

Ford 6R80 (2009-2014), 6R80 (2015-Later); ZF6HP19, ZF6HP26, ZF6HP28

Input/Output Shaft Bushing

Part No.

95030-05

• Bushings (6)



NOTE: Fits units with .669" (16.98mm) dia. shaft journals only.

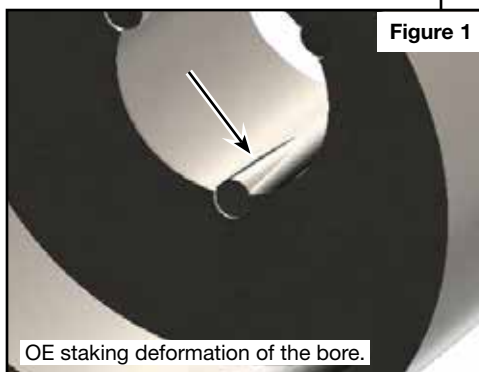
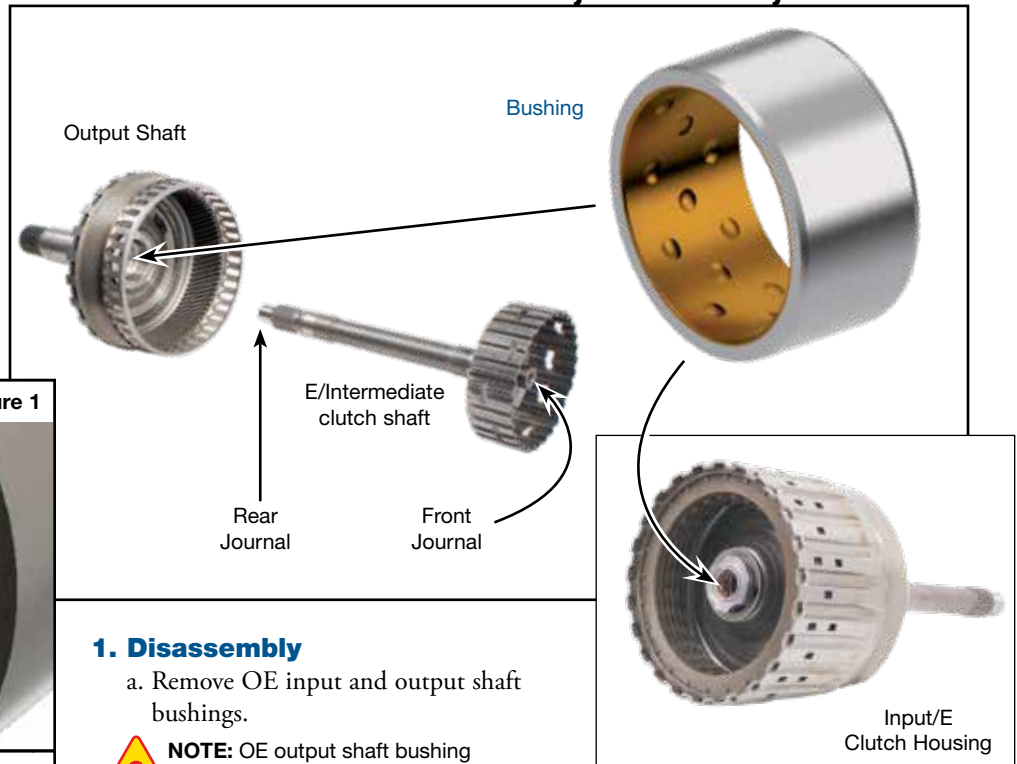


Figure 1

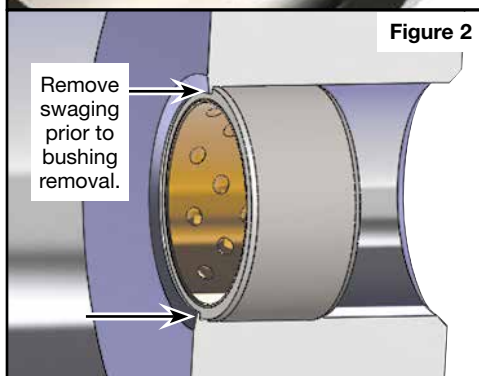


Figure 2



Figure 3

1. Disassembly

- Remove OE input and output shaft bushings.



NOTE: OE output shaft bushing is staked/coined in place. After bushing removal, internal staking deformation must be removed from the bore to prevent distortion of Sonnax bushing during installation (**Figure 1**).

A die grinder or lathe may be used to carefully remove these bore protrusions.

Some output shaft bushings are retained by a swaging operation (**Figure 2**). The swaging will need to be removed to allow bushing service.



CAUTION: Exercise care when using a puller to remove bushing, as it is possible to inadvertently cause grooving of the bore with the puller arms. These grooves can prevent the mating parts from fitting together properly.

2. Assembly



CAUTION: Use of an arbor press is required for correct installation. DO NOT use a hydraulic press or a bushing driver and hammer to install, as doing so will distort the bushing and cause fitment issues.

- Install Sonnax input and output shaft bushings flush with bottom of bore chamfer (**Figure 3**).
- After installation and fit-testing of Sonnax output shaft bushing, lightly stake bushing in place (**Figure 4**).



Figure 4