

## F-Clutch Bushing & Seal Kit

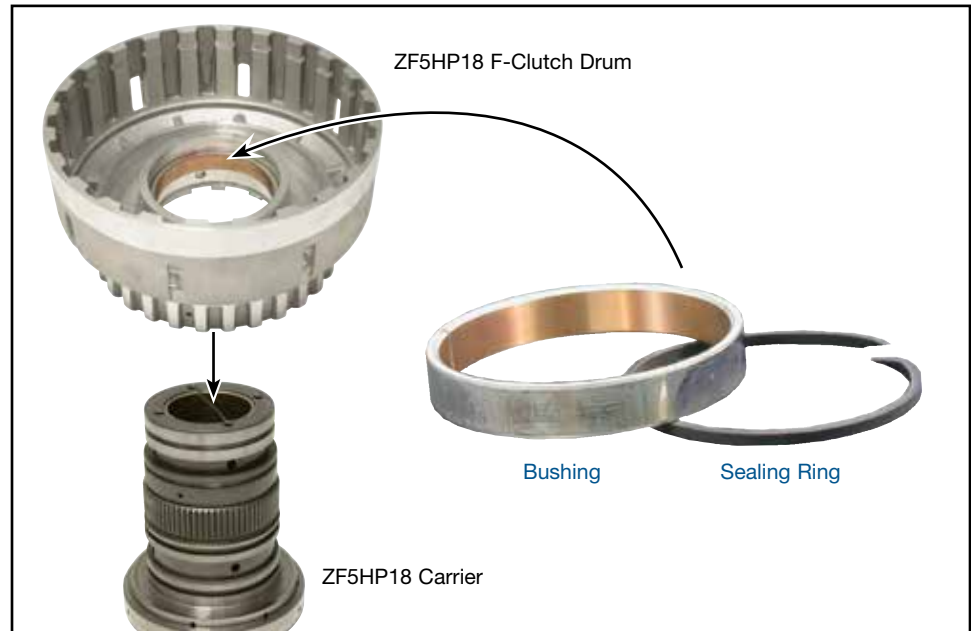
### Part No.

**85110-01K**

- Sealing Ring
- Bushing

**NOTE:** Fits all ZF5HP18 units and early bushing-style ZF5HP19 units.

## ZF5HP18, ZF5HP19



### 1. Disassembly

- Remove OE F-clutch drum and support shaft from transmission and clean thoroughly.
- Remove OE 3-tabbed bushing and ID O-ring from bottom side of the clutch drum (opposite end from the clutch plates and piston).
- Select a round piece of stock smaller than the I.D. of the clutch drum bore (so as not to damage the bore) and press the worn OE bushing out.  
**NOTE:** A properly sized bushing driver/arbor is recommended for installation and removal of bushing to prevent component damage.
- With OE clutch facing up, press the worn OE bushing down and out the bottom of the clutch drum.
- Remove OE shaft seal ring from the support shaft (this is the first ring down on the small end of the shaft).

### 2. Installation & Assembly

- With the clutch drum facing up, press Sonnax bushing into the clutch drum approximately .31" from the top of the hub/bore, using the same piece of round stock used to disassemble the bushing.
- Clean any burrs or chips from the bore of the clutch drum and bushing generated from the pressing operation.
- Install Sonnax shaft seal ring onto the shaft and apply a coat of Trans Jel™ to the outside of the seal ring to retain the seal to the shaft during assembly.
- Install a new O-ring into the I.D. groove in the bottom of the clutch drum bore and reassemble the 3-tabbed bushing.
- Reassemble the F-clutch drum and support shaft assemblies back in the transmission.