

Pump Bushing



Part No.

68004-02



NOTES: Finish-in-Place.
Oversized O.D.
Also fits 722.3 & 722.5 units.
Machining required.

Mercedes 722.6



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

1. Remove and discard OE bushing.
2. Machine pump housing bore I.D. to 2.0000" +/- .0005".
3. The post-machining surface finish of the pump housing bore must be Ra60 – Ra125.
4. Install Sonnax bushing.
5. I.D. of Sonnax bushing must be machined in place. The surface finish should be Ra30 or better. Recommended diametric clearance is .002–.005". Measure O.D. of the mating converter hub, add .002–.005", machine the I.D. of installed bushing to the calculated dimension.