

Ford 10R80; GM 10L80 (Gen. 1 & 2)

CDF Drum Saver Kit

Part No.

129910-01K



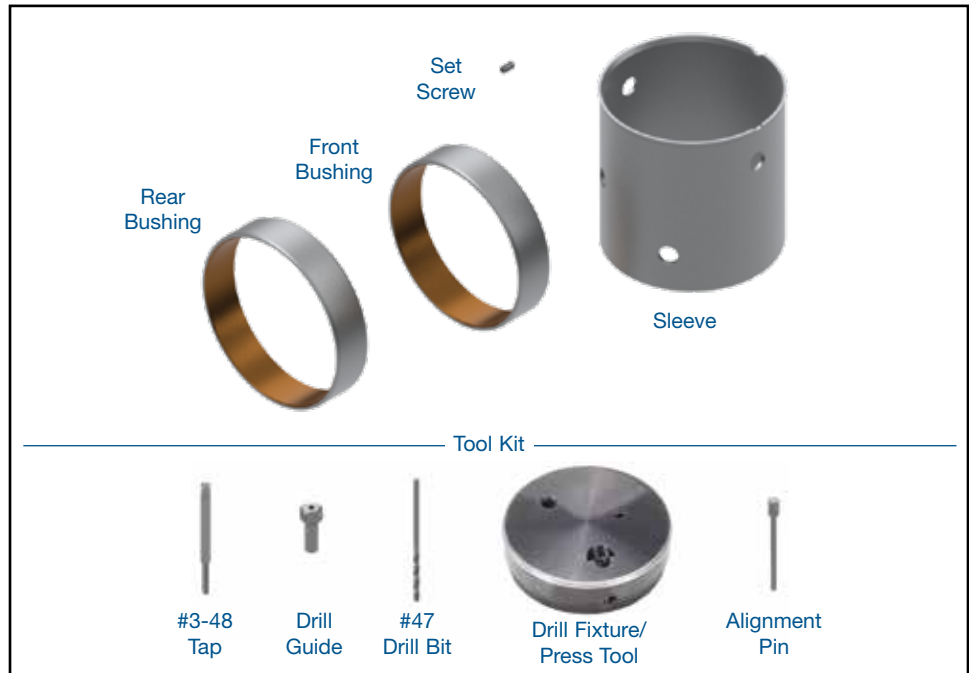
- Sleeve
- Set Screws (2) 1 Extra
- Front Bushing
- Rear Bushing

Tool Kit

Part No.

129910-TK

- #3-48 Tap
- Drill Guide
- #47 Drill
- Drill Fixture/Press Tool
- Alignment Pin



1. Disassembly

- Remove front and rear bushings.
- Press out the CDF drum sleeve.

NOTE: The sleeve has a very tight press fit. Heating the drum to 150–200°F will greatly aid sleeve removal.

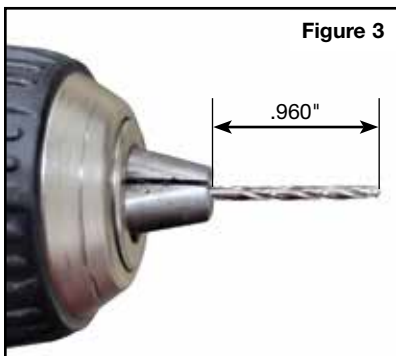
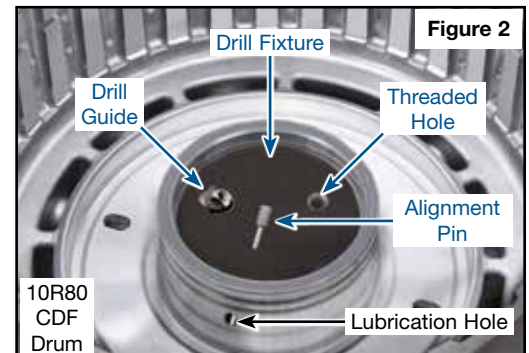
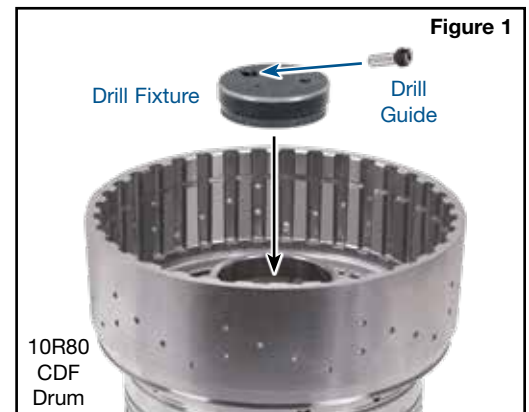
2. Bore Prep

NOTE: Sonnax tool kit 129910-TK is required.

- Press the Sonnax drill guide into the Sonnax drill fixture. Ensure it is fully inserted in the drill fixture (Figures 1 & 2).
- Place the drill fixture in the front bushing bore. Rotate the drill fixture until the alignment pin fits into the existing lubrication hole in the CDF drum (Figure 2).

NOTE: A 1/4-20 bolt can be threaded in the drill fixture to act as a handle.

- Using the #47 drill bit, set the drill bit length from tip of the drill chuck or drill stop to .960" (Figure 3).



2. Bore Prep (continued)

- d. Using the Sonnax drill guide, drill a hole in the CDF drum until the chuck/drill stop bottoms out on the drill guide (Figure 4).



NOTE: Drill depth is very important, as it is not desirable to drill all the way through the wall.

- e. Remove the drill fixture. Tap the bore with the Sonnax #3-48 tap.

3. Installation & Assembly

Sleeve

- a. Clean all debris out of the CDF sleeve bore. Inspect the bore for any damage, ensure there is no raised material in the bore. For ease of installation, pre-heat the CDF drum to 200 °F.
- b. Lubricate the outside diameter of the Sonnax sleeve to aid installation.
- c. Once the drum is heated, align the half moon on the bottom of the sleeve with the tapped bore on the CDF drum bore chamfer (Figure 5). Using an arbor press and the Sonnax drill fixture as a driver, press Sonnax sleeve fully into the CDF drum until the flange on the sleeve bottoms out in the drum.
- d. Verify Sonnax sleeve is fully pressed. Measure the distance from the top flange of the sleeve to the top of the center support (Figure 6). The measurement should be .663" (± .010").
- e. Using red Loctite®, install Sonnax set screw into the threaded hole at the top of the sleeve, bottoming out the set screw. Ensure the set screw sits below the surface of the sleeve.

Bushings

- a. Clean all debris out of the CDF front bushing bore. Inspect the bore for any damage, ensure there is no raised material in the bore.
- b. Using the correct size bushing driver, press in Sonnax front bushing 129910-01 using an arbor press, to a depth of .057" (Figure 7). Lubricate the outside diameter of the bushing to aid installation.
- c. Repeat steps A and B for the rear CDF drum bushing using Sonnax rear bushing 129910-02. Press the rear bushing to a depth of .194" (Figure 7).



Figure 4

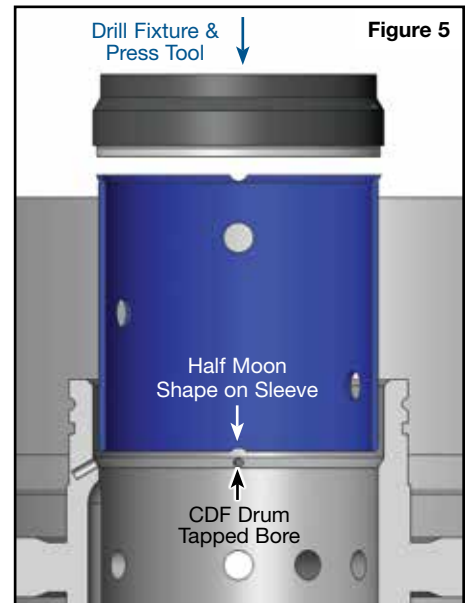


Figure 5

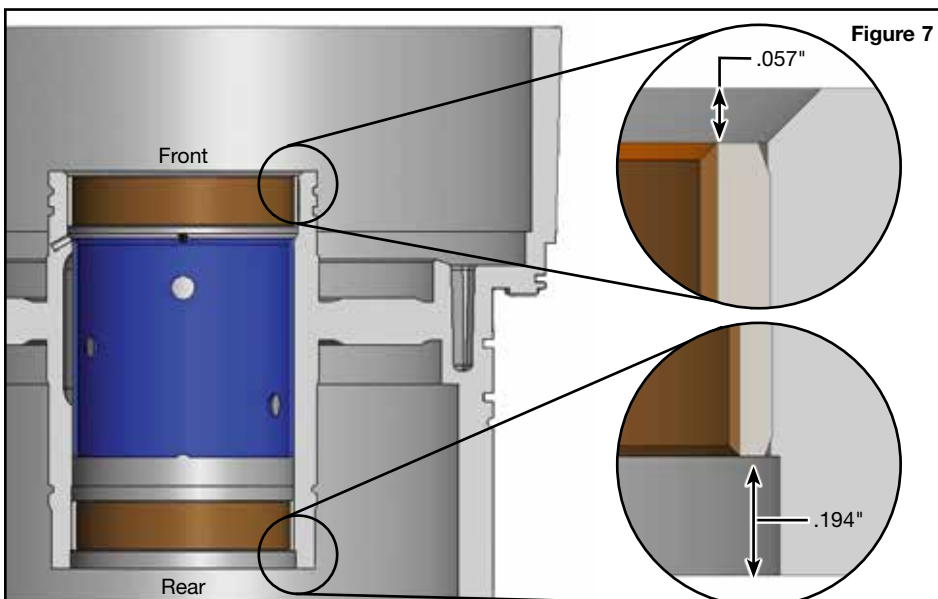


Figure 7

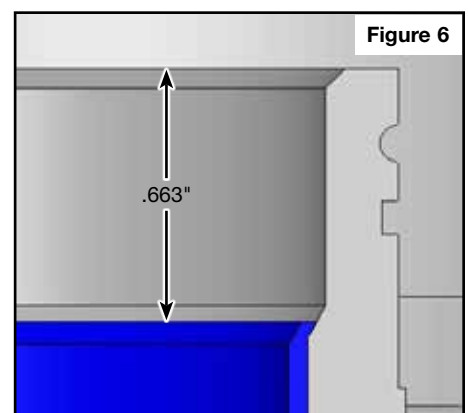


Figure 6