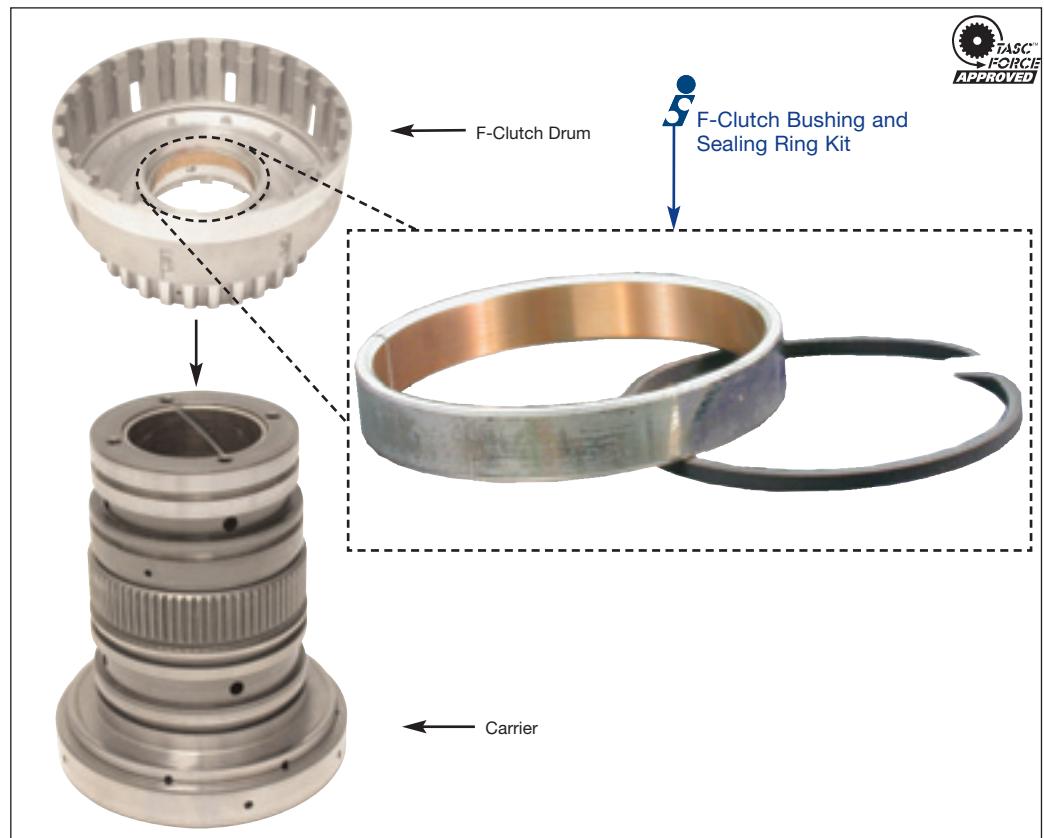


F-Clutch Drum Bushing and Sealing Ring Kit

85110-01K

1 Sealing Ring
1 Bushing

Note: Fits early bushing-style ZF5HP19.



Instructions

1. Remove the F-clutch drum and support shaft from the transmission and clean the parts thoroughly.
2. Remove the 3-tabbed bushing and ID O-ring from the bottom side of the clutch drum (opposite end from the clutch plates and piston).
3. Select a round piece of stock smaller than the ID of the clutch drum bore so as not to damage the bore while pressing the worn bushing out.

Note: A properly sized bushing driver / arbor is recommended for installation and removal of bushing to prevent component damage.

4. With the clutch facing up, press the worn bushing down and out the bottom of the clutch drum.
5. Remove the shaft seal ring from the support shaft: This is the first ring down on the small end of the shaft.
6. With clutch drum facing up, press the new Sonnax bushing into the clutch drum approximately .31" (8mm) from the top of the hub/bore, using the same piece of round stock used to disassemble the bushing.
7. Clean any burrs or chips from the bore of the clutch drum and bushing generated from the pressing operation.
8. Install the new Sonnax shaft seal ring onto the shaft and apply a coat of Trans Jel™ to the outside of the seal ring to retain the seal to the shaft during assembly.
9. Install a new O-ring into the ID groove in the bottom of the clutch drum bore and reassemble the 3-tabbed bushing.
10. Reassemble the F-clutch drum and support shaft assemblies back in the transmission.