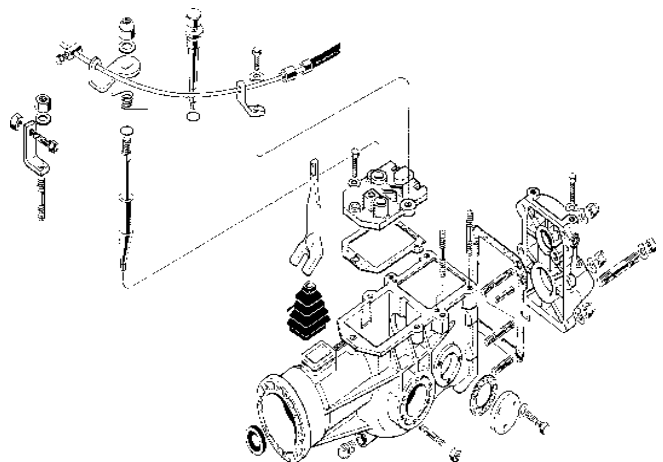
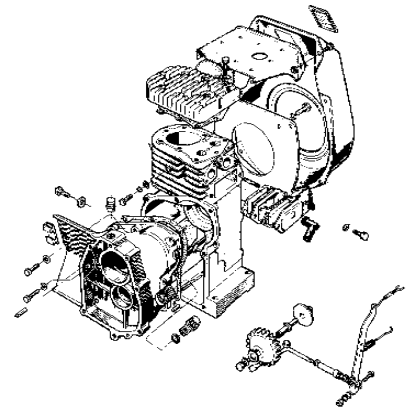
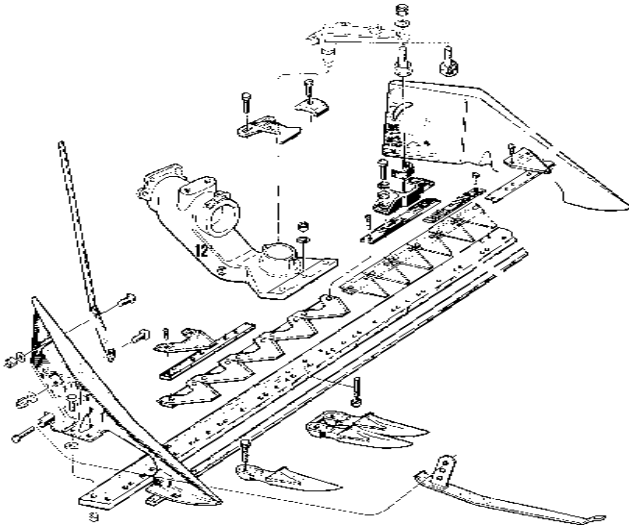


Flat-Rate Labor Manual



Model	Repair Made	Labor Hours
CA180 Engine	Air Cleaner Replacement	0.1
	Spark Plug Replacement	0.1
	Spark Plug Cable Replacement	0.5
	Breaker Points Adjustment	0.2
	Breaker Points Replacement	0.3
	Condenser Replacement	0.2
	Coil Replacement	0.7
	Crankcase Replacement	4
	Crankshaft Bearing PTO Side (Engine Assembled)	1
	Crankshaft Bearing PTO Side (Engine Disassembled)	0.2
	Crankshaft Bearing Flywheel Side (Engine Assembled)	3
	Crankshaft Bearing Flywheel Side (Engine Disassembled)	0.3
	Engine Support Replacement	0.2
	Cylinder Honing	0.2
	Cylinder Boring	1
	Complete Piston Replacement	2.5
	Piston Ring Replacement	2.3
	Crankshaft Replacement	3
	Crankshaft Grinding (Crank Pin)	1.3
	Crankshaft Grinding (Main Journals)	1.2
	Crankshaft Grinding (Complete)	2.5
	Connecting Rod Replacement	2
	Complete Cylinder Head Replacement	0.7
	Replace Rocker Arms Pr.	0.3
	Replace Push Rods Pr.	0.3
	Replace Rocker Arm Gasket Cover	0.2
	Replace Valve Guides Pr.	1.7
	Replace Valve Springs Pr.	1.5
	Replace Valve Locking Plate Pr.	1.5
	Change And Grind Valves (Engine Assembled)	2.4
	Change And Grind Valves (Engine Disassembled)	0.3
	Oil Seal Replacement (PTO Side)	0.2
	Oil Seal Replacement (Flywheel Side)	0.7
	Breather Valve Replacement	0.3
	Air Conveyor Replacement	0.3
	Cylinder Conveyor Replacement	0.3
	Top Conveyor Replacment	0.4
	Flywheel Screen Replacement	0.2
	Govenor Fork Replacement	0.7
	Governor Assembly Replacement	0.8
	Governor Linkage Replacement	0.2
	Governor Ball Replacement	0.6
	Fuel Tank Replacement	0.5
	Camshaft Replacement	1.5
	Timing Cover Replacement	0.5
	Cover Gasket Replacement	0.4
	Crankshaft Gear Replacement	1
	Complete Gear Train Replacement	1.3
	Carburetor Replacement	0.2
	Float Replacement	0.3
Replace Needle Seat	0.3	
Replace Float Bowl	0.2	
Atomizer Replacement	0.2	
Fuel Filter Replacement	0.2	
Fly Wheel Nut Replacement	0.2	
Starting Pulley Replacement	0.2	
Engine Flywheel Replacement	0.5	
Recoil Replacement	0.2	
Cable Replacement (Recoil)	0.5	

201 - 203		
	Remove And Replace Wheel Axle Seals	2.5
	Repair Oil Leak At Shifter Cam O-Ring	1.3
	Remove And Replace Side Cover Gasket	1
	Remove And Replace Engine/Trans. Gasket	1
	Cable Replacement	0.2
	Drive Shaft Replacement	2
	PTO Coupling Replacement	0.75
	Inner Tube Replacement	0.5
	PTO Coupling Pin Replacement	0.75
	Replace Transmission Housing	3.5
	Throttle Control Replacement	0.75
204 - 205		
	Remove And Replace Wheel Axle Seals	2.5
	Repair Oil Leak At Shifter Cam O-Ring	1.3
	Remove And Replace Side Cover Gasket	1
	Remove And Replace Engine/Trans. Gasket	1
	Cable Replacement	0.2
	Drive Shaft Replacement	2
	PTO Coupling Replacement	0.75
	Inner Tube Replacement	0.5
	PTO Coupling Pin Replacement	0.75
	Replace Transmission Housing	3.5
	Wheel Gear Replacement	0.6
	Wheel Hub Replacement	0.8
	Complete Wheel Assembly Replacement	0.5
	Replace Any Or All Gears In Transmission	2.5
	Throttle Control Replacement	0.75
600 Series ' 94 & Before		
	PTO Coupling Replacement	0.75
	Clutch Replacement	0.75
	Operator Presence Control Lever Replacement	0.5
	Cable Replacement	0.2
	Inner Tube Replacement	0.75
	PTO Transmission Cover Replacement	2
	Replace Any Or All Drive Gears In Transmission	3
	Replace Reverser Gear External Mount	1
	Differential Replacement	5
	Clutch Or Brake Lever Replacement	0.5
	Throttle Lever Replacement	0.25
	Shift Quadrant Adjustment	0.25
	Handle Bar Release Spring Replacement	1
	PTO Shaft Replacement	2
	PTO Conversion	4
	Bumper Replacement	0.5
700 Series ' 94 & Before		
	Clutch Replacement	0.75
	Clutch Or Brake Lever Replacement	0.5
	Throttle Lever Replacement	0.25
	Shift Quadrant Adjustment	0.25
	PTO Coupling Replacement	0.75
	Operator Presence Control Lever Replacement	0.5
	Cable Replacement	0.25
	Inner Tube Replacement	0.5
	PTO Transmission Cover Replacement	2
	Replace Any Or All Drive Gears In Transmission	3
	Replace Reverser Gear External Mount	1
	Differential Replacement	5

	Handle Bar Release Spring Replacement	1
	PTO Shaft Replacement	2
	PTO Conversion	4
	Bumper Replacement	0.5
700 Series ' 95 & After		
	Cable Replacement	0.25
	Replace Reverser Gear External Mount	1
	PTO Transmission Cover Replacement and PTO	2.5
	Replace Any Or All Gears In Transmission	3
	Throttle Control Replacement	0.75
	Throttle Lever Replacement	0.25
	Operator Presence Control Lever Replacement	0.5
	Clutch Lever Replacement	0.5
	Reveser Handle Replacement	0.5
	Bumper Replacement	0.5
	Clutch Replacement	0.75
	Oil Seal (By Clutch) Replacement	1
	Inner Tube Replacement	0.75
800 Series ' 95 & After		
	Cable Replacement	0.25
	PTO Transmission Cover Replacement & PTO Engagem	2.5
	Replace Any Or All Gears In Transmission	3
	Throttle Lever Replacement	0.25
	Operator Presence Control Lever Replacement	0.5
	Clutch Or Brake Lever Replacement	0.5
	Reveser Handle Replacement	0.5
	Bumper Replacement	0.5
	Clutch Replacement	0.75
	Oil Seal (By Clutch) Replacement	1
	Differential Replacement	5
	Handle Bar Release Spring Replacement	1
	Inner Tube Replacement	0.75
Tillers 200 Series		
	Replace Both Oil Seals	2
	Replace Slip Clutch	2
	Replace Rear Cover Gasket	1
	Replace Tiller Hood	0.75
	Replace Tine Hub	0.75
	Replace All Gears And Seals	2.5
	Replace Attachment Springs	0.25
Tillers		
	Replace Tiller Hood	0.75
	Replace Both Oil Seals	2
	Replace All Gears And Seals	2.5
	Replace Tine Hub	0.75
	Replace Rear Cover Gasket	1
	Replace Complete Tiller Transmission	1
	Replace Bearing Left Side	2
	Replace Bearing Right Side	1
Cutter Bars		
	Replace Attachment Springs (200 Ser)	0.25
	Replace Cutter Bar Hood	0.5
	Replace Crank Drive And Bearings	1.5
	Replace Retaining Studs (200 Ser)	1
	Replace Blade Coupling	0.5
	Replace PTO Coupling (200 Ser)	0.75
	Replace Drive Shaft	1

Lawnmowers		
	Replace Bag (22")	0.5
	Replace Bag (38")	0.75
	Replace Drive Shaft	2
	Replace PTO Seal	0.75
	Replace Brake (22")	1
	Replace Gear Housing	2
	Replace Gear Box Gasket (22")	0.5
	Replace Gear Box Gasket (38")	0.75
Snow Throwers		
	Replace Turbine	1
	Replace Oil Seals	1.5
	Replace Main Drive Shaft	2.5
	Replace Chute Control Cable	0.5
	Replace Chute Gear Ring	0.75
	Replace Chute Control Lever	0.5
Chipper/Shredder		
	Replace Chipper Chute	0.5
	Replace Chipper Hopper	0.75
	Replace Both Chipper Chute And Hopper	1.25
	Replace Bearing Chute Side	1
	Replace Bearing Pulley Side	1.5
	Replace Both Bearings	2.5
	Replace Chipper Belt	0.75
	Replace Complete Clutch	0.75
	Replace Clutch Lining	1.25
	Replace Chipper Flywheel	3
	Replace Chipper Blade	0.75
Sweepers		
	Replace Complete Set Of Brushes	1.5
	Replace Individual Brushes	0.75
	Replace Universal Joint	1
	Replace Brace With Adjusting Plate	1
	Replace PTO Drive Shaft	1.5
	Realign Set Screw	1

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Flat Labor-Rate
Manual
6/29/11