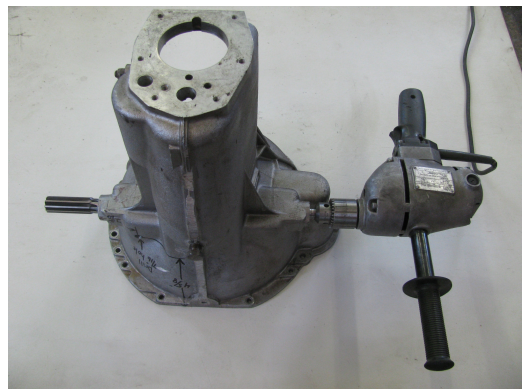
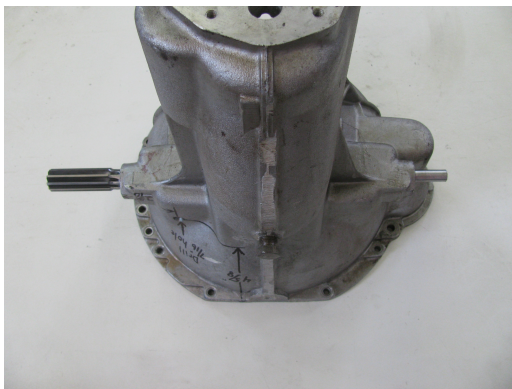


## ENLARGING TRANSMISSION HOUSING CROSS SHAFT HOLES WITH GOODPARTS REAMER

- 1) Remove cross shaft and remove bushing from left (drivers) side of housing.
- 2) Leave bushing in right side to guide the reamer. If original bushing is severely worn, remove it and insert the supplied  $\frac{3}{4}$ " x  $\frac{7}{8}$ " bushing just flush with the outside of the housing. A section of shaft is supplied to use as a punch to remove the bushing.
- 3) Generously lubricate the shank of the reamer and the inside of the bushing and trans housing with motor oil.
- 4) Insert the reamer through the left side and on through the right side. The fit should be fairly tight and may require the help of a soft faced hammer.
- 5) Tighten the chuck of a heavy duty, slow speed  $\frac{1}{2}$ " drill onto the end of the reamer shank. **BE SURE** to place the chuck jaws on the flat spots on the reamer shank and tighten securely so it does not slip.
- 6) Apply cutting fluid to reamer cutting edges.
- 7) Hold drill and trans housing securely and run drill in forward direction while pulling reamer into housing. Stop periodically to remove chips and apply more cutting fluid. Cut into housing to a depth of approximately 0.813" (approximately  $1\frac{15}{16}$ " of reamer protruding from the housing)
- 8) Remove the reamer then remove the bushing from the right side using the punch supplied.
- 9) Insert the  $\frac{3}{4}$ " x 1" bronze bushing into the 1" hole you just reamed in the left side.
- 10) Lubricate the shank of the reamer and inside of the bushing and housing and insert the reamer through the right side and out through the bushing in the left side.
- 11) Ream the right side the same as the left.
- 12) Remove the reamer then remove the bushing from the right side using the punch supplied.
- 13) Clean the tools and bushings and return ship to Good Parts. Please return the cutting fluid bottle, even if it is empty.



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