

Ford 4R100, 4R70E, 4R70W, 5R110W, 4R75E, 4R75W, AOD, AODE, C6, E40D

Pump Bushing

Part No.

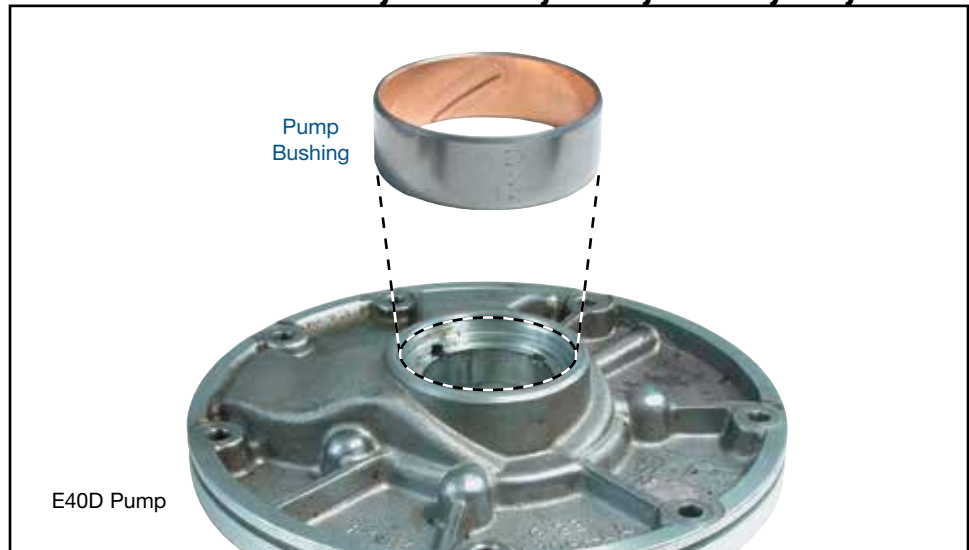
36002-01



NOTE: This is a finish-in-place bushing; precision I.D. machining is required after installation.

Required Tooling:

- Arbor press
- Shouldered arbor
- Lathe w/3-jaw chuck, 11.0" dia. capacity
- Magnetic indicator stand
- One-tenth indicator
- Carbide-tipped boring bar
- Go/No Go plug gauge
(Go dia. 1.9982" / No Go dia. 1.9992")



1. Disassembly

- Remove seal from housing.
- Use an arbor press and shouldered arbor to remove OE bushing from the pump housing.

2. Assembly

- Use arbor press and shouldered arbor to install Sonnax bushing to the proper depth of .020-.060" below housing shoulder.



NOTE: Make sure oil groove entrance in bushing is on pump gear side of housing.

- Clamp on large O.D., being careful not to mark the surface, and indicate the I.D. of the seal bore where the seal is pressed into. This must run within .0005" T.I.R.



NOTE: Pump housing should be clamped on large diameter where O-ring seal groove is located. This diameter runs true with the I.D. where the bushing is pressed.

- Bore the bushing I.D. to a size of 1.998-1.999". Surface finish must be 16-32 micro-inch (μ in) or better.

