

## Shift Lever Case Bore Repair Sleeve

Part No.

**22179-02**



## Tool Kit

Part No.

**56361-TL**

- Reamer
- Reamer Guide
- Reamer Guide Plate
- Reamer Alignment Bushing
- Screws (2) M8 x 20mm
- Screws (3) M6 x 20mm
- Screws (3) 5/16" x 3/4"
- Sleeve Installation Tool
- Clamp Bracket

**NOTE:** Follow instructions as this tool kit contains more parts than are required for Chrysler RWD installation.

**WARNING:** Required tool kit **56361-TL** is no longer in production. Check with your distributor for availability.

## Chrysler 42RE, 42RH, 46RE, 46RH, 47RE, 47RH, 48RE, A727, A904

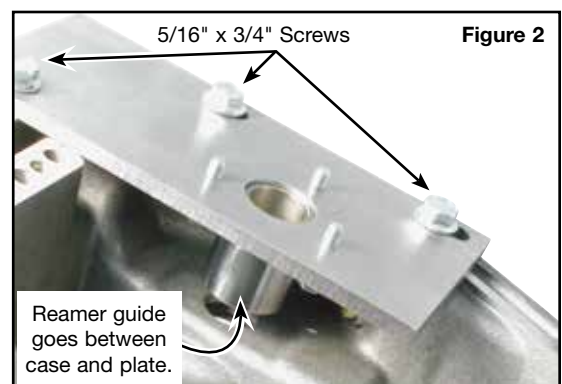
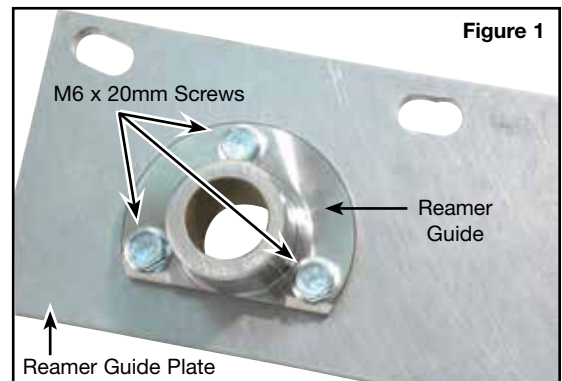


### 1. Disassembly

- a. Remove valve body and manual shaft seal from case.
- b. Clean seal bore and pan/valve body surface of case.
- c. Run a file across case pan gasket surface to make sure there are no nicks or burrs where the reamer guide plate attaches to case.

### 2. Reaming

- a. Attach Sonnax reamer guide to reamer guide plate with three (M6 x 20mm) screws (**Figure 1**). Ensure all three screw holes on the reamer guide line up, as the guide can only be attached to one side of the plate.
- b. With reamer guide located between case and plate, mount reamer guide plate to the case using three 5/16" x 3/4" screws, leaving them slightly loose for plate alignment (**Figure 2**).



### 2. Reaming (continued)

- c. Place reamer alignment bushing into manual shaft seal bore in case (seal must be removed).
- d. Align reamer guide plate by inserting reamer through reamer guide and into alignment bushing (**Figure 3**). Tighten screws to secure reamer guide plate to the case. Ensure reamer rotates freely in alignment bushing.
- e. Remove alignment bushing from case.
- f. Ream hole with a low speed drill (approximately 250 RPM) and appropriate cutting fluid.

### 3. Installation & Assembly

- a. Coat Sonnax bore repair sleeve with Loctite® and install Sonnax repair sleeve from inside of case (**Figure 4**).
- b. Install new seal and valve body.
- c. Verify free rotation of shift linkage.

