

Manual Shaft/Case Repair Sleeve

56361-01K

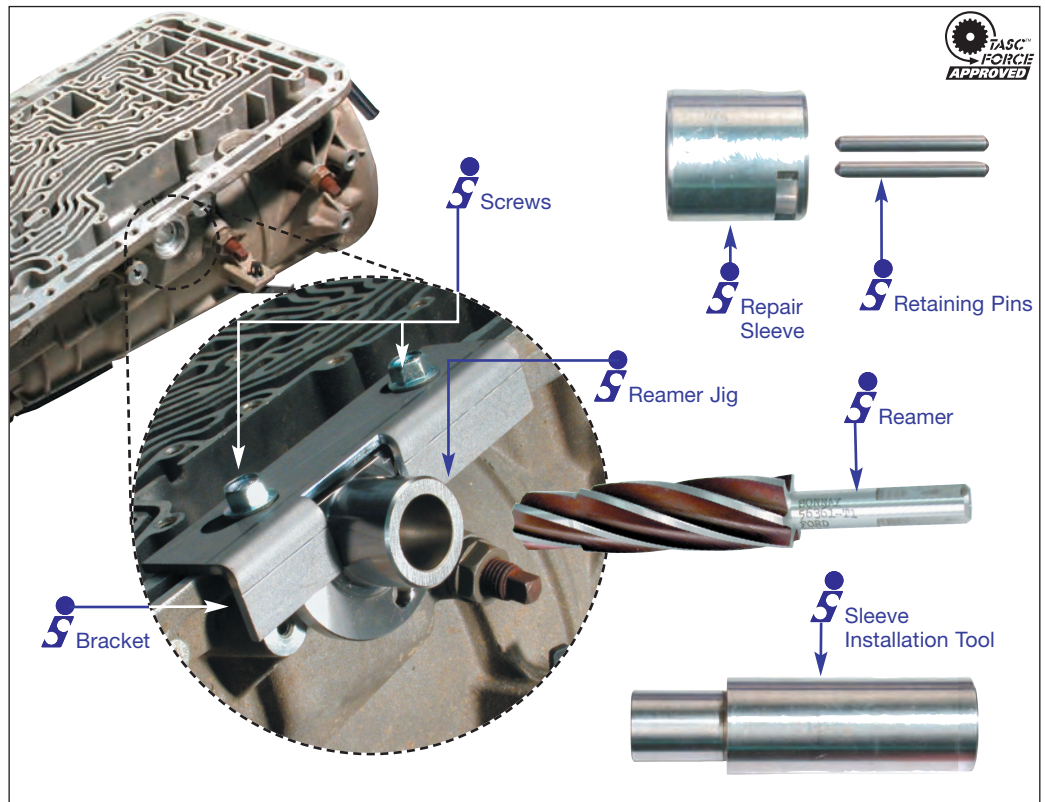
- 1 Repair Sleeve
- 1 Retaining Pin (3mm)
- 1 Retaining Pin (.125")



56361-TL

- 1 Reamer
- 1 Reamer Jig
- 1 Reamer Alignment Bushing
- 1 Plate
- 8 Flanged Hex Head Cap Screws
- 1 Sleeve Installation Tool
- 1 Clamp Bracket

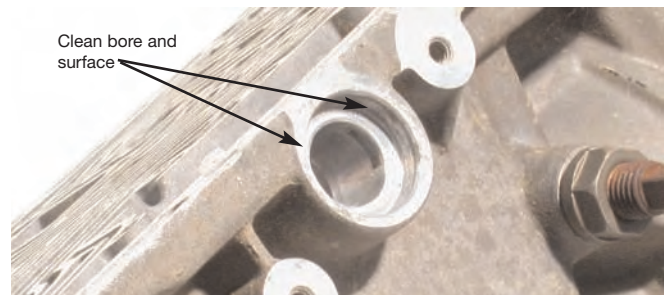
Note: Tool kit also works with Chrysler manual shaft sleeve 22179-02.



Instructions:

1. Remove shift linkage retaining pin, manual shaft and seal.
2. Clean seal bore and machined surface where reamer jig seats against case. Remove any nicks or burrs.
3. Mount the reamer jig.
For units with NSS/MLPS sensor, use step 3A below.
For units without NSS/MLPS sensor, use step 3B below.

Case Preparation



Units with NSS/MLPS Sensor



3A) If case has NSS/MLPS mounting holes, mount the reamer jig to the case with two 6mm screws (see photo with NSS/MLPS mounting holes).

Units without NSS/MLPS Sensor



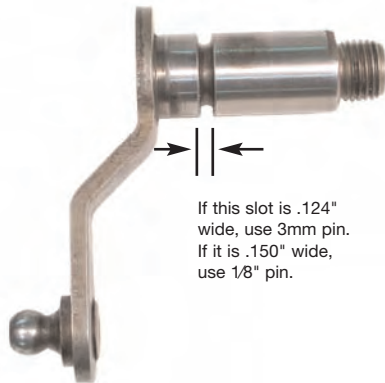
3B) If case does NOT have NSS/MLPS mounting screw holes, then use bracket and two 8mm screws to mount the reamer jig in place. With bracket tight, make sure reamer jig is flush to case and does not move.

Instructions Continued:

4. Using the piloted reamer in a electric drill, ream out the case bore. Run the reamer at approximately 250 RPM and slow feed rate. Use appropriate cutting fluid.
5. Before installing bushing, grind or file a small chamfer in the leading edge of the bore.
6. The bushing must be aligned with the case pin slot. Identify the orientation of the retaining pin slot in the case. The bushing has a witness mark on one end to help with alignment.

NOTE: The pin hole is on a slight angle and is NOT perpendicular to the pan surface of the case.

7. Use sleeve installation tool to press sleeve into case until slot lines up with alignment pin hole. If necessary redrill pin hole: $\frac{1}{8}$ inch drill bit for $\frac{1}{8}$ inch pin, # 32 drill bit for 3mm/.118 inch pin.
8. Measure the retaining pin groove on the manual shaft to determine the proper retaining pin. See picture to the left.



9. Install replacement seal flush with the case. Install manual shaft and appropriate size retaining pin. Flare end of pin prior to installation or stake case around pin to secure pin and ensure it will not fall out of case.

Bushing Alignment

