

Instructions

Ford E40D, 4R100

Rear Case Bushing



Fits '95–later. Late style - three grooves to front, one groove to back.

Bushing Installation Tool

Part No. T36008A

Also Available

Oversized Rear Case Bushing 36008C Fits '95-later.

Rear Case Bushing

36008B Fits C6 & E4OD '89-'94.



1. Disassembly

- a. Remove worn/damaged bushings from case.
- b. Remove any ridge or case material with a hone if bore I.D. is irregular or not center-machined.

2. Installation & Assembly

- a. Using high-speed cutting wheel, cut a notch into case (**Figure 1**).
- b. Mark the case where the lube hole is bored to assist with proper bushing alignment (**Figure 2**).
- c. Mark Sonnax bushing for proper alignment with lube hole (**Figure 3**).
- d. Apply bearing sealer such as Loctite[®] 609 or equivalent to case bore.
- e. Align lubrication hole on Sonnax bushing with lube hole in case (**Figure 4**).





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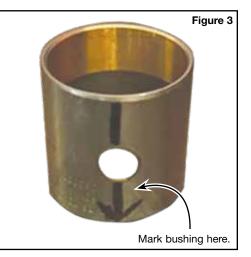
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36008D-IN 08-24-18



2. Installation & Assembly (continued)

- f. It is important to use Sonnax installation tool **T36008A** to prevent deformation of the long, thin-walled bushing (**Figure 5**). In addition, the tool shoulder is designed to seat bushing at the proper depth. Install Sonnax bushing with grooves toward front of case.
- g. Stake bushing in place at notch (Figure 6).
- h. Confirm lubrication holes are properly lined up and that acceptable clearance has been maintained between bushing and output shaft.



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