

## Aisin Seiki AS68RC

### Stator Shaft Kit

#### Part No.

# 99520-05K

- Stator Shaft Assembly Bearings Installed
- Coiled Spring Pins (2)

**NOTE:** Fits Dodge units only.

**NOTE:** Sonnax stator shaft must be used with OE input shaft 68284099AA, which can be identified by 1.585" journal where the rear stator bearing rides (**Figure 1**). If your AS68RC unit came with a shaft that measures 1.535" at this location, you must upgrade to OE shaft 68284099AA.

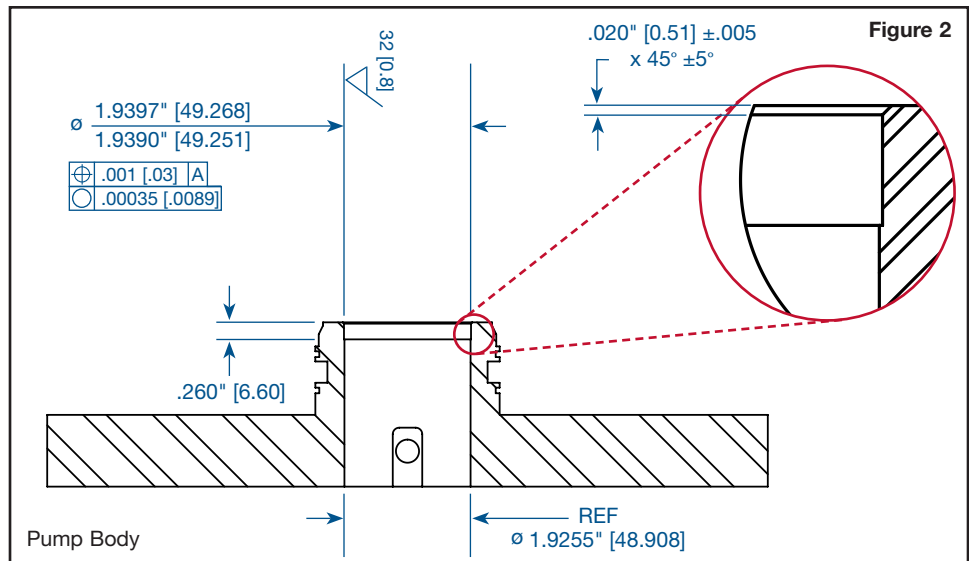
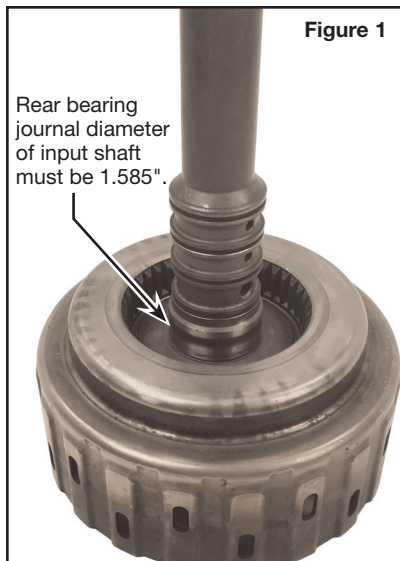


### 1. Disassembly

- Press OE stator shaft out of pump.
- Machine pump body to specification (**Figure 2**). The lower side of this tolerance is ideal.

**CAUTION:** Ensure qualified machinist is employed for this task, as machining errors may render the pump unusable.

- Clean pump body bore. Ensure all contaminants are removed from bore.



### 2. Installation & Assembly

- For the best cylindrical bond, apply Loctite 640® or equivalent to Sonnax stator shaft between the feed slots.
- Place Sonnax stator shaft into pump body, ensuring it is straight. Line up feed hole of pump body with 1.560" slot in stator (**Figure 3**).



**NOTE:** Alignment of feed hole to center of slot is critical. To prevent possible cross-leaks, recommend using an alignment fixture.

- Using arbor, press Sonnax stator shaft until it seats against pump face. This will take approximately 6–7 tons of force once the knurls begin to engage.
- Using holes in Sonnax stator shaft as pilots, drill to a depth of 1.2" from stator surface using a .125" bit (**Figure 4**).
- Flush and blow out drilled holes and install coiled spring pins. Pins must be slightly below flush of surface.

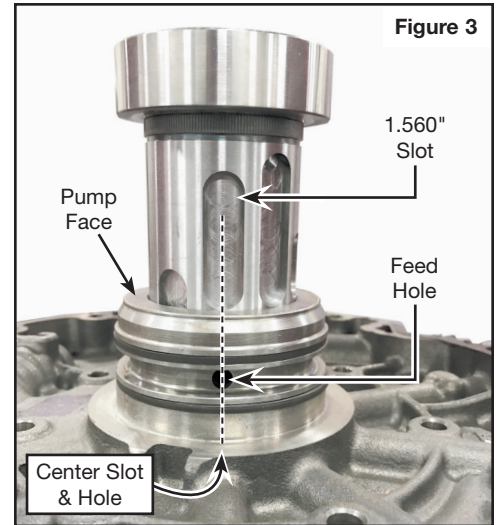


Figure 3

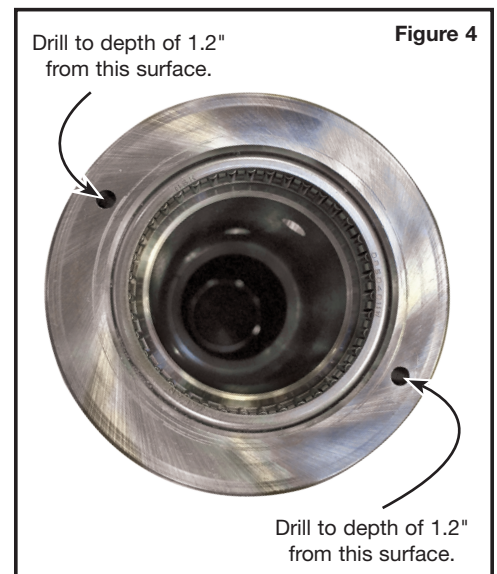


Figure 4