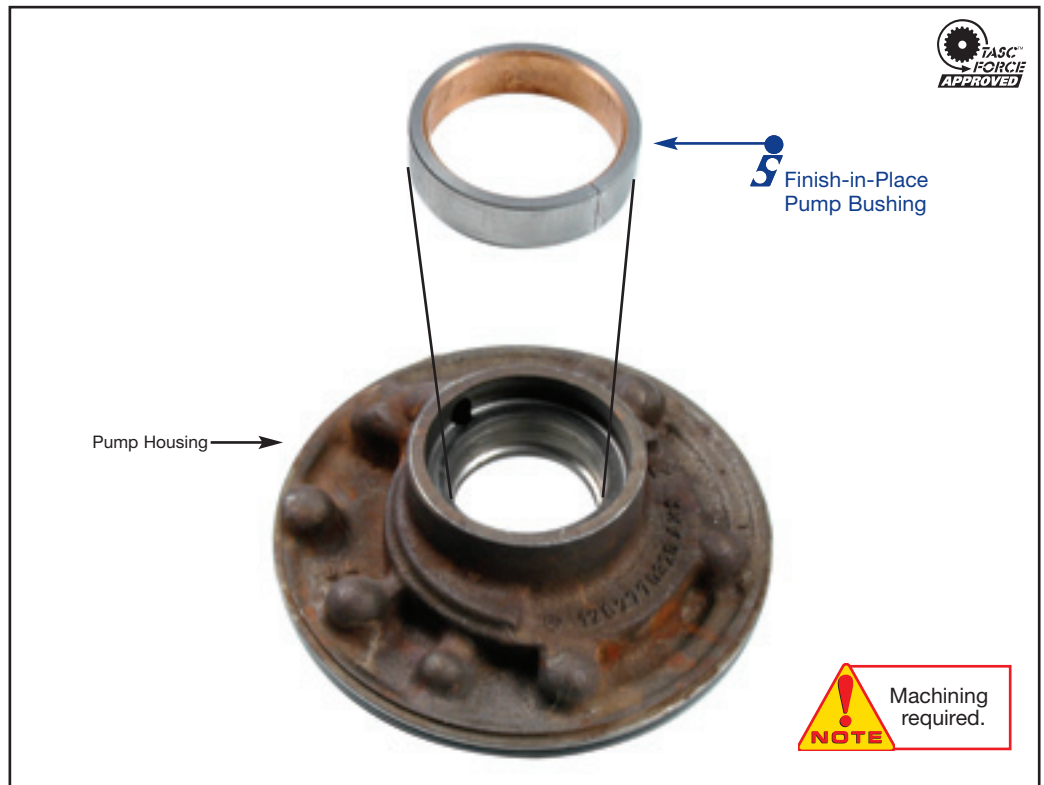


Oversized Pump Bushing

68004-02

1 Finish-in-Place Pump Bushing



INSTRUCTIONS

This is an oversized finish-in-place bushing designed for damaged pump housings. The pump housing bushing bore ID will require machining. This ID must be machined to $\varnothing 2.0000'' \pm .0005''$ ($\varnothing 50.800\text{mm} \pm 0.013\text{mm}$).

After installation, the bushing ID must be machined to set the desired clearance with the converter hub. Recommended clearance is $.002-.005''$. Measure the OD of the mating converter hub, add $.002-.005''$, and machine the ID of the installed bushing to the calculated dimension.

INSTALLATION

1. Remove and discard the OEM bushing.
2. Machine the pump housing bore ID to $2.0000'' \pm .0005''$ ($\varnothing 50.800\text{mm} \pm 0.013\text{mm}$).
3. The post-machining surface finish of the pump housing bore must be Ra60 – Ra125.
4. Install the new Sonnax bushing.
5. Machine in place the newly installed bushing. The surface finish should be Ra30 or better.