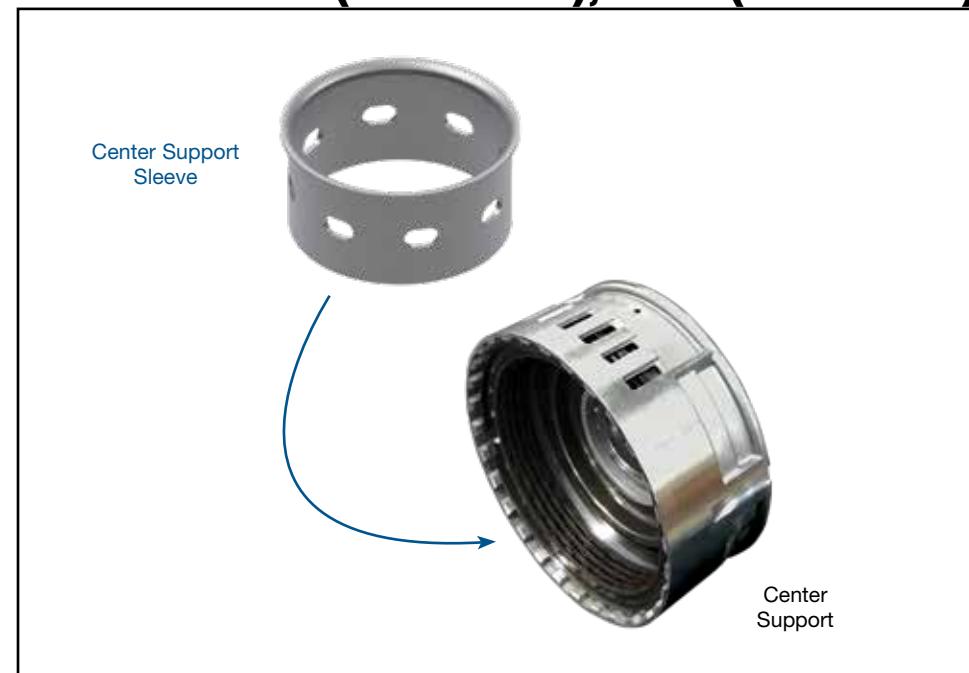


Ford 6R60, 6R75, 6R80 (2009–2014), 6R80 (2015–Later)

Center Support Sleeve

Part No.

95630-02



1. Machine Center Support

- Remove center support sleeve.
- Using aluminum pie jaws, chuck on the major \varnothing 7.965" outside diameter of the center support.
- Place indicator inside bore #2 (Figure 1) and check runout — should not exceed .001" TIR (Total Indicator Reading).
- Using a single point boring bar, re-bore inside diameters of bore #1 and bore #2 to dimensions shown under "Machined Bore Measurement" (Figure 2).

NOTE: Dimension "A" must have a $45^\circ \pm 5^\circ$ lead in chamfer to oversize bore #2.

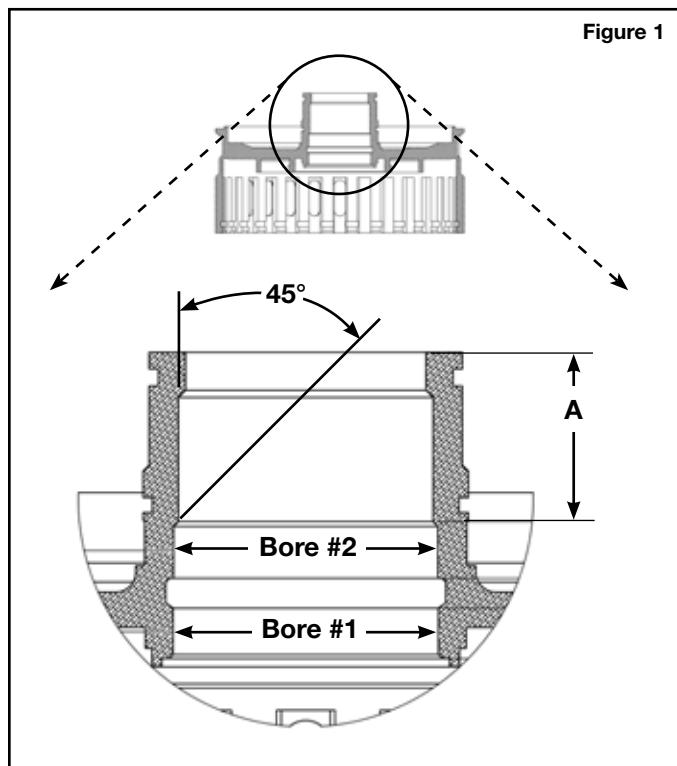


Figure 2

Bore Location	OE Bore Measurement	Machined Bore Measurement
Bore # 1	1.958"	2.0000" - 2.0020"
Bore # 2	1.952"	1.9930" - 1.9950"

2. Installation & Assembly

- a. Clean all debris from center support. Inspect the machined bore surfaces and the O.D. to ensure there is no raised material. Remove all burrs.
- b. Press sleeve into bore using an arbor press and suitable driver. When pressing the sleeve, support the center support at the surface shown (Figure 3).

NOTE: For easier press of sleeve, preheat center support to 200° F and freeze sleeve prior to pressing in.

- c. Verify flat brim of sleeve is flush to mating surface.

