sonnax®

TRANSMISSION PARTS

Instructions

Ford 4F50N, AX4N, AX4S, AXOD, AXODE

Channel Plate Repair Sleeve

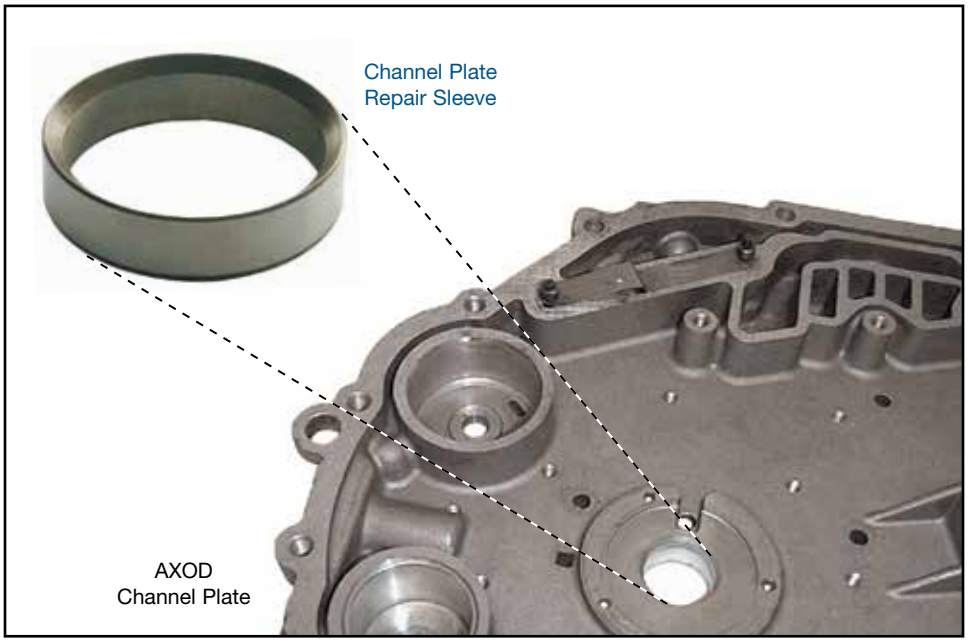
Part No. 96803

• Sleeves (5)

NOTE: This repair sleeve requires machining.

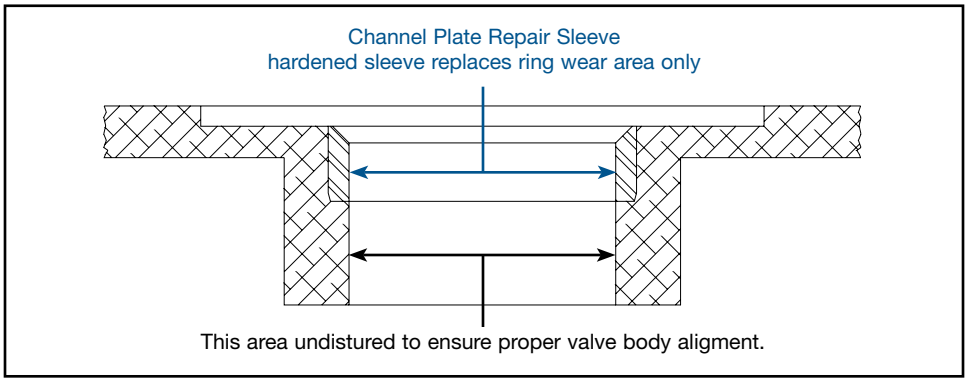
REQUIRED TOOLS:

- Bridgeport type milling machine
- Precision boring head 2"
- Carbide-tipped boring bar
- Pair of 1-2-3 blocks
- Toe clamp set
- Indicol indicator holder
- Tenth reading test indicator
- Depth micrometer
- Bore gauge
- Ring gauge 1.1562" dia.
- Solvent
- Loctite® 609



Installation & Assembly

1. With 1-2-3 blocks supporting the chain cover, toe clamp the chain cover to the mill table, case mounting surface side up.
2. Using the tenth reading indicator, align the mill spindle within .0005" TIR to the seal bore. Make certain the indicated surface is not worn.
3. Counterbore the seal bore to a diameter of 1.1562–1.1567" and a depth of .276–.286". Inside radius at bottom of counterbore not to exceed .01". Requires a sharp carbide boring bar and a fine feed rate to maintain size tolerance.
4. Remove machining burrs and break the top edge corner, .01" maximum. Thoroughly clean the repair sleeve and counterbore surfaces with a solvent compatible with Loctite®.
5. Apply Loctite 609® retaining compound to O.D. of sleeve. With sleeve I.D. chamfer facing up, press sleeve into place with mill spindle. Wipe off excess Loctite 609®.



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