

Bell Housing or Pump Cover Bushing

56001X

5 Bushings

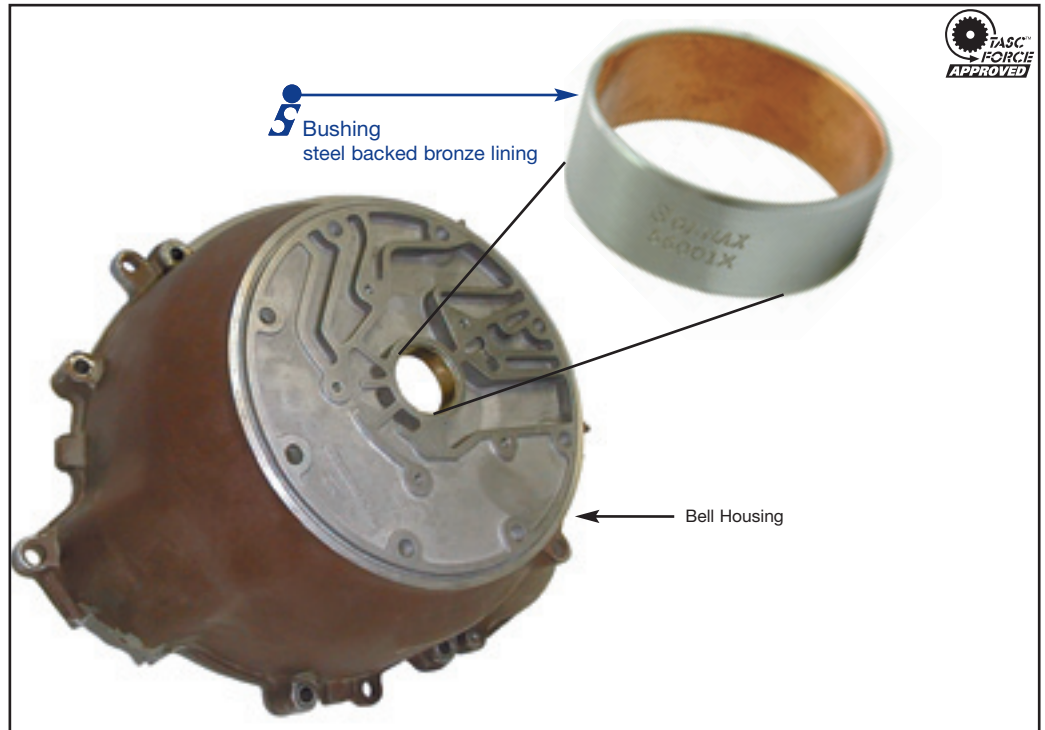


Note: Finish-in-place style bushing requires advanced machining skills to ensure proper I.D. and location after installation.

Also Available:

56947-02K

Boost Valve Kit



A4LD, 4R/5R44E, 4R/5R55E Installation Instructions:

Tooling Required: Arbor press, oil seal puller, shouldered arbor, locating fixture, Bridgeport-type milling machine, 2-inch precision boring head, carbide-tipped boring bar, toe clamp set, Indicol indicator holder, tenth reading test indicator, bore gauge, 41mm diameter ring gauge.

1. Remove the oil seal with a puller, then use an arbor press and shouldered arbor to remove the OEM bushing from the bell housing.
2. Use the arbor press and shouldered arbor to install the replacement bushing to proper depth.
3. Toe clamp the locating fixture (see Figure 1) to the mill table. Using the tenth reading indicator, align the fixture pilot diameter within .0005" TIR to the mill spindle (see Figure 2).

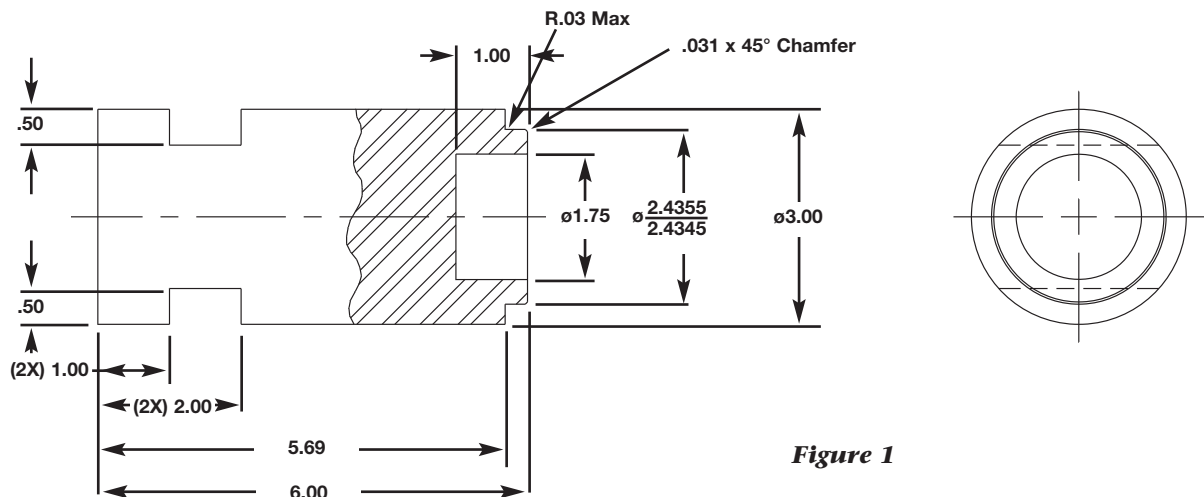


Figure 1

PART NUMBER 56001X

Installation Instructions continued:

4. Place the bell housing or pump cover over the fixture so that the fixture pilot diameter engages the seal bore. Toe clamp the block mounting surface of the bell housing or pump cover to the mill table (see Figure 3).
5. Bore the bushing I.D. to a size of 41.000mm - 41.025mm, (1.6142"-1.6152"). This requires a sharp carbide boring bar and a fine feed rate to achieve a desirable 32-microinch surface finish.

Note: To ensure stator-to-bell alignment, always use the factory-preferred pump alignment tool.

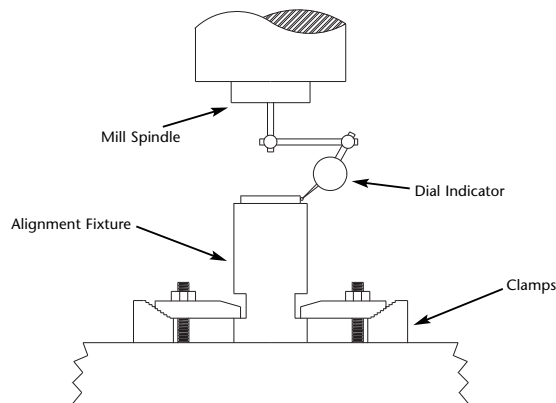


Figure 2

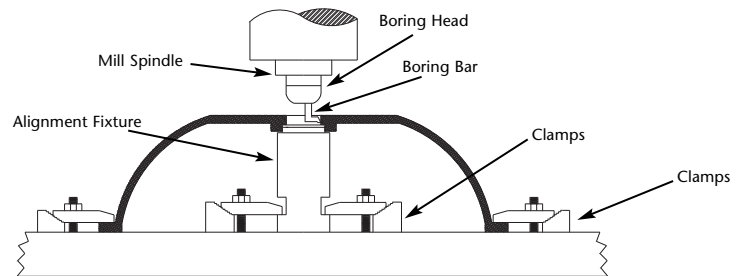


Figure 3

5R55BN/W/S Installation Instructions:

Tooling Required: Arbor press, oil seal puller, shouldered arbor, lathe with 4-jaw chuck, carbide-tipped boring bar, tenth reading indicator, bore gauge, 41mm diameter ring gauge.

1. Remove the oil seal with a puller, then use an arbor press and shouldered arbor to remove the OEM bushing from the pump cover.
2. Use the arbor press and shouldered arbor to install the replacement bushing to proper depth.
3. Clamp the outer diameter of the pump cover in a 4-jaw chuck. Using the tenth reading indicator, align the chuck to the bushing bore to within .0005" TIR.

Note: Do not use a 3-jaw chuck. The O.D. of the pump cover to the I.D. of the pump bushing is not within the .005" TIR requirement.

4. Bore the bushing I.D. to a size of 41.000mm - 41.025mm, (1.6142"-1.6152"). This requires a sharp carbide boring bar and a fine feed rate to achieve a desirable 32-microinch surface finish.

Note: To ensure stator-to-pump alignment, always use the factory-preferred pump alignment tool.