

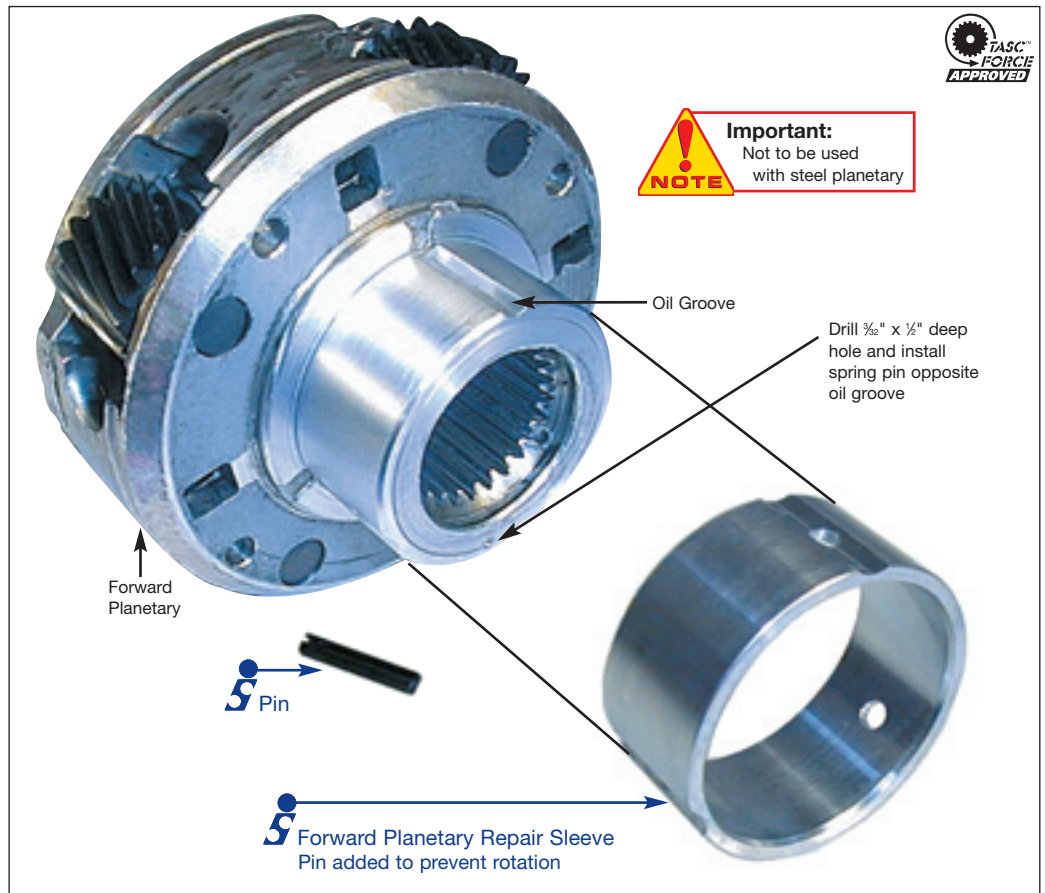
Forward Planetary Repair Sleeve

36440-01

1 Repair Sleeve
1 Spring Pin



Important:
Not to be used
with steel planetary



Installation Instructions:

1. Fixture the 3-pinion carrier in a 3-jaw lathe chuck. The 4-pinion carrier as used with diesel and 460 CID engine applications requires the use of a 4-jaw chuck.
2. Using a .0005" reading test indicator, check runout of the carrier body on both the OD and the thrust surfaces. The runout of the carrier installed in the lathe must be less than .001" TIR. If the observed runout is greater than the .001" TIR, align the chuck or refixture carrier as necessary.
3. Turn the worn carrier journal to a diameter of 1.8149/1.8143". The resized journal must have a smooth finish, free of chatter and galling.
4. Apply Loctite® to the newly turned carrier journal diameter, following Loctite® instructions.
5. Align the repair sleeve so that the three oil grooves and holes in the sleeve match the three oil holes in the carrier. The end of the sleeve with the I.D. chamfer must be installed first.
6. Using an arbor press, install the repair sleeve onto the carrier. Do not press directly against the sleeve with the ram. Use a plastic or hard wood block to avoid marring the sleeve.
7. After installing the new sleeve, drill a $\frac{3}{32}$ " dia. x $\frac{1}{2}$ " deep hole between the sleeve I.D. and the carrier journal O.D. Locate the hole 180° from any oil groove as shown. Apply a drop of Loctite® into the hole and then press in the spring pin provided. The spring pin must be flush with the carrier surface.

**Before repair with 36440-01,
forward planetary repair sleeve**



**After repair with 36440-01,
forward planetary repair sleeve**



Drill $\frac{3}{32}$ " x $\frac{1}{2}$ " deep hole and install spring pin here