

## Bell Housing/Pump Cover Bushing



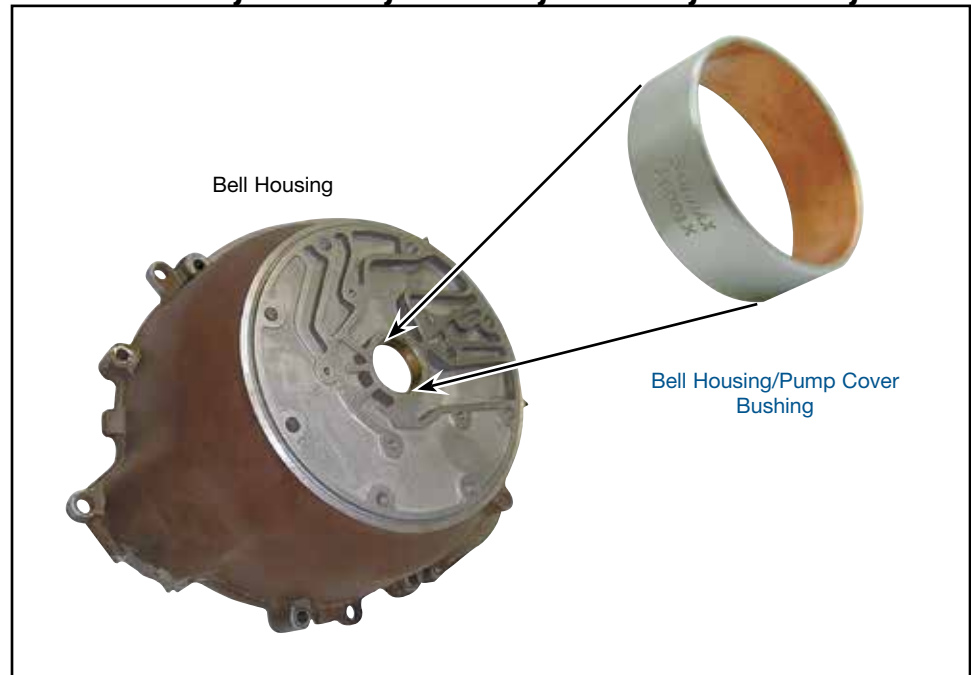
Part No.

**56001X**

Bushings (5)

**NOTE:** Finish-in-place style bushing requires advanced machining to ensure proper I.D. and location after installation.

## Ford 4R44E, 4R55E, 5R44E, 5R55E, 5R55N, 5R55S, 5R55W, A4LD



### A4LD, 4R/5R44E, 4R/5R55E Tooling Required

- Arbor press
- Oil seal puller
- Shouldered arbor
- Locating fixture
- Bridgeport-type milling machine
- Ring gauge, 41mm dia.
- Toe clamp set
- Two-inch precision boring head
- Carbide-tipped boring bar
- Bore gauge
- Indicol indicator holder
- Tenth reading test indicator
- Toe clamp set

### A4LD, 4R/5R44E, 4R/5R55E Bell Housing Instructions

1. Remove the oil seal with a puller, then use an arbor press and shouldered arbor to remove the OE bushing from the bell housing.
2. Use the arbor press and shouldered arbor to install the replacement bushing to proper depth.
3. Toe clamp the locating fixture (**Figure 1**) to the mill table. Using the tenth reading indicator, align the fixture pilot diameter within .0005" TIR to the mill spindle (**Figure 2**).
4. Place the bell housing or pump cover over the fixture so that the fixture pilot diameter engages the seal bore. Toe clamp the block mounting surface of the bell housing or pump cover to the mill table (**Figure 3**).
5. Bore the bushing I.D. to a size of 1.6142–1.6152". This requires a sharp carbide boring bar and a fine feed rate to achieve a desirable 32-microinch surface finish.

**NOTE:** To ensure stator-to-bell alignment, always use the factory-preferred pump alignment tool.

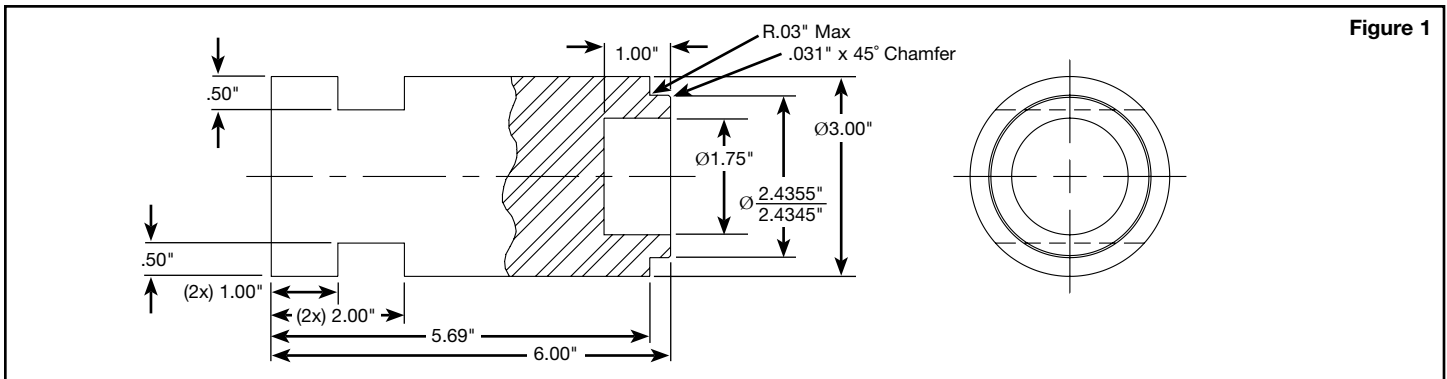


Figure 1

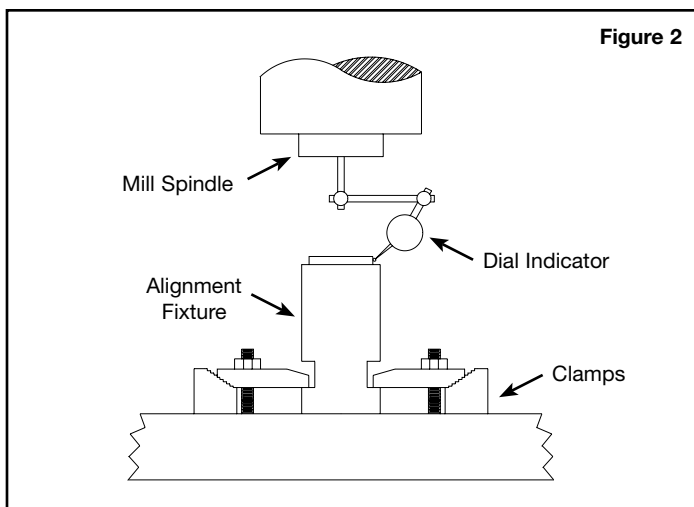


Figure 2

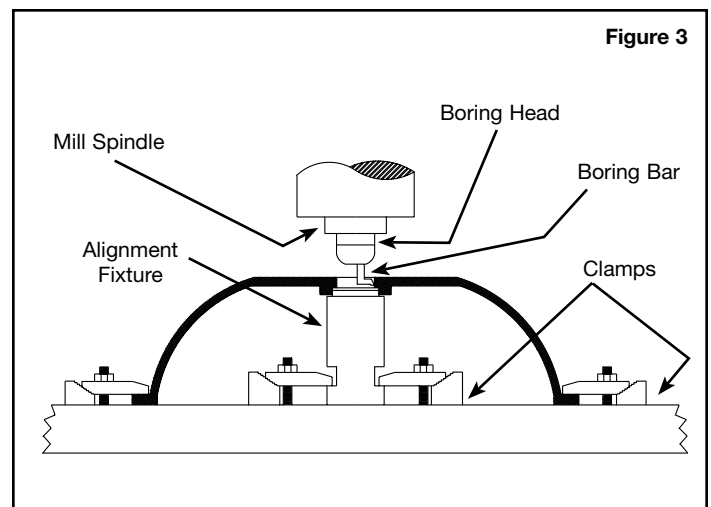


Figure 3

### 5R55N/W/S Tools Required

- Arbor press
- Oil seal puller
- Shouldered arbor
- Lathe with 4-jaw chuck
- Carbide-tipped boring bar
- Tenth reading indicator
- Bore gauge
- Ring gauge, 41mm dia.

### 5R55N/W/S Pump Cover Instructions

1. Remove the oil seal with a puller, then use an arbor press and shouldered arbor to remove the OE bushing from the pump cover.
2. Use the arbor press and shouldered arbor to install the replacement bushing to proper depth.
3. Clamp the outer diameter of the pump cover in a 4-jaw chuck. Using the tenth reading indicator, align the chuck to the bushing bore within .0005" TIR.

**NOTE:** Do not use a 3-jaw chuck. The O.D. of the pump cover to the I.D. of the pump bushing is not within the .005" TIR requirement.

4. Bore the bushing I.D. to a size of 1.6142–1.6152". This requires a sharp carbide boring bar and a fine feed rate to achieve a desirable 32-microinch surface finish.

**NOTE:** To ensure stator-to-pump alignment, always use the factory-preferred pump alignment tool.