $\pm 1/4$, Camber $\pm 1/2$.					