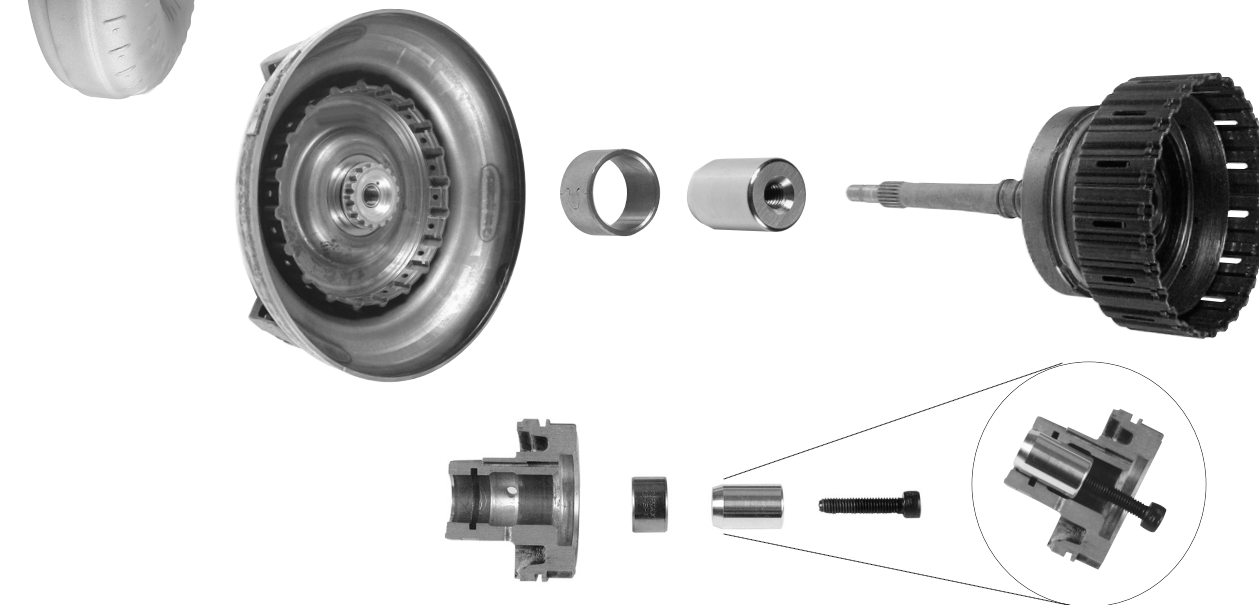


TORQUE CONVERTER PARTS

MB-B-1 & MB-B-1T

PILOT BUSHING & INSTALLATION TOOL



INSTALLATION INSTRUCTIONS

1. Inspect the front cover/pilot insert to determine if the pilot insert is loose. Do not proceed if there is any perceptible movement of the pilot within the cover. Obtain a different front cover if there is any suspicion that the pilot insert is loose.
2. Be sure that a functional seal ring (Sonnax **MB-O-3V**) is installed in the pilot I.D. groove.
3. Chuck the front cover up on a lathe. The front cover pilot OD should be checked to run true.
4. Insert pin **MB-B-1T** into the pilot ID through the seal ring and push it to the end of the bore. During machining the installed pin and seal ring will prevent chips from packing into the front cover under the pilot, where they are difficult to flush out.
5. Use Transgel™ (or similar product) to block the fluid passages within the pilot in order to reduce the amount of chips introduced into the passages during machining.
6. Machine the pilot ID to a diameter of 19.98mm/20.00mm (.787"/.788") with a depth of 12.70mm/12.95mm (.500"/.510").
7. Remove the front cover from the lathe.
8. Use suction or vacuum to remove the machine chips and Transgel™ from the pilot bore. Do not use pressurized air.
9. Remove pin **MB-B-1T** using an M6 fastener as a handle.
10. Thoroughly flush all debris from the pilot bore and lube passages.
11. Repeat step 10. Be sure all debris is removed and passages are open.
12. Use an arbor press and bushing arbor to install the **MB-B-1** bushing. When installed, the bushing must be flush or just below flush with the bottom of the pilot's counterbore.