

Part No.

41005-01

1 Pump Bushing

Fits F4A/5A 40 & 50 series

pumps only



Part No.

41005-TL

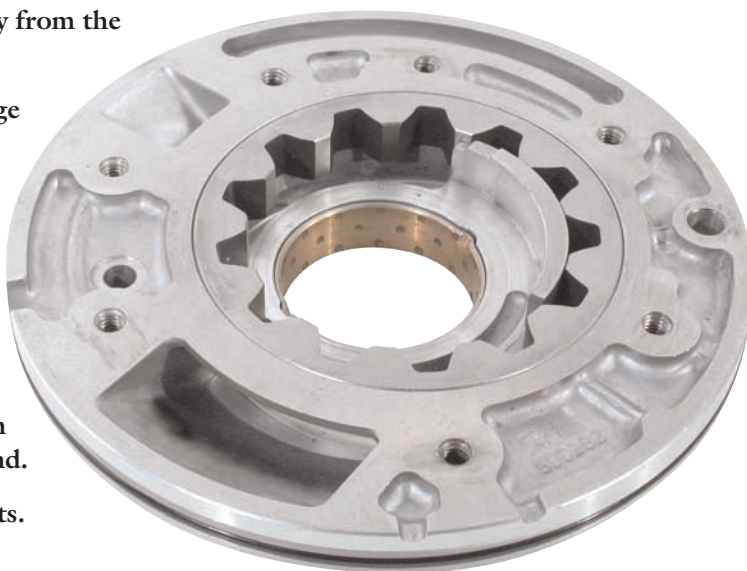
Pump Alignment Tool



INSTRUCTIONS FOR INSTALLING PUMP BUSHING

NOTE: Sonnax pump bushing **41005-01** is made for the 40 or 50 series pumps and cannot be used as a replacement bushing in earlier-style pumps.

1. Disassemble the pump and separate the pump body from the backing plate and pump gears.
2. Remove the worn pump bushing. Do not damage the bore when removing the worn bushing.
3. Orient the new Sonnax pump bushing **41005-01** so the seam line lies about 90° rotation away from the two stake pockets on the inside of the pump body.
4. Install the Sonnax pump bushing using correct bushing installation technique. The final position should be flush or just below flush. Check both ends of bushing. It should not overhang on either end.
5. Stake the new bushing in place at the stake pockets.



Pump Bushing & Alignment Tool

INSTRUCTIONS FOR USE OF PUMP ALIGNMENT TOOL

1. Reassemble the pump but do not tighten the torx fasteners completely.
2. Lube $\frac{3}{4}$ " at the end of the smaller outside diameter of the Sonnax pump alignment tool and the first $\frac{1}{2}$ " at the inner diameter of the pump stator support shaft with a light coat of ATF or Translube™ (see Figure 1).
3. Place the alignment tool over the stator support shaft. Using a twisting motion, carefully slide the smaller outside diameter of the tool through the new bushing. At the same time, the inner diameter of the stator support shaft must slip around the projecting cylinder on the inside of the alignment tool (see Figure 2).

NOTE: Inserting the tool may be difficult as clearances are minimal. Remember to rotate the tool as you insert it through the new bushing.

4. The pump is properly aligned when the pump body is seated flat against the pump backing plate and the alignment tool is seated against the end of the stator support shaft (see Figure 2).
5. Tighten torx fasteners to specifications. (Front-wheel-drive F4A41/42 and F5A51 tighten to 80-85 inch pounds; Rear-wheel-drive R4A/V4A51 and R5A/V5A51 tighten to 100-110 inch pounds.)
6. Carefully remove the alignment tool from the pump. Remember to rotate the tool as you remove it.

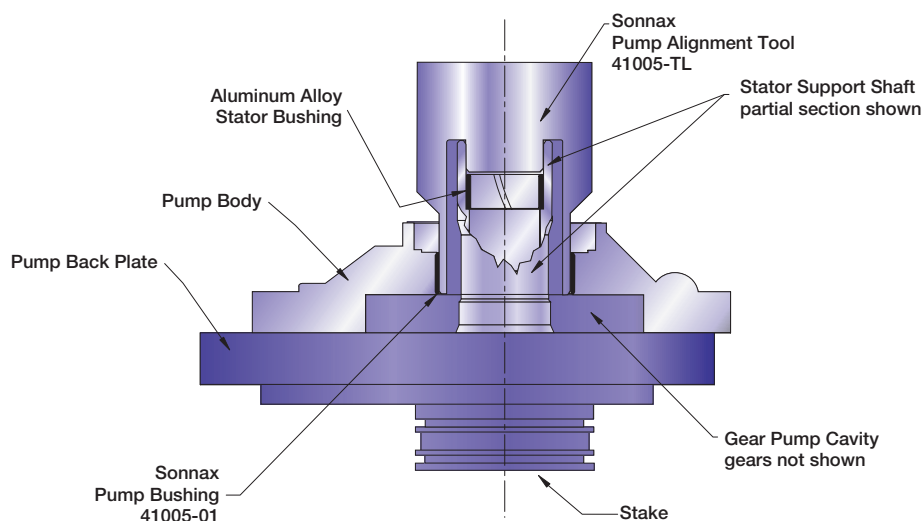


FIGURE 1

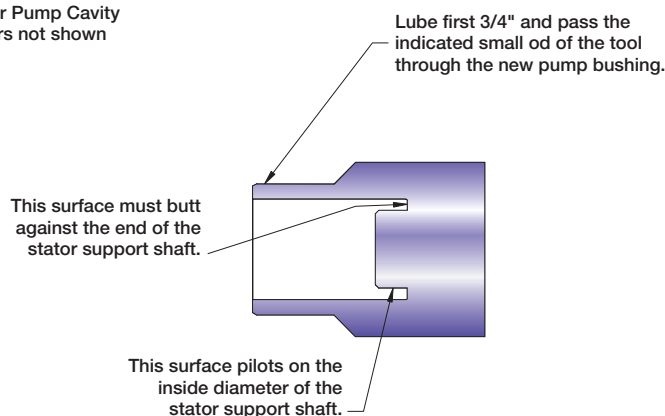


FIGURE 2