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TRANSMISSION PARTS

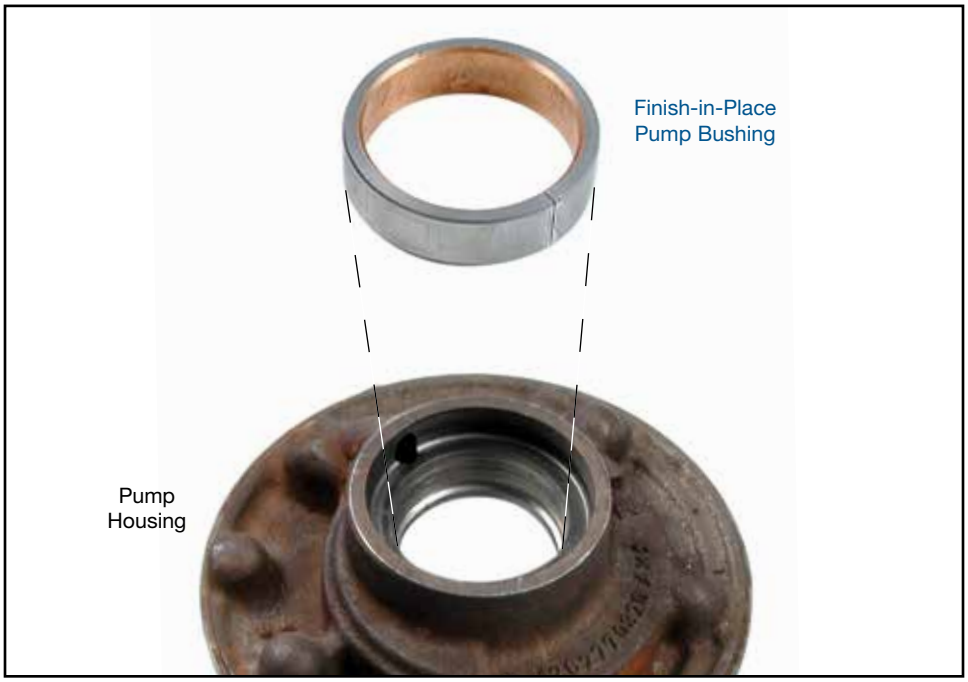
Instructions

Mercedes 722.3, 722.5, 722.6

Oversized Finish-in-Place Pump Bushing

Part No.
68004-02

NOTE: Machining required.



NOTE: This bushing is designed for damaged pump housings. The pump bore must be machined prior to installing Sonnax bushing. After bushing installation, bushing ID must be machined to set the desired clearance with the converter hub.

1. Remove and discard OE bushing.
2. Machine pump housing bore ID to 2.0000” +/- .0005” (Ø50.800mm +/- 0.013mm).
3. The post-machining surface finish of the pump housing bore must be Ra60 – Ra125.
4. Install Sonnax bushing.
5. ID of Sonnax bushing must be machined in place. The surface finish should be Ra30 or better. Recommended diametric clearance is .002"–.005". Measure OD of the mating converter hub, add .002"–.005", machine the ID of installed bushing to the calculated dimension.

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