sonnax®

**TRANSMISSION** PARTS

*Instructions*

# Ford C6, E40D

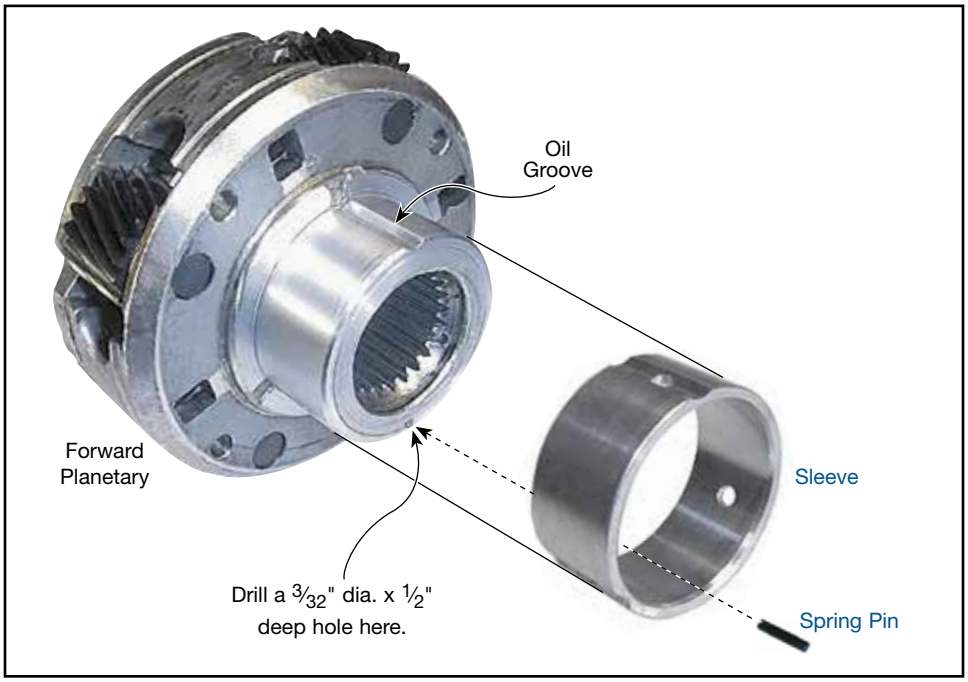
## Forward Planetary Repair Sleeve Kit

### Part No.
**36440-01**

- Sleeve
- Spring Pin

**NOTE:** This repair sleeve requires that the planetary carrier be turned using a lathe.

**NOTE:** Not to be used with steel planetary.




### 1. Machining Preparation

a. Fixture the 3-pinion carrier in a 3-jaw lathe chuck. The 4-pinion carrier as used with diesel and 460 CID engine applications requires the use of a 4-jaw chuck.

b. Using a .0005" reading test indicator, check runout of the carrier body on both the O.D. and the thrust surfaces. The runout of the carrier installed in the lathe must be less than .001" TIR. If the observed runout is greater than the .001" TIR, align the chuck or refixture carrier as necessary.

c. Turn the worn carrier journal to a diameter of 1.8149–1.8143". The resized journal must have a smooth finish, free of chatter and galling.

d. Apply Loctite® to the newly turned carrier journal diameter, following Loctite® instructions.

### 2. Installation & Assembly

a. Align Sonnax sleeve so the three oil grooves and holes in the sleeve match the three oil holes in the carrier. The end of the sleeve with the I.D. chamfer must be installed first.

b. Using an arbor press, install Sonnax sleeve onto the carrier. Do not press directly against Sonnax sleeve with the ram. Use a plastic or hard wood block to avoid marring sleeve.

c. After installing Sonnax sleeve, drill a 3⁄32" dia. x 1⁄2" deep hole between the sleeve I.D. and the carrier journal O.D. Locate the hole 180° from any oil groove (main photo). Apply a drop of Loctite® into the hole and then press in Sonnax spring pin. The spring pin must be flush with the carrier surface.



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