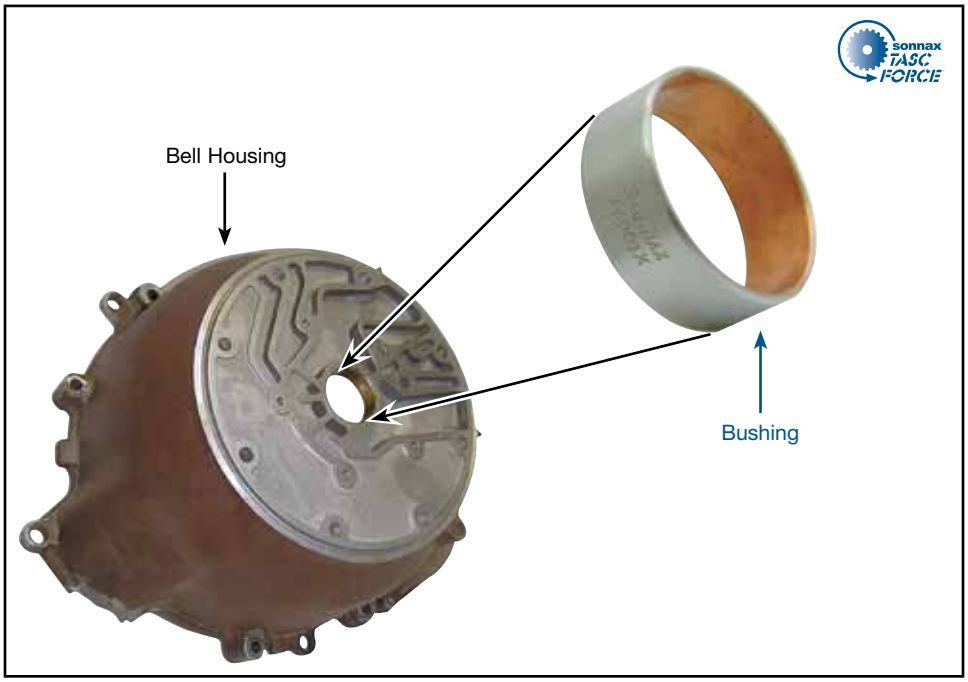
Ford A4LD, 4R44E/55E, 5R44E/55E, 5R55N/W/S

Bell Housing or Pump Cover Bushing

Part No.
56001X

Bushings (5)

NOTE: Finish-in-place style bushing requires advanced machining skills to ensure proper I.D. and location after installation.



A4LD, 4R/5R44E, 4R/5R55E Bell Housing Instructions

Tooling Required:

- Arbor press
- Locating fixture
- Toe clamp set
- Bore gauge
- Toe clamp set
- Oil seal puller
- Bridgeport-type milling machine
- Two-inch precision boring head
- Indicol indicator holder
- Shouldered arbor
- Ring gauge, 41mm dia.
- Carbide-tipped boring bar
- Tenth reading test indicator

1. Remove the oil seal with a puller, then use an arbor press and shouldered arbor to remove the OE bushing from the bell housing.
2. Use the arbor press and shouldered arbor to install the replacement bushing to proper depth.
3. Toe clamp the locating fixture (**Figure 1**) to the mill table. Using the tenth reading indicator, align the fixture pilot diameter within .0005" TIR to the mill spindle (**Figure 2**).
4. Place the bell housing or pump cover over the fixture so that the fixture pilot diameter engages the seal bore. Toe clamp the block mounting surface of the bell housing or pump cover to the mill table (**Figure 3**).
5. Bore the bushing I.D. to a size of 1.6142"–1.6152". This requires a sharp carbide boring bar and a fine feed rate to achieve a desirable 32-microinch surface finish.

NOTE: To ensure stator-to-bell alignment, always use the factory-preferred pump alignment tool.

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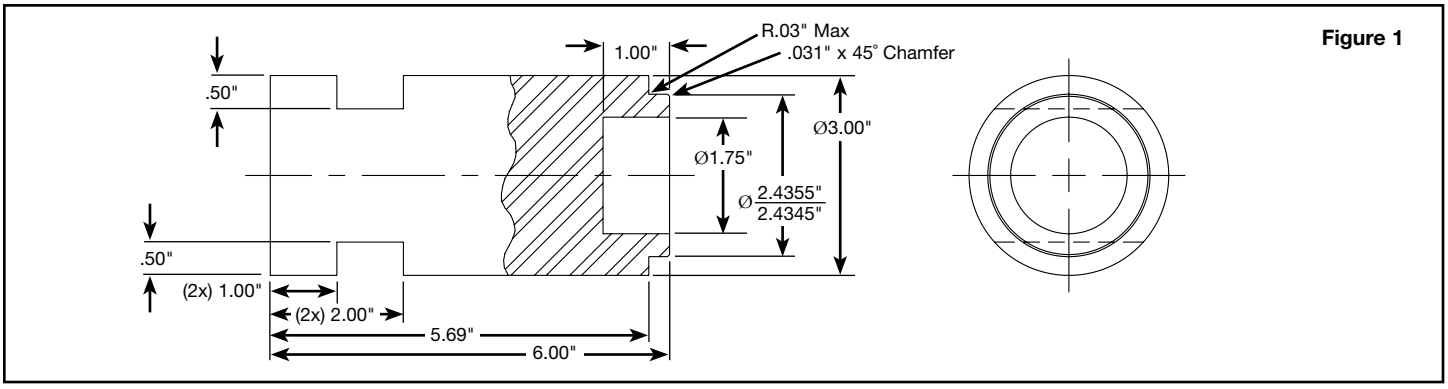

Figure 1

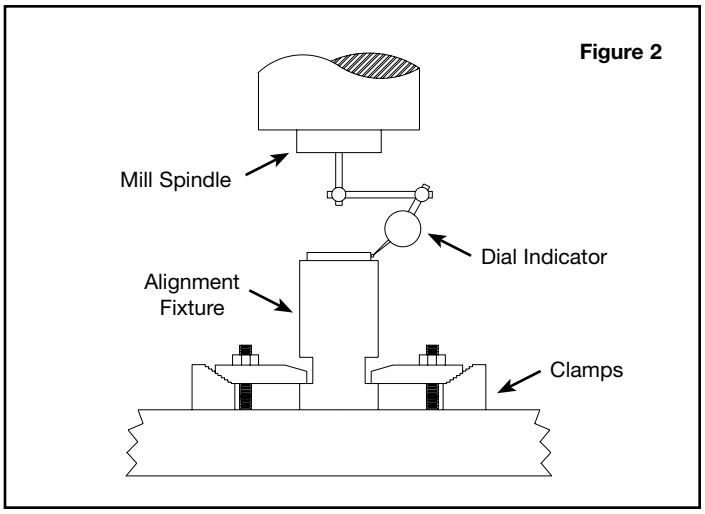

Figure 2

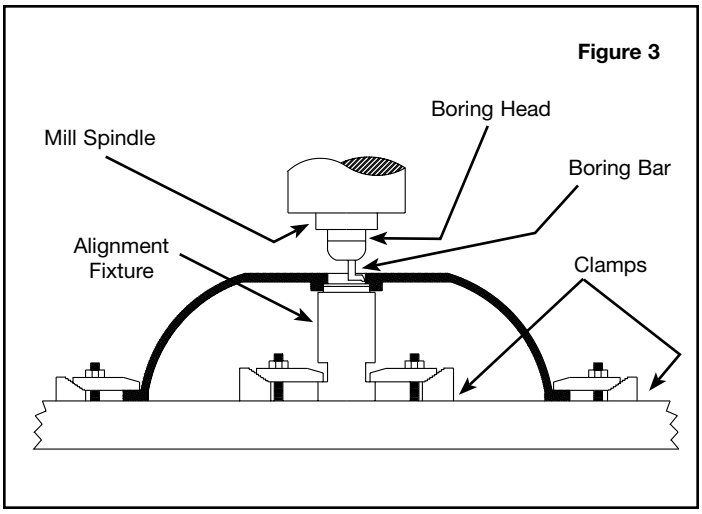

Figure 3

5R55N/W/S Pump Instructions

Tooling Required:

- Arbor press
- Lathe with 4-jaw chuck
- Bore gauge
- Oil seal puller
- Carbide-tipped boring bar
- Ring gauge, 41mm dia.
- Shouldered arbor
- Tenth reading indicator

1. Remove the oil seal with a puller, then use an arbor press and shouldered arbor to remove the OE bushing from the pump cover.
2. Use the arbor press and shouldered arbor to install the replacement bushing to proper depth.
3. Clamp the outer diameter of the pump cover in a 4-jaw chuck. Using the tenth reading indicator, align the chuck to the bushing bore within .0005" TIR.

NOTE: Do not use a 3-jaw chuck. The O.D. of the pump cover to the I.D. of the pump bushing is not within the .005" TIR requirement.

4. Bore the bushing I.D. to a size of 1.6142"–1.6152". This requires a sharp carbide boring bar and a fine feed rate to achieve a desirable 32-microinch surface finish.

NOTE: To ensure stator-to-pump alignment, always use the factory-preferred pump alignment tool.

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