

Shift Lever Case Bore Repair Sleeve

Part No.
22179-02



Tool Kit

Part No.
56361-TL

- Reamer
- Reamer Guide
- Reamer Guide Plate
- Reamer Alignment Bushing
- Screws (2) M8 x 20mm
- Screws (3) M6 x 20mm
- Screws (3) 5/16" x 3/4"
- Sleeve Installation Tool
- Clamp Bracket

NOTE: Follow instructions as this tool kit contains more parts than are required for Chrysler RWD installation.

Chrysler 42RE, 42RH, 46RE, 46RH, 47RE, 47RH, 48RE, A727, A904

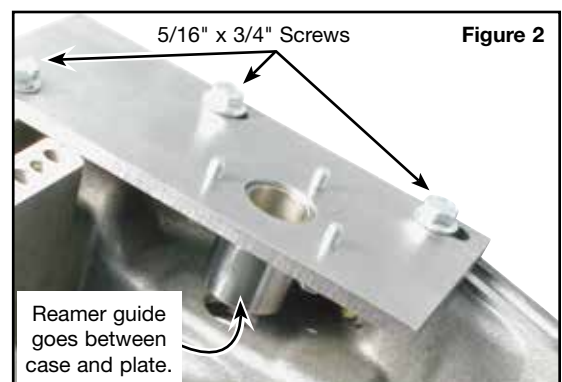
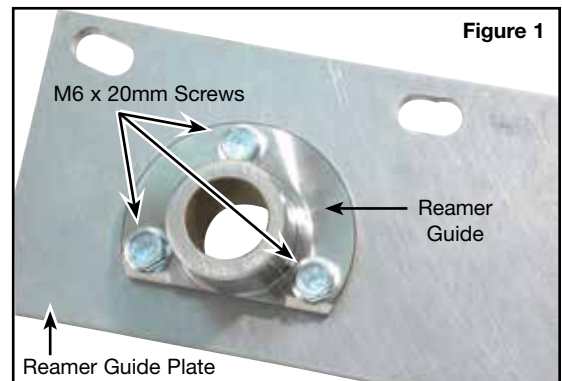


1. Disassembly

- a. Remove valve body and manual shaft seal from case.
- b. Clean seal bore and pan/valve body surface of case.
- c. Run a file across case pan gasket surface to make sure there are no nicks or burrs where the reamer guide plate attaches to case.

2. Reaming

- a. Attach Sonnax reamer guide to reamer guide plate with three (M6 x 20mm) screws (**Figure 1**). Ensure all three screw holes on the reamer guide line up, as the guide can only be attached to one side of the plate.
- b. With reamer guide located between case and plate, mount reamer guide plate to the case using three 5/16" x 3/4" screws, leaving them slightly loose for plate alignment (**Figure 2**).

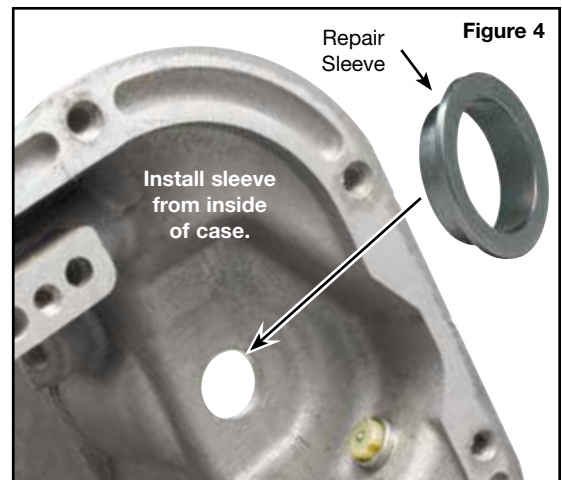
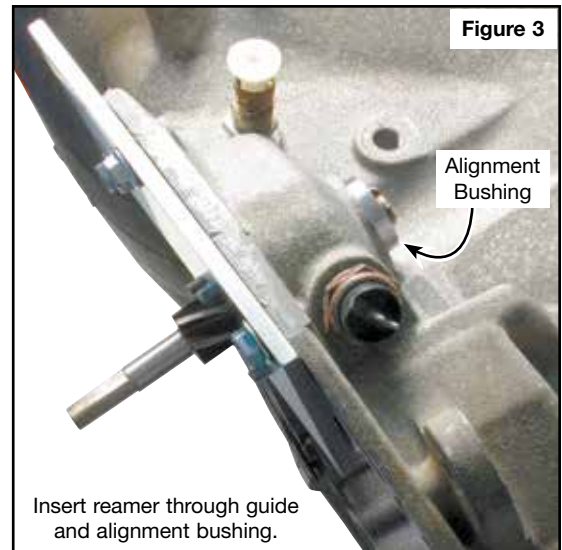


2. Reaming (continued)

- c. Place reamer alignment bushing into manual shaft seal bore in case (seal must be removed).
- d. Align reamer guide plate by inserting reamer through reamer guide and into alignment bushing (**Figure 3**). Tighten screws to secure reamer guide plate to the case. Ensure reamer rotates freely in alignment bushing.
- e. Remove alignment bushing from case.
- f. Ream hole with a low speed drill (approximately 250 RPM) and appropriate cutting fluid.

3. Installation & Assembly

- a. Coat Sonnax bore repair sleeve with Loctite® and install Sonnax repair sleeve from inside of case (**Figure 4**).
- b. Install new seal and valve body.
- c. Verify free rotation of shift linkage.



Ford 4R44E, 4R55E, 4R70E, 4R70W, 4R75E, 4R75W, 5R44E, 5R55E, A4LD, AOD, AODE

Shift Lever Case Bore Repair Sleeve

Part No.
56361-01K



- Repair Sleeve
- Retaining Pin 3mm
- Retaining Pin .125"

WARNING: Shift lever case bore repair sleeve is no longer in production. Check with your distributor for availability.

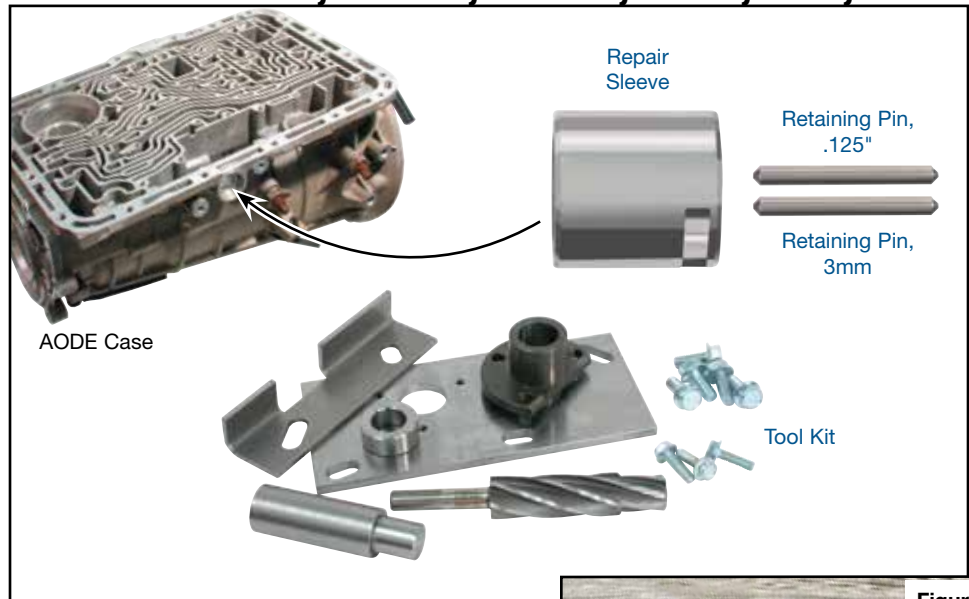
Tool Kit



Part No.
56361-TL

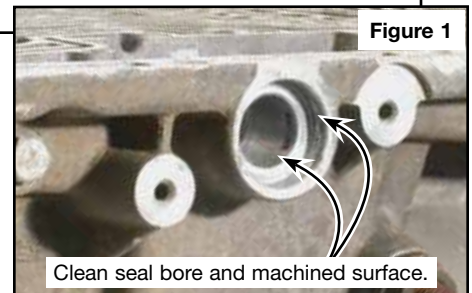
- Reamer
- Reamer Jig
- Reamer Guide Plate
- Reamer Alignment Bushing
- Screws (2) M8 x 20mm
- Screws (3) M6 x 20mm
- Screws (3) 5/16" x 3/4"
- Sleeve Installation Tool
- Clamp Bracket

NOTE: This tool kit can also be used to install shift lever case bore repair sleeve 22179-02 in all Chrysler RWD units.



1. Disassembly & Case Preparation

- Remove shift linkage retaining pin, manual shaft and seal.
- Clean seal bore and machined surface where reamer jig seats against case. Remove any nicks or burrs (**Figure 1**).



2. Tool Kit & Reaming

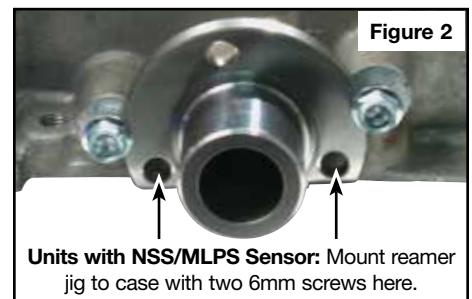
- Mount Sonnax reamer jig based on sensor:

• Units with NSS/MLPS Sensor:

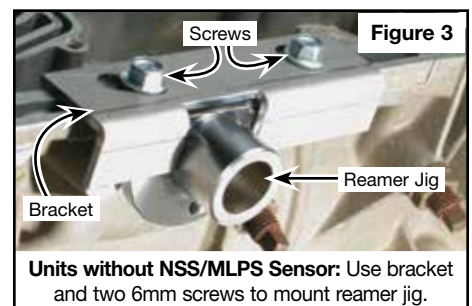
If case has NSS/MLPS mounting holes, mount reamer jig to case with two 6mm screws (**Figure 2**).

• Units without NSS/MLPS Sensor:

If case does NOT have NSS/MLPS mounting screw holes, then use bracket and two 8mm screws to mount reamer jig in place. With bracket tight, ensure reamer jig is flush to case and does not move (**Figure 3**).



- Using Sonnax piloted reamer in electric drill, ream out case bore. Run the reamer at approximately 250 RPM and slow feed rate.



NOTE: Use appropriate cutting fluid.

3. Installation & Assembly

- Before installing Sonnax sleeve, grind or file a small chamfer in the leading edge of the bore.
- Sonnax sleeve must be aligned with case pin slot. Identify orientation of retaining pin slot in case. Sonnax sleeve has a witness mark on one end to help with alignment (Figure 4).



NOTE: The pin hole is on a slight angle and is NOT perpendicular to the pan surface of the case (Figure 5).

- Use Sonnax sleeve installation tool to press sleeve into case until slot lines up with alignment pin hole.



NOTE: If necessary, redrill pin hole: 1/8" drill bit for .125" pin, #32 drill bit for 3mm pin.

- Measure retaining pin groove on OE manual shaft to determine proper Sonnax retaining pin replacement (Figure 6).
- Install replacement seal flush with case. Install manual shaft and appropriate size Sonnax retaining pin. Flare end of Sonnax retaining pin prior to installation or stake case around pin to secure pin to ensure it will not fall out of case (Figure 7).

