

**Ford 6R80; ZF6HP19, ZF6HP26, ZF6HP28**

**Input/Output Shaft Bushing**

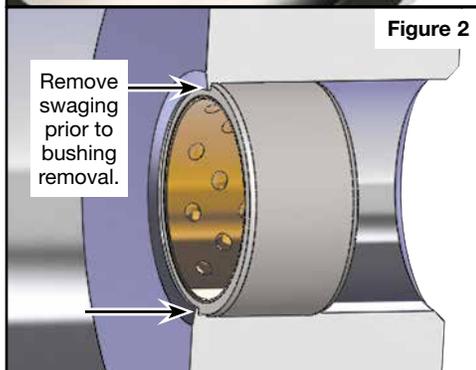
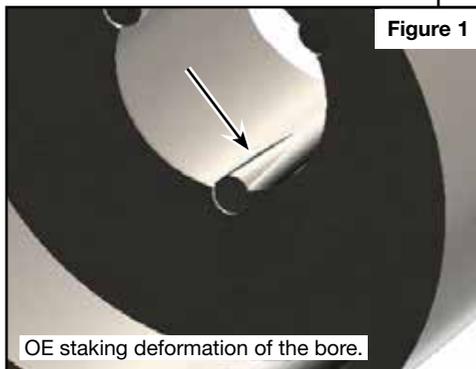
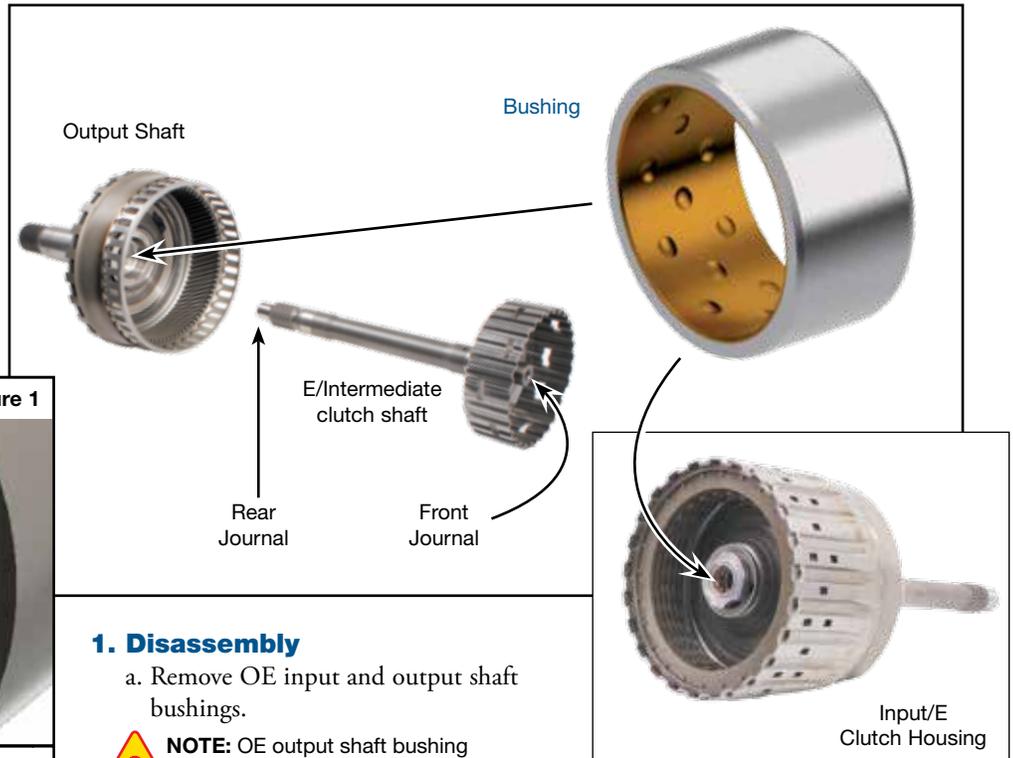
**Part No.**

**95030-05**

• Bushings (6)



**NOTE:** Fits units with .669" (16.98mm) dia. shaft journals only.



**1. Disassembly**

- a. Remove OE input and output shaft bushings.



**NOTE:** OE output shaft bushing is staked/coined in place. After bushing removal, internal staking deformation must be removed from the bore to prevent distortion of Sonnax bushing during installation (**Figure 1**).

A die grinder or lathe may be used to carefully remove these bore protrusions.

Some output shaft bushings are retained by a swaging operation (**Figure 2**). The swaging will need to be removed to allow bushing service.



**CAUTION:** Exercise care when using a puller to remove bushing, as it is possible to inadvertently cause grooving of the bore with the puller arms. These grooves can prevent the mating parts from fitting together properly.

**2. Assembly**



**CAUTION:** Use of an arbor press is required for correct installation. DO NOT use a hydraulic press or a bushing driver and hammer to install, as doing so will distort the bushing and cause fitment issues.

- a. Install Sonnax input and output shaft bushings flush with bottom of bore chamfer (**Figure 3**).
- b. After installation and fit-testing of Sonnax output shaft bushing, lightly stake bushing in place (**Figure 4**).

