

## Ford 10R80

### CDF Drum Saver Kit

**Part No.**  
**129910-01K**

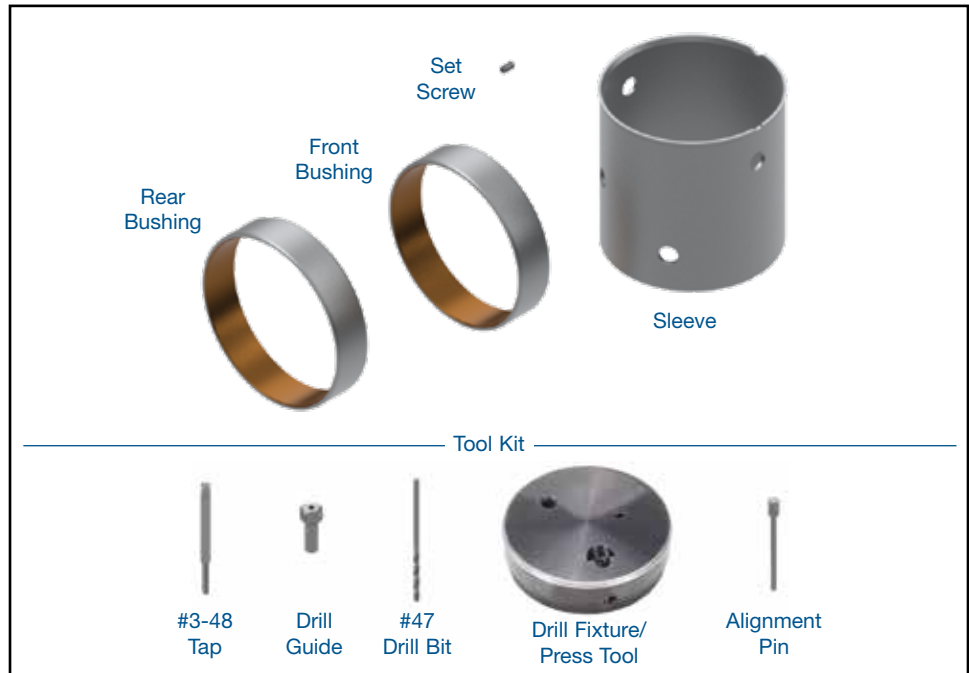


- Sleeve
- Set Screws (2) 1 Extra
- Front Bushing
- Rear Bushing

### Tool Kit

**Part No.**  
**129910-TK**

- #3-48 Tap
- Drill Guide
- #47 Drill
- Drill Fixture/Press Tool
- Alignment Pin



#### 1. Disassembly

- Remove front and rear bushings.
- Press out the CDF drum sleeve.

**NOTE:** The sleeve has a very tight press fit. Heating the drum to 150–200°F will greatly aid sleeve removal.

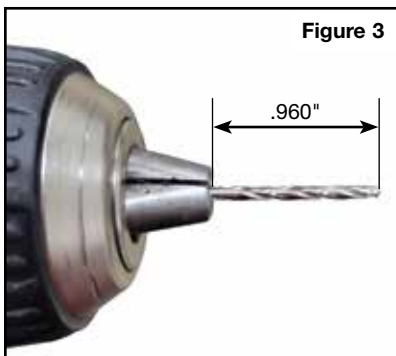
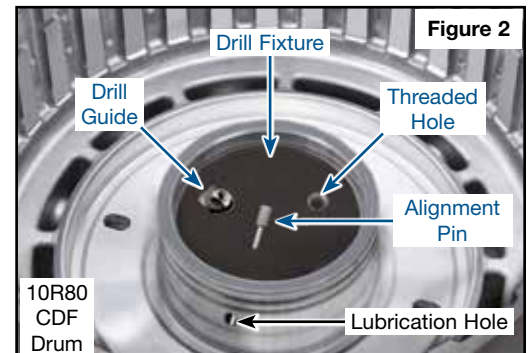
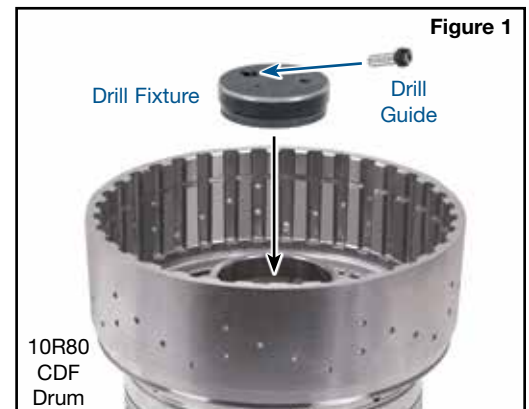
#### 2. Bore Prep

**NOTE:** Sonnax tool kit 129910-TK is required.

- Press the Sonnax drill guide into the Sonnax drill fixture. Ensure it is fully inserted in the drill fixture (Figures 1 & 2).
- Place the drill fixture in the front bushing bore. Rotate the drill fixture until the alignment pin fits into the existing lubrication hole in the CDF drum (Figure 2).

**NOTE:** A 1/4-20 bolt can be threaded in the drill fixture to act as a handle.

- Using the #47 drill bit, set the drill bit length from tip of the drill chuck or drill stop to .960" (Figure 3).



## 2. Bore Prep (continued)

- d. Using the Sonnax drill guide, drill a hole in the CDF drum until the chuck/drill stop bottoms out on the drill guide (**Figure 4**).



**NOTE:** Drill depth is very important, as it is not desirable to drill all the way through the wall.

- e. Remove the drill fixture. Tap the bore with the Sonnax #3-48 tap.

## 3. Installation & Assembly

### Sleeve

- Clean all debris out of the CDF sleeve bore. Inspect the bore for any damage, ensure there is no raised material in the bore. For ease of installation, pre-heat the CDF drum to 200 °F.
- Lubricate the outside diameter of the Sonnax sleeve to aid installation.
- Once the drum is heated, align the half moon on the bottom of the sleeve with the tapped bore on the CDF drum bore chamfer (**Figure 5**). Using an arbor press and the Sonnax drill fixture as a driver, press Sonnax sleeve fully into the CDF drum until the flange on the sleeve bottoms out in the drum.
- Verify Sonnax sleeve is fully pressed. Measure the distance from the top flange of the sleeve to the top of the center support (**Figure 6**). The measurement should be .663" ( $\pm .010$ ").
- Using red Loctite®, install Sonnax set screw into the threaded hole at the top of the sleeve, bottoming out the set screw. Ensure the set screw sits below the surface of the sleeve.

### Bushings

- Clean all debris out of the CDF front bushing bore. Inspect the bore for any damage, ensure there is no raised material in the bore.
- Using the correct size bushing driver, press in Sonnax front bushing **129910-01** using an arbor press, to a depth of .057" (**Figure 7**). Lubricate the outside diameter of the bushing to aid installation.
- Repeat steps A and B for the rear CDF drum bushing using Sonnax rear bushing **129910-02**. Press the rear bushing to a depth of .194" (**Figure 7**).



Figure 4

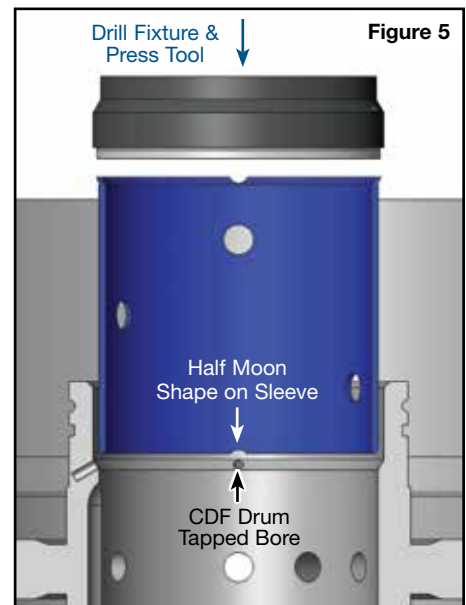


Figure 5

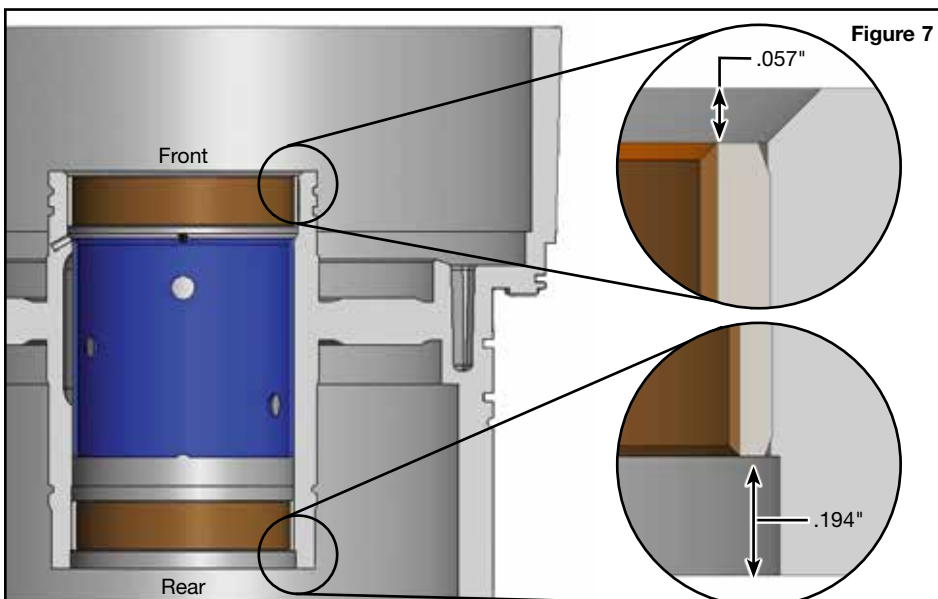


Figure 7

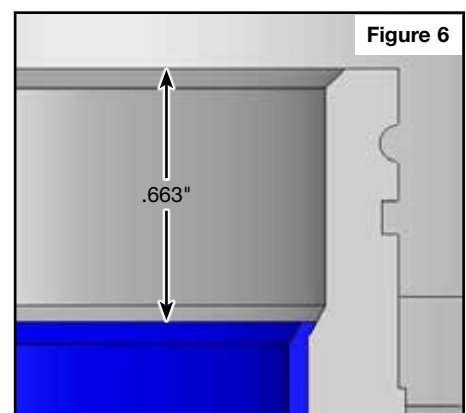


Figure 6