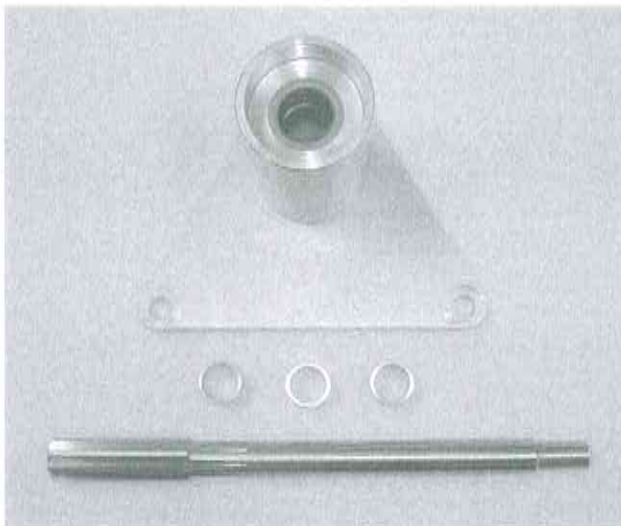
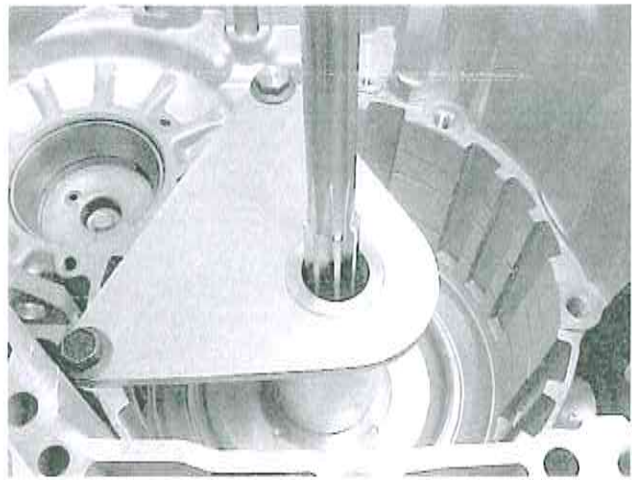


09G TF60SN C2 Clutch Drum Bushing Repair Tool

The center post at the rear of the 09G case holds a bushing that tends to ruin the case when it spins. In order to save the cases we have produced an oversize bushing.



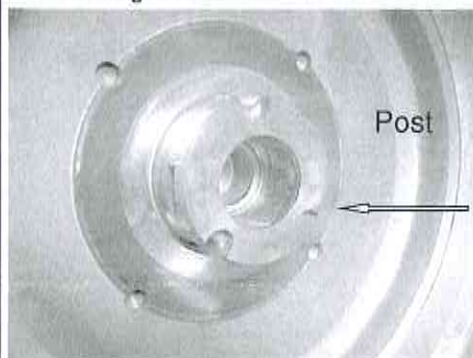
Machining of the case is necessary to install the bushing. The sleeve at the rear of the case must fit firmly on the post. Three bushings come with the tool. Omega Machine is please to announce this tool so you can repair these cases in house.

Your feedback is welcome on all our products!

Omega Machine & Tool, Inc.
"Precision and Innovation for Today"

Tel. 800 601 7722 – Fax 916 928 6020
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**O9G VW Case
Bushing Repair
(2003 and up)**

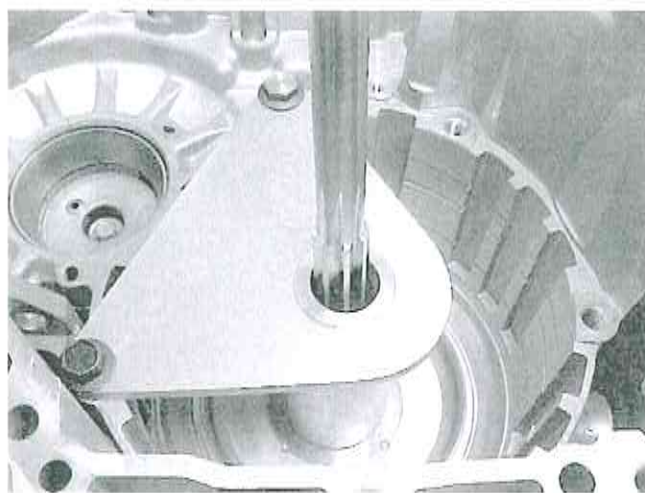
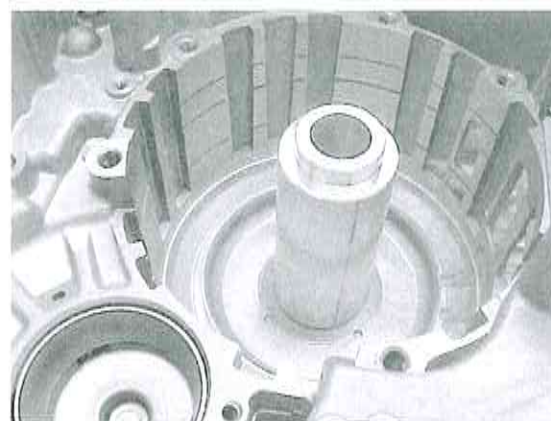


Problem: This post supports a sealing ring sleeve. The center of the post holds a bushing that tends to ruin the case when it fails. Getting the bushing out is difficult.

Omega is supplying an oversize bushing to replace the stock bushing. This is part number 90448A.

If the case fit is bad, follow the instructions below. If the sealing ring sleeve is loose, fix that first.

Begin by placing the reamer guide over the sealing ring sleeve. Make sure it seats on top of the sleeve.

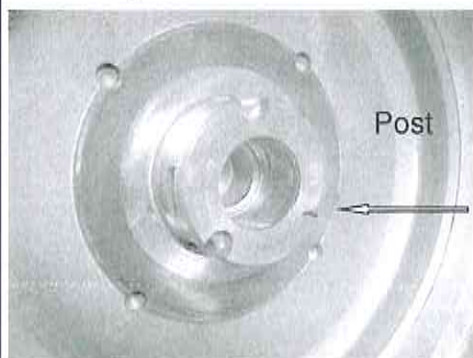


Bolt on the top plate to center and stabilize the reamer guide. Use WD-40 to lubricate the reamer. Use a 1/2" drill on slow speed and press firmly until it stops cutting. There is a definite change in the feed when it bottoms out. Carefully extract the reamer. Store it in the plastic case to keep it sharp.

Insert the new bushing and check the fit with the drum. Using Loctite is advised, as there seems to be high stress in this bushing area. Drive the bushing in as straight as possible to avoid deforming the bushing or the bore.



O9G VW Case Repair (2003 and up)



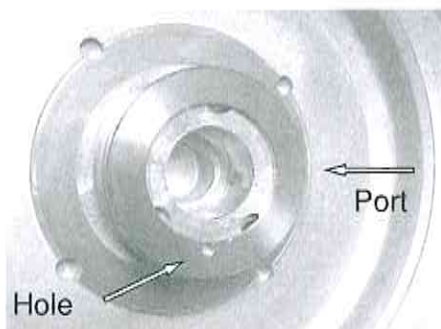
Post

Problem: This post supports a sealing ring sleeve. If the sleeve comes loose, it blocks the port. The bushing in the center tends to self destruct and ruin the bushing fit in the case. This procedure addresses both of these problems.

Step 1: Using the kit drill bit, drill through the sealing ring sleeve. Look carefully at the picture to get the hole at the 9 o'clock position with the oval port at the 12 o'clock position. **Important!**



Step 2: Place the drilled sleeve back into the case with the port aligned. The drilled hole should be at the 6 o'clock position. Be sure to remove any burrs.



Port

Hole

Step 3: Put a piece of masking tape on the drill bit to make sure the hole is deep enough to allow the pin to go all the way in.

Step 4: Drill the hole....



Step 5: Install the pin



The bushing repair is on the next page. Contact Omega if you do not have this or go to the website for instructions.

Your finished repair should look like this.

Extra pins and drill bits are available. Call 9-5:00 PST

