



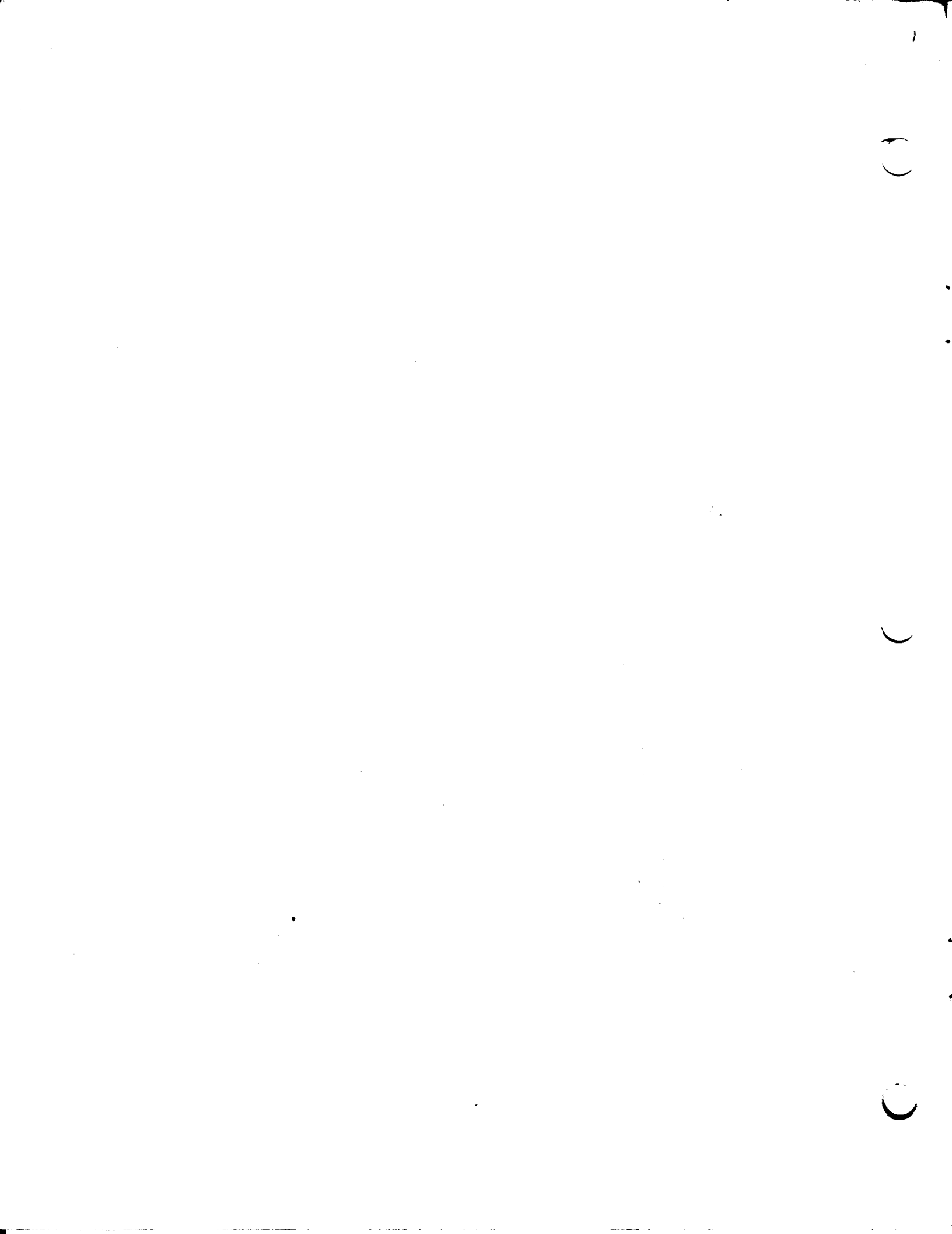
APPROVED LABOR ALLOWANCE SCHEDULE



 **TELEDYNE CONTINENTAL MOTORS**
Aircraft Products Division

X30552

APRIL 1984



LABOR ALLOWANCE SCHEDULE

1. Labor allowances shown are for removal and replacement of engines or parts.
2. Complete top overhaul consists of removal of cylinders, honing cylinders, replacing guides, grinding valve seats, cleaning pistons, installing new rings and reinstalling cylinders.
3. Single cylinder replacement. When cylinder bore is serviceable and can be reconditioned by cleaning and honing only, add one (1) hour. If reconditioning also requires replacement of guides and grinding of valve seats, add one (1) additional hour.
4. First Cylinder Change - each side. When a new cylinder is installed, the labor allowance includes installing valves, piston and rings. For each additional cylinder installation, the labor allowance will be three (3) hours.
5. Labor allowance for fuel system components includes required normal adjustments.

O-200 SERIES

	Cessna 150	Bellanca	Citabria	Rallye	Taylorcraft					
Engine Change	10.0	10.0	10.0	10.0	10.0					
Complete Top Overhaul	25.0	25.0	25.0	25.0	25.0					
First Cylinder Change	4.0	4.0	4.0	4.0	4.0					
Starter Adapter	1.8	1.8	1.8	1.8	1.8					
Starter	.8	.8	.8	.8	.8					
Fuel Pump (opt.)	1.0	1.0	1.0	1.0	1.0					
Accessory Drive Housing	7.0	7.0	7.0	7.0	7.0					
Crankshaft Oil Seal	1.0	1.0	1.0	1.0	1.0					
Oil Cooler (opt.)	1.0	1.0	1.0	1.0	1.0					
Oil Pump	8.0	8.0	8.0	8.0	8.0					
Oil Sump	2.0	2.0	2.0	2.0	2.0					
Alternator or Generator	1.5	1.5	1.5	1.5	1.5					
Magneto	1.4	1.4	1.4	1.4	1.4					
Ignition Harness	1.5	1.5	1.5	1.5	1.5					
Carb.	2.0	2.0	2.0	2.0	2.0					

IO-360 SERIES

	Cessna 337 Front	Cessna 337 Rear	Cessna 172 XP	Maule						
Engine Change	26.0	28.0	22.0	22.0						
Complete Top Overhaul	36.0	36.0	36.0	36.0						
First Cylinder Change	6.0	6.0	6.0	6.0						
Starter Adapter	3.0	6.0	3.0	3.0						
Starter	1.0	2.0	1.0	1.0						
Throttle & Controller	N/A	N/A	N/A	N/A						
Fuel Metering	2.0	2.0	2.0	2.0						
Complete Fuel Injection	9.0	9.0	9.0	9.0						
Fuel Pump	2.5	2.5	2.5	4.0						
Fuel Discharge Nozzle	.3 ea.	.3 ea.	.3 ea.	.3 ea.						
Fuel Distributor Valve	1.0	1.0	1.0	1.0						
Accessory Drive Housing	14.0	20.0	12.0	12.0						
Crankshaft Oil Seal	3.0	3.0	2.0	2.0						
Oil Cooler	3.0	3.0	3.0	3.0						
Oil Pump	15.0	21.0	13.0	13.0						
Oil Sump	20.0	20.0	15.0	15.0						
Alternator	3.4	3.4	2.0	2.0						
Magneto	2.0	2.5	1.5	1.5						
Ignition Comp. Harness	2.5	2.5	2.5	2.5						

* Add 1 hour hot prop.

L/TSIO-360 SERIES

	Cessna 337 Front	Cessna 337 Rear	PA28R-201T	PA34-200T	Mooney					
Engine Change	30.0	34.0	32.0	30.0	32.0					
Complete Top Overhaul	36.0	36.0	36.0	36.0	36.0					
First Cylinder Change	6.0	6.0	6.0	6.0	6.0					
Starter Adapter	3.0	6.0	** 2.5	** 2.0	2.5					
Starter	1.0	2.0	1.0	1.0	1.0					
Throttle & Controller										
Fuel Metering	2.0	2.0	1.5	1.5	1.5					
Complete Fuel Injection	11.0	11.0	7.0	7.0	7.0					
Fuel Pump	2.5	2.5	2.5	2.0	2.5					
Fuel Discharge Nozzle	.5 ea.	.5 ea.	.5 ea.	.5 ea.	.5 ea.					
Fuel Distributor Valve	1.0	1.0	1.0	1.0	1.0					
Accessory Drive Housing	19.0	25.0	9.0	8.0	9.0					
Crankshaft Oil Seal	* 3.0	* 3.0	* 3.0	* 3.0	* 3.0					
Eng. Mount Bracket Forge Cooler	3.0	3.0	3.0	3.0	3.0					
Oil Cooler	3.0	3.0	1.5	1.5	2.0					
Oil Pump	20.0	26.0	10.0	10.0	10.0					
Oil Sump	15.0	15.0	10.0	4.0	10.0					
Alternator	3.4	3.4	1.5	1.0	1.5					
Magneto	2.0	2.5	*** 1.5	*** 1.0	1.5					
Ignition Harness	3.0	3.0	2.0	1.5	2.0					

* Add 1 hour hot prop.

** Starter Adapter with air cond. add 1 hour.

*** Add .5 with air cond.

L/TSIO-360 (cont'd.)

	Cessna 337 Front	Cessna 337 Rear	PA28R-201	PA34-200T	Mooney					
Turbocharger			2.0	2.0	2.0					
Valve Assy. Exhaust Bypass			.5	.5	.5					
Air Cond. Comp. Mount			FWD 2.0 AFT 1.0	FWD 2.0 AFT 1.0						
Air Cond. Belt			.5	.5						
Air Cond. Sheave			.5	.5						

O-470 SERIES	Beech 35 G	Bellanca 14-19 K	Cessna 310 B, M	Cessna 188 R, S	Cessna 182	Cessna 180 A, K, L, R	Navion P			
Engine Change	29.0	29.0	29.0	29.0	21.0	21.0	29.0			
Complete Top Overhaul	38.0	36.0	40.0	36.0	36.0	36.0	36.0			
First Cylinder Change	*	6.0	6.0	6.0	6.0	6.0	6.0			
Starter Adapter	3.0	3.0	3.0	10.0	**	10.0	3.0			
Starter	1.0	1.0	1.0	1.0	1.0	1.0	1.0			
Throttle & Controller	N/A	N/A	N/A	N/A	N/A	N/A	N/A			
Fuel Metering	N/A	N/A	N/A	N/A	N/A	N/A	N/A			
Complete Fuel Injection	N/A	N/A	N/A	N/A	N/A	N/A	N/A			
Fuel Pump	2.0	2.0	2.0	N/A	N/A	N/A	2.0			
Fuel Discharge Nozzle	N/A	N/A	N/A	N/A	N/A	N/A	N/A			
Fuel Distributor Valve	N/A	N/A	N/A	N/A	N/A	N/A	N/A			
Accessory Drive Housing	N/A	N/A	N/A	N/A	N/A	N/A	N/A			
Crankshaft Oil Seal	***	***	***	***	***	***	***			
Oil Cooler	2.0	2.0	2.0	1.5	3.0	3.0	2.0			
Oil Pump	4.0	4.0	4.0	15.0	10.0	10.0	4.0			
Oil Sump	15.0	15.0	15.0	15.0	10.0	10.0	15.0			
Alternator or Generator	1.0	1.0					1.0			
Magneto	1.5	1.5	1.5	1.5	1.5	1.5	1.5			
Ignition Harness	3.0	3.0	3.0	3.0	3.0	3.0	3.0			
Carb.	3.0	3.0	3.0	3.0	3.0	3.0	3.0			

* No. 6 cylinder add 2 hours.

** 1978 C182 add 6 hours

*** Add 1 hour hot prop

IO-470 SERIES

	Beech 55 L	Beech 35, 33 C, J, K, N	Bellanca D, F	Cessna 310 U, V, D	Cessna 210, 205 E, S	Cessna 185 F	Navion H	Rockwell 500 M	Rockwell 200 D	
Engine Change	29.0	29.0	29.0	29.0	29.0	29.0	29.0	29.0	29.0	
Complete Top Overhaul	36.0	38.0	36.0	36.0	36.0	36.0	36.0	36.0	36.0	
First Cylinder Change	6.0	6.0 *	6.0	6.0	6.0	6.0	6.0	6.0	6.0	
Starter Adapter	3.0	3.0	3.0	3.0	3.0	10.0	3.0	3.0	3.0	
Starter	1.0	1.0	1.0	1.0	1.0	1.0	1.0	1.0	1.0	
Throttle & Controller	4.0									
Fuel Metering	2.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	
Complete Fuel Injection	9.0	9.0	9.0	9.0	9.0	9.0	9.0	9.0	9.0	
Fuel Pump	4.0	3.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	
Fuel Discharge Nozzle	.3 ea.	.3 ea.	.3 ea.	.3 ea.	.3 ea.	.3 ea.	.3 ea.	.3 ea.	.3 ea.	
Fuel Distributor Valve	.8	.8	.8	.8	.8	1.0	.8	.8	.8	
Accessory Drive Housing	1.0	1.0	1.0	1.0	1.0	1.0	1.0	1.0	1.0	
Crankshaft Oil Seal	** 3.0	** 3.0	** 3.0	** 3.0	** 3.0	** 3.0	** 3.0	** 3.0	** 3.0	
Oil Cooler	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	
Oil Pump	4.0	4.0	4.0	4.0	10.0	10.0	4.0	4.0	4.0	
Oil Sump	20.0	15.0		15.0	15.0	15.0	15.0	15.0	15.0	
Alternator or Generator	1.0	1.0	1.0	1.0			1.0	1.0	1.0	
Magneto	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	
Ignition Harness	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	

* No. 6 cylinder add 2 hours.

** Add 1 hour hot prop.

TSIO-470 SERIES

	Cessna 320									
Engine Change	36.0									
Complete Top Overhaul	37.0									
First Cylinder Change	6.0									
Starter Adapter	4.0									
Starter	1.0									
Throttle & Controller										
Fuel Metering	4.0									
Complete Fuel Injection	11.0									
Fuel Pump	4.0									
Fuel Discharge Nozzle	.5									
Fuel Distributor Valve	1.0									
Accessory Drive Housing										
Crankshaft Oil Seal	3.0*									
Oil Cooler	3.0									
Oil Pump	4.0									
Oil Sump	15.0									
Alternator	1.0									
Magneto	1.5									
Ignition Harness	3.0									
Turbocharger	5.0									

* Add 1 hour hot prop.

IO-520 SERIES

	Beech 58 & 55	Beech 36, 35, 33	Bellanca 17-30	Cessna 310R	Cessna 210	Cessna 207, 206	Cessna 188 D	Cessna 185	Rockwell 200 A	
Engine Change	29.0	29.0	29.0	29.0	29.0	29.0	29.0	29.0	29.0	
Complete Top Overhaul	37.0	37.0	37.0	37.0	37.0	37.0	37.0	37.0	37.0	
First Cylinder Change	6.0	6.0 *	6.0	6.0	6.0	6.0	6.0	6.0	6.0	
Starter Adapter	4.0	4.0	4.0	4.0	4.0	4.0	10.0	10.0	4.0	
Starter	1.0	1.0	1.0	1.5	.8	.8	1.5	1.5	1.0	
Throttle & Controller	4.0	1.5		3.0						
Fuel Metering	2.0	1.5	4.0	2.5	4.0	4.0	4.0	4.0	4.0	
Complete Fuel Injection	9.0	5.0	9.0	9.0	9.0	9.0	9.0	9.0	9.0	
Fuel Pump	3.0	2.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	
Fuel Discharge Nozzle	.3 ea.	.3 ea.	.3 ea.	.3 ea.	.3 ea.	.3 ea.	.3 ea.	.3 ea.	.3 ea.	
Fuel Distributor Valve	.8	.8	1.0	1.0	1.0	1.0	1.0	1.0	.8	
Accessory Drive Housing	1.0	1.0	1.0	1.0	1.0	1.0	1.0	1.0	1.0	
Crankshaft Oil Seal	** 3.0	** 3.0	** 3.0	** 3.0	** 3.0	** 3.0	** 3.0	** 3.0	** 3.0	
Oil Cooler	3.0	3.0	3.0	3.0	3.0	3.0	1.5	3.0	3.0	
Oil Pump	4.0	4.0	4.0	4.0	10.0	10.0	10.0	10.0	4.0	
Oil Sump	4.0	15.0	4.0	14.0	20.0	20.0	15.0	15.0	15.0	
Alternator	2.0	2.0	2.0	2.0					2.0	
Magneto	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	
Ignition Harness	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	
Air Cond. Comp. Mount		4.0								

* No. 6 cylinder add 2 hours.

** Add 1 hour hot prop.

IO-520 (cont'd.)

	Beech 58 & 55	Beech 36, 35, 33	Bellanca 17-30	Cessna 310R	Cessna 207, 206	Cessna 188 D	Cessna 185	Rockwell 200 A		
Air Cond. Belt		2.0								
Air Cond. Sheave	2.0									

TSIO-520 SERIES

	Beech 58P	Beech V35A-TC and A36-TC D	Cessna 402, 414	Cessna 303, 340	Cessna 310R B	Cessna 210 & P210	Cessna 207, 206	Cessna 188T	Ram	Malibu	
Engine Change	47.0	36.0	36.0	36.0	36.0	P40.0 36.0	36.0	29.0	36.0	36.0	
Complete Top Overhaul	37.0	37.0	37.0	37.0	37.0	P42.0 37.0	37.0	37.0	37.0	37.0	
First Cylinder Change	6.0	* 6.0	6.0	6.0	6.0	*** 6.0	*** 6.0	6.0	6.0	7.0	
Starter Adapter	4.0 RH 8.0 LH	4.0	4.0	4.0	4.0	4.0	4.0	10.0	3.0	8.0	
Starter	1.0	1.0	1.5	1.5	1.5	.8	.8	1.5	1.5	1.0	
Throttle & Controller	3.0	1.5	3.5	3.5	3.5				*	2.0	
Fuel Metering		1.5	4.0	4.0	2.5	4.0	4.0	4.0	4.0		
Complete Fuel Injection	6.0	6.0	11.0	11.0	10.0	11.0	11.0	9.0	11.0	11.0	
Fuel Pump	2.0	3.0	4.0	4.0	3.5	4.0	4.0	4.0	4.0	4.0	
Fuel Discharge Nozzle	.5 ea.	.5 ea.	.5 ea.	.5 ea.	.5 ea.	.5 ea.	.5 ea.	.3 ea.	.5 ea.	.5 ea.	
Fuel Distributor Valve	.8	.8	1.5	1.5	1.5	1.0	1.0	1.0	1.0	2.0	
Accessory Drive Housing	1.0	1.0	1.0	1.0	1.0	1.0	1.0	1.0	1.0	1.0	
Crankshaft Oil Seal	** 3.0	** 3.0	** 3.0	** 3.0	** 3.0	** 3.0	** 3.0	** 3.0	** 3.0	** 1.5	** 3.0
Oil Cooler	3.0	3.0	3.0	3.0	3.0	3.0	3.0	1.5	1.5	3.0	
Oil Pump	6.0	15.0	5.0	5.0	5.0	20.0	20.0	10.0	4.0	5.0	
Oil Sump	15.0	15.0	10.0	10.0	15.0	20.0	20.0	15.5	16.5	5.0	
Alternator	2.0	2.0	2.2	2.2	2.0					1.5	
Magneto	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	
Ignition Harness	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	
Turbocharger	5.0	10.0	5.0	5.0	4.5				2.0	1.5	

* No. 6 cylinder add 2 hours.

** Add 1 hour hot prop.

*** 1-3-5 cylinder add 1 hour

TSIO-520 (cont'd.)

	Beech 58P	Beech V35A-TC and A36-TC D	Cessna 402, 414	Cessna 303, 340	Cessna 310R B	Cessna 210	Cessna 207, 206	Cessna 188T	Ram	Malibu
Controller	1.5									1.5
Waste Gate	1.5	2.5						1.5		2.5
Air Cond. Comp. Mount	4.0									4.0
Air Cond. Belt	2.0									2.0
Air Cond. Sheave	2.0									6.0
Intercooler			4.0	4.0						1.5
Overboost Valve										1.0
Diverter Valve										1.0

GTSIO-520 SERIES

	Cessna 421B	Cessna 421C	Cessna 404	Cessna 411 or Beagle	Rockwell 685					
Engine Change	44.0	44.0	44.0	44.0	65.0					
Complete Top Overhaul	46.0	46.0	46.0	46.0	46.0					
First Cylinder Change	7.0	7.0	7.0	7.0	9.0					
Starter Adapter	6.0	6.0	6.0	6.0	6.0					
Starter	1.5	1.5	1.5	1.5	1.5					
Throttle & Controller	2.0	2.0	2.0	2.0	3.0					
Fuel Metering	4.0	4.0	4.0	4.0	4.0					
Complete Fuel Injection	11.0	11.0	11.0	11.0	16.0					
Fuel Pump	4.0	4.0	4.0	4.0	6.0					
Fuel Discharge Nozzle	.5 ea.	.5 ea.	.5 ea.	.5 ea.	.5 ea.					
Fuel Distributor Valve	2.5	2.5	1.5	1.5	2.5					
Accessory Drive Housing	1.0	1.0	1.0	1.0	1.0					
Crankshaft Oil Seal	* 3.0	* 3.0	* 3.0	* 3.0	* 3.0					
Oil Cooler	4.0	4.0	3.5	4.0	6.0					
Oil Pump	5.0	5.0	8.0	5.0	12.0					
Oil Sump	20.0	20.0	20.0	20.0	30.0					
Alternator	2.0	2.0	2.0	2.0	4.0					
Magneto	2.5	2.5	2.5	2.5	4.0					
Ignition Harness	3.0	3.0	3.0	3.0	4.0					
Turbocharger	5.5	5.5	5.5	5.5	12.0					

* Add 1 hour hot prop.

GTSIO-520 (cont'd.)

	Cessna 421B	Cessna 421C	Cessna 404	Cessna 411 or Beagle	Rockwell 685					
Waste Gate					1.0					
Air Cond. Comp. Mount										
Air Cond. Belt										
Air Cond. Sheave										

IO-550 SERIES

	Beech 58	Beech 36							
Engine Change	29.0	29.0							
Complete Top Overhaul	37.0	37.0							
First Cylinder Change	6.0	6.0 *							
Starter Adapter	4.0	4.0							
Starter	1.0	1.0							
Throttle & Controller	4.0	1.5							
Fuel Metering	2.0	1.5							
Complete Fuel Injection	9.0	5.0							
Fuel Pump	3.0	2.0							
Fuel Discharge Nozzle	.3 ea.	.3 ea.							
Fuel Distributor Valve	.8	.8							
Accessory Drive Housing	1.0	1.0							
Crankshaft Oil Seal	3.0 **	3.0 **							
Oil Cooler	3.0	3.0							
Oil Pump	4.0	4.0							
Oil Sump	4.0	15.0							
Alternator	2.0	2.0							
Magneto	1.5	1.5							
Ignition Harness	3.0	3.0							
Air Cond. Comp. Mount		4.0							

* No. 6 cylinder add 2 hours.

** Add 1 hour hot prop.

IO-550 (cont'd.)

	Beech 58	Beech 36							
Air Cond. Belt		2.0							
Air Cond. Sheave	2.0								

6-285

PA 36-285

Engine Change	32.0									
Complete Top Overhaul	36.0									
First Cylinder Change	6.0									
Starter Adapter										
Starter	1.5									
Throttle & Controller										
Fuel Metering	3.0									
Complete Fuel Injection	10.0									
Fuel Pump	4.0									
Fuel Discharge Nozzle	.3									
Fuel Distributor Valve	1.0									
Accessory Drive Housing										
Crankshaft Oil Seal	3.0									
Oil Cooler										
Oil Pump	3.5									
Oil Sump	8.0									
Alternator	1.0									
Magneto	1.5									
Ignition Harness	2.5									

 **TELEDYNE CONTINENTAL MOTORS**
Aircraft Products Division

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