

Case Bushing

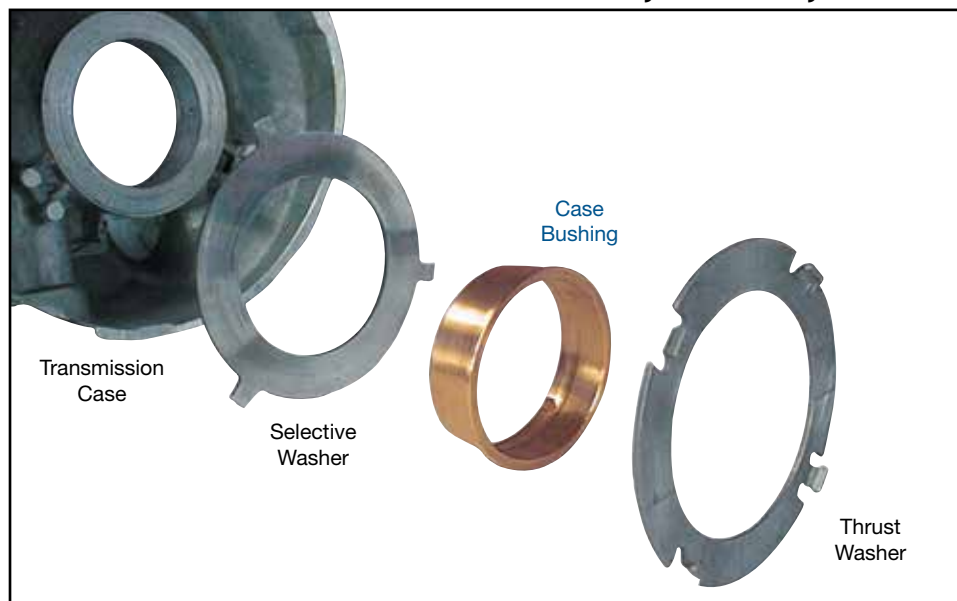
Part No.

34006-SP



NOTE: Locating points on case for selective washer are not concentric. When installing Sonnax case bushing, it may be necessary to grind 3 ears on selective washer slightly to refit in case.

GM 400, 4L80-E, 4L85-E



1. Disassembly

Remove OE output shaft, selective washer, thrust washer and case bushing from transmission case.

2. Determine Whether Lube Hole Modification is Necessary

The two lube holes on the output shaft feed lube oil into the center of the output shaft and forward into the planetaries and rear section of the transmission. Depending on application and year, in rare instances the output shaft lube holes will need modification using a die grinder.

- **4L80-E & 4L85-E Most Models:** There will be a slight overlap of the lube holes when installing the Sonnax bushing (**Figure 1**). This is okay; no modification necessary.
- **4L80-E & 4L85-E, Some '91-'96 Models:** On some models from this time period, there will be a significant overlap of the lube holes when installing the Sonnax bushing (**Figure 2**). In these rare instances, the output shaft lube holes require modification (**Figure 3**).
- **400 Models:** The lube passage will be completely covered by the bushing. This is normal, as there are grooves on the inner diameter to lube the rear thrust bearing. No modification necessary.

3. Installation

- Press Sonnax bushing into housing bore from inside of transmission with the flange seated on the flat, raised surface of transmission case. The housing bore should not measure more than 2.1285" in diameter for an ideal fit. For some applications, the bushing may be slightly longer than the bore depth. This will not be a problem.
- Return OE selective washer, thrust washer, and output shaft to the transmission case.
- The rear unit endplay, controlled by the selective washer, should be set in accordance with OE specifications.

NOTE: On some applications, the output shaft may be snug during reassembly. Tap on the shaft at spline area to reform the bushing high spots.

