

Shift Fork Guide Roller Repair Kit

100329-01K

- 1 Roller
- 1 Roller Shaft
- 1 Push-on Retainer



Instructions

Disassembly of the OEM Shift Fork Guide Roller:

1. Using a cut-off tool, cut the roller shaft outboard of the roller (*see Figure 1*).
2. Remove the roller from the shift fork.
3. Cut the roller shaft a second time close to the shift fork (*see Figure 1*).
4. Grind the remaining stub of the OEM roller shaft flush with the aluminum of the shift fork. Minimize grinding of the shift fork's aluminum material (*see Figure 2*).
5. Press what remains of the OEM roller shaft out of the shift fork toward the fork side (*see Figure 1*).

WARNING: If the roller shaft is pressed out toward the roller side of the shift fork, it will distort the bore and the new replacement roller shaft will not fit.

6. Remove any sharp edges or burrs created during the disassembly of the shift fork roller.

Installing Sonnax Guide Roller Shaft & Guide Roller

1. Identify the counterbored end of the guide roller and insert the roller guide shaft end through the counterbore first. The counterbore must face away from the shift fork when installed.
2. Start the shaft end into the shift fork bore.
3. Press the shaft fully into the shift fork.
4. Ensure the roller rotates freely after the shaft is fully seated into the shift fork.
5. Press the push-on circular retainer over the exposed roller shaft at the fork side.

