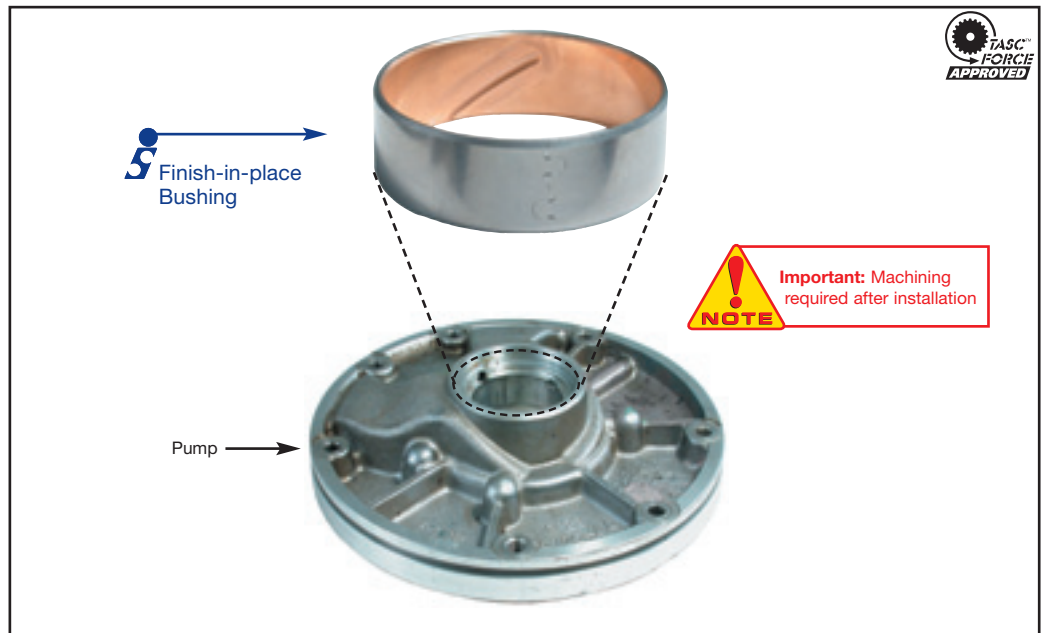


## Finish-In-Place Pump Bushing

**36002-01**

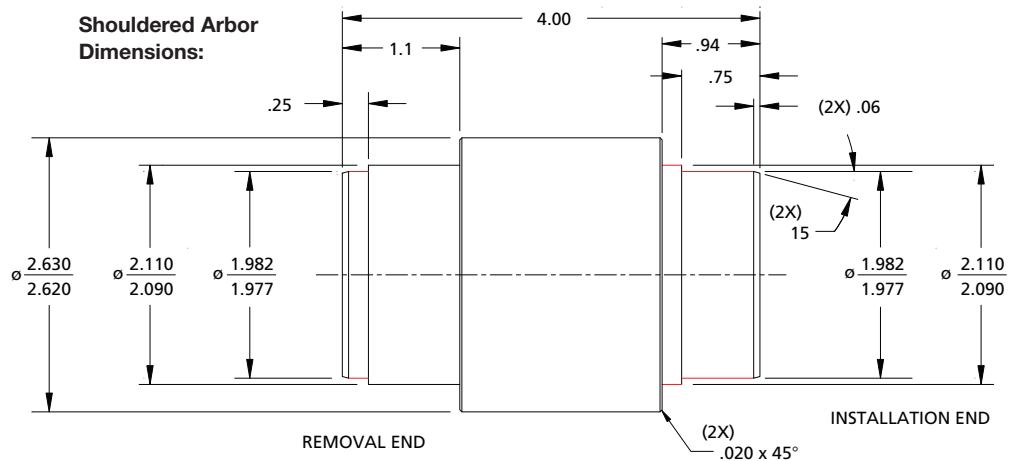
## 1 Front Pump Bushing



## Machining and Installation Instruction

### Tooling Required:

Arbor press, shouldered arbor, lathe with a 3-jaw chuck that will open up to 11.0" in diameter, magnetic indicator stand, one tenth indicator, carbide tipped boring bar, and a Go/No Go plug gauge (Go Diameter 1.9982" / No Go Diameter 1.9992")



### Procedure:

1. Remove seal from housing.
2. Use an arbor press and shouldered arbor to remove the OEM bushing from the pump housing.
3. Use the arbor press and shouldered arbor to install the replacement bushing to the proper depth, .020-.060 below housing shoulder.

**Note:** Make sure the oil groove entrance in the bushing is on the pump gear side of the housing.

4. Clamp on large O.D., being careful not to mark the surface, and indicate the I.D. of the seal bore where the seal is pressed into. This must run within .0005" T.I.R.

**Note:** All pump housings (E4OD, AOD&E, C6) should be clamped on the large diameter where the o-ring seal is. This diameter runs true with the I.D. where the bushing is pressed.

5. Bore the bushing I.D. to a size of 1.998"/1.999", finish should be 16 to 32 microinch surface finish or better.