sonnax®

TORQUE CONVERTER PARTS

Instructions

Mercedes 722.6, 722.9

Bushing

Part No.
MB-B-1

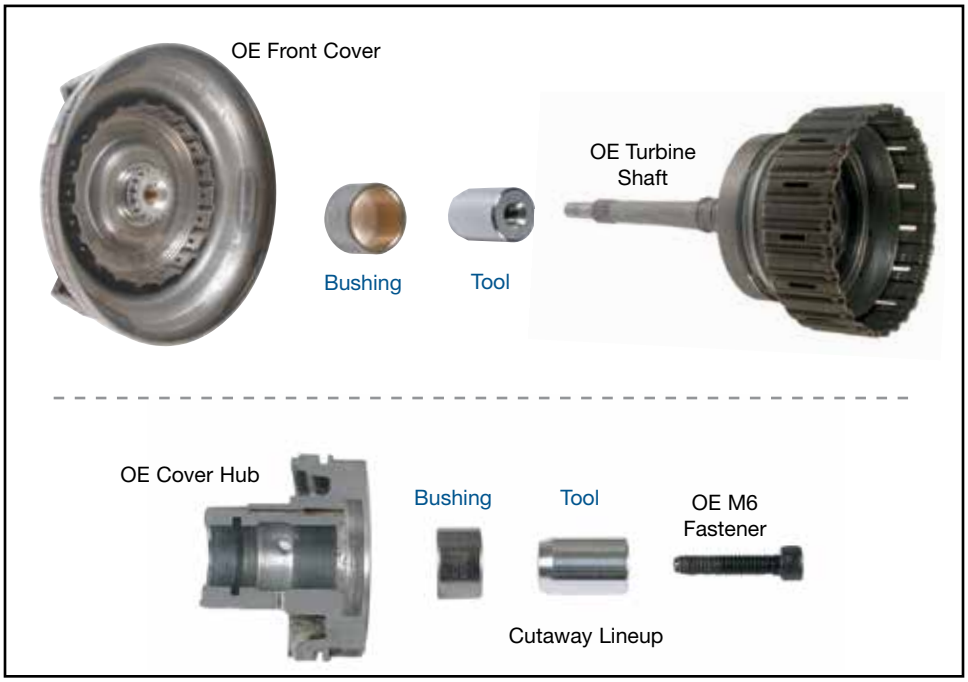
NOTE: Used for OE front cover hub repair only. Standard quantity 5/bag

Tool

Part No.
MB-B-1T

Debris Barrier

Associated Part
MB-O-5V Seal Ring



1. Inspect the front cover/pilot insert to determine if the pilot insert is loose.

NOTE: Do not proceed if there is any perceptible movement of the pilot within the cover. Obtain a different front cover if there is any suspicion that the pilot insert is loose.

2. Be sure that a functional seal ring (Sonnax **MB-O-5V**) is installed in the pilot I.D. groove.
3. Chuck the front cover up on a lathe. The front cover pilot O.D. should be checked to run true.
4. Insert tool **MB-B-1T** into the pilot I.D. through the seal ring and push it to the end of the bore. During machining, the installed tool and seal ring will prevent chips from packing into the front cover under the pilot, where they are difficult to flush out.
5. Use TransJel™ (or similar product) to block the fluid passages within the pilot in order to reduce the amount of chips introduced into the passages during machining.
6. Machine the pilot I.D. to a diameter of .787–.788" with a depth of .500–.510".
7. Remove the front cover from the lathe.
8. Use suction or vacuum to remove the machine chips and TransJel from the pilot bore. Do not use pressurized air.
9. Remove tool **MB-B-1T** using an M6 fastener as a handle (**Figure 1**).
10. Thoroughly flush all debris from the pilot bore and lube passages. Repeat. Be sure all debris is removed and passages are open.
11. Use an arbor press and bushing arbor to install the **MB-B-1** bushing. When installed, the bushing must be flush or just below flush with the bottom of the pilot's counterbore.

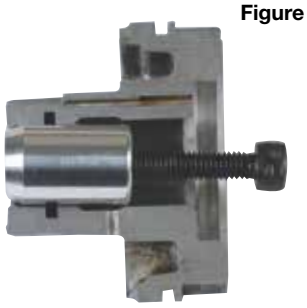


Figure 1

800-843-2600 • 802-463-9722 • F: 802-463-4059 • www.sonnax.com