

Oversized Pump Bushing

Part No.

85916-01U



NOTE: Machining required.

ZF5HP19



NOTE: This bushing is designed for damaged pump housings. The pump bore must be machined prior to installing Sonnax bushing. After bushing installation, bushing I.D. must be machined to set the desired clearance with the converter hub.

1. Remove and discard OE bushing.
2. Center pump using a 4 jaw chuck. Indicate off O.D. of pump or front pump seal bore.
3. Bore pump housing to 2.0020"[50.85mm] +/- .0015"[0.040mm].
4. The post-machining surface finish of the pump housing bore must be Ra60 – Ra125.
5. Install Sonnax bushing.
6. I.D. of Sonnax bushing must be machined in place with a surface finish of Ra30 or better. Recommended diametral clearance between bushing and impeller hub is .0027–.0045" (.069–.114mm). As a reference, inside diameter of installed OE bushing is 1.7743" [45.066mm]. Measure the O.D. of the mating converter hub, add .003" (.08mm), and machine the I.D. of the installed bushing to the calculated dimension.