

## ZF6HP26, ZF6HP28

### Bushing Kit

#### Part No.

### 95030-26K

- Rear Stator Support Bushing (Small Shaft Version) 1.022" I.D.
- Rear Stator Support Bushing (Large Shaft Version) 1.180" I.D.
- "A" Drum Front Bushing 2.353" I.D.
- "A" Drum Rear Bushing 1.967" I.D.
- Input/Output Shaft Bushings (2) .669" I.D.
- Sun Gear Shaft Bushings (2) (Small Shaft Version) .952" I.D.
- Sun Gear Shaft Bushings (2) (Small Shaft Version) .991" I.D.
- "B" Clutch Bushings (2) 1.337" I.D.



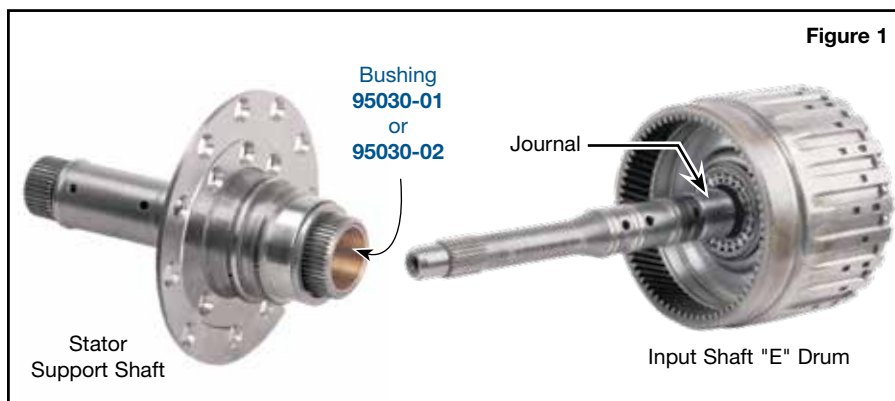
**NOTE:** See chart for bushing details.

**CAUTION:** Use of an arbor press is required for correct installation of all Sonnax bushings. Do not use a hydraulic press or a bushing driver/hammer to install, as doing so will distort the bushing and cause fitment issues.

**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.

### Bushing Kit Contents

95030-26K Bushing Kit Contents	Mating Shaft Dia. Journal	Quantity	Sonnax Part ID Number
Rear Stator Support Bushing	1.022" I.D. (25.97mm)	1	95030-01
Rear Stator Support Bushing	1.180" I.D. (29.96mm)	1	95030-02
"A" Drum Front Bushing	2.353" I.D. (59.77mm)	1	95030-03
"A" Drum Rear Bushing	1.967" I.D. (49.97mm)	1	95030-04
Input/Output Shaft Bushings	.669" I.D. (16.98mm)	2	95030-05
Sun Gear Shaft Bushings	.952" I.D. (24.17mm)	2	95030-06
Sun Gear Shaft Bushings	.991" I.D. (25.17mm)	2	95030-06A
"B" Clutch Bushings	1.337" I.D. (33.97mm)	2	95030-07



### 1. Rear Stator Support Bushing Installation

- Remove OE stator support bushing.
- Install Sonnax rear stator support bushing 95030-01 or 95030-02.

### 2. "A" Drum Front Bushing Installation

- a. Remove OE "A" drum front bushing.
- b. With chamfer side of Sonnax "A" drum front bushing **95030-03** facing outward, install bushing flush with bottom of bore chamfer (**Figure 2**).

### 3. "A" Drum Rear Bushing Installation

- a. Remove OE "A" drum rear bushing.
- b. Install Sonnax "A" drum rear bushing **95030-04** flush with bottom of bore chamfer (**Figure 2**).

### 4. Input/Output Shaft Bushing Installation

- a. Remove OE input and output shaft bushings (**Figure 3**).

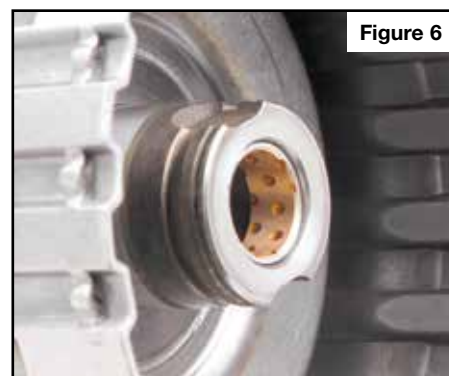
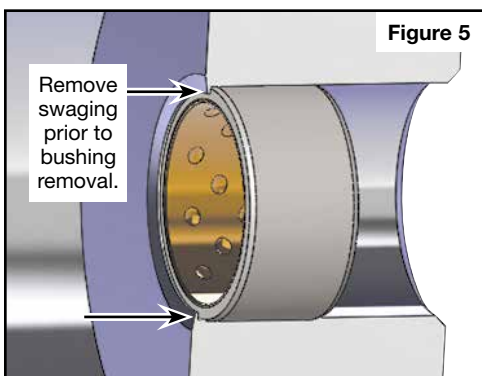
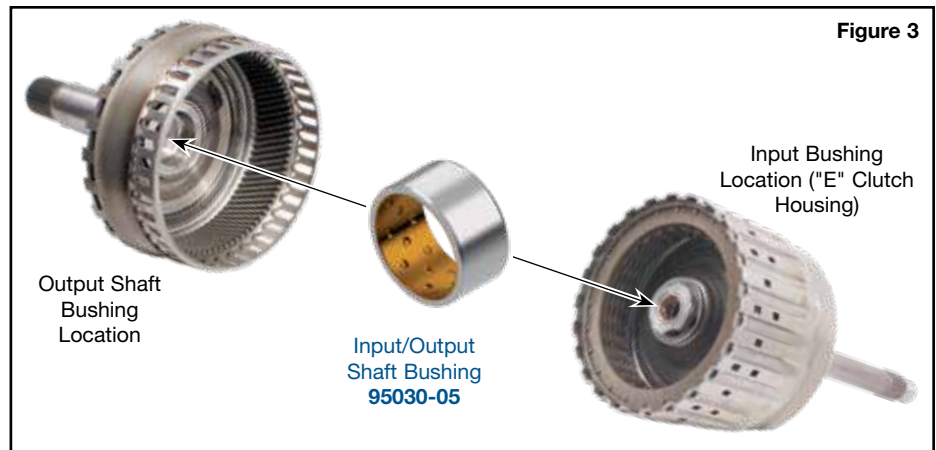
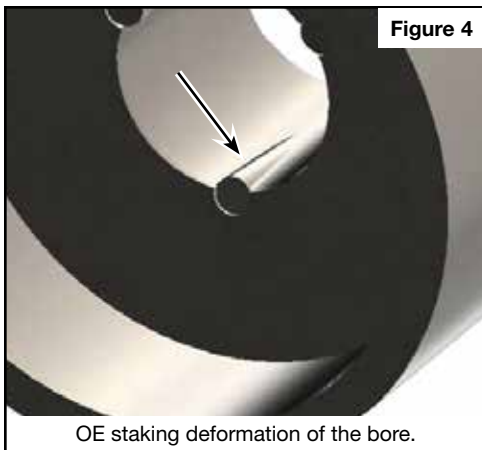


**NOTE:** OE output shaft bushing is staked/coined in place. Internal staking deformation must be removed from the bore to prevent distortion of Sonnax bushing during installation (**Figure 4**).

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 5**). The swaging will need to be removed to allow bushing service.

- b. Install Sonnax input and output shaft bushings **95030-05** flush with bottom of bore chamfer (**Figure 6**).
- c. After installation and fit-testing of Sonnax output shaft bushing, lightly stake bushing in place (**Figure 7**).



#### 5. Sun Gear Shaft Bushing Installation

- Note and record installation depth of OE bushings for reference during installation of Sonnax bushings.
- Remove OE sun gear shaft bushings (Figure 8).
- Install Sonnax bushings 95030-06 or 95030-06A to same depth of previously removed OE bushings (Figure 9).

#### 6. "B" Clutch Bushing Installation

- Remove both OE "B" clutch bushings (Figure 10).
- Install rear Sonnax bushing 95030-07 flush with bottom of bore chamfer (Figure 11).
- Install front Sonnax bushing 95030-07 to a depth of .125" below bearing surface (Figure 12).

