

## Pump Bushings

### 85916-01

1 Oversized Precision  
Pump Bushing



### 85916-01U

1 Oversized Finish-in-Place  
Pump Bushing



### Installation Instructions

Both bushings are oversized and are designed for damaged pump housings. The pump-housing-bushing-bore will require machining. Also, after installation of the **85916-01U** bushing, the ID must be machined to set the desired clearance with the converter hub. See specifications below.

#### Installation of Oversized Precision Pump Bushing 85916-01

1. Remove and discard OEM bushing.
2. Machine pump housing bore ID to 1.9992" +/- .0005" (Ø50.780mm +/- 0.013mm).
3. The post-machining surface finish of the pump housing bore must be Ra60 – Ra125.
4. Install new Sonnax bushing.
5. Do not machine bushing ID of the **85916-01** version.

#### Installation of Oversized Finish-in-Place Pump Bushing 85916-01U

1. Remove and discard OEM bushing.
2. Machine pump housing bore ID to 1.9992" +/- .0005" (Ø50.780mm +/- 0.013mm)
3. The post-machining surface finish of the pump housing bore must be Ra60 – Ra125.
4. Install new Sonnax bushing.
5. ID of newly installed bushing must be machined in place. The surface finish should be Ra30 or better. Recommended diametric clearance is .002" (.051mm), or .001" (.025mm) per side. Measure the OD of the mating converter hub, add .002" (.051mm), and machine the ID of the installed bushing to the calculated dimension.