

## Section E (Transaxle)

| Unit           | Area Affected                                                                                                                                                  | Drill Size         | Thread Size and Finished Tap depth | Rough Tap No. | Fin. Tap No. | Heli-Coil Insert No.       | Insert Tool No. | Tang Break-off Tool No. |
|----------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------|------------------------------------|---------------|--------------|----------------------------|-----------------|-------------------------|
| Gearbox casing | Hypoid casing face                                                                                                                                             | $\frac{5}{16}$ "   | $\frac{5}{16}$ " x 18 UNC x .96"   | 5 CRU         | 5 CBB        | 3585-5CN x $\frac{5}{8}$ " | 3551-5          | 3580-5                  |
|                | *Mounting cover                                                                                                                                                | $\frac{5}{16}$ "   | $\frac{5}{16}$ " x 18 UNC x 1.00"  | 5 CRU         | 5 CBB        | 3585-5CN x $\frac{5}{8}$ " | 3551-5          | 3580-5                  |
|                | Filler plug and Drain plug                                                                                                                                     | $\frac{5.3}{64}$ " | $\frac{1}{2}$ " x 14 BSP-through   | 8 PR          | 8 PB         | 1325-8CN x $\frac{1}{2}$ " | PIP-8           | Use pliers              |
|                | *Insert to be fitted to Dowel holes .225"-.25" deep from top face of hole.                                                                                     |                    |                                    |               |              |                            |                 |                         |
| Clutch housing | †Hypoid casing face                                                                                                                                            | $\frac{5}{16}$ "   | $\frac{5}{16}$ " x 18 UNC x 1.00"  | 5 CRU         | 5 CBB        | 3585-5CN x $\frac{5}{8}$ " | 3551-5          | 3680-5                  |
|                | Clutch withdrawal lever clip stud                                                                                                                              | $\frac{5}{16}$ "   | $\frac{5}{16}$ " x 18 UNC x .96"   | 5 CRU         | 5 CBB        | 3585-5CN x $\frac{5}{8}$ " | 3551-5          | 3580-5                  |
|                | †Top dowel hole insert must be positioned .225"-.25" below top face of hole.<br>Bottom dowel hole insert must be positioned .275"-.30" below top face of hole. |                    |                                    |               |              |                            |                 |                         |
| Mounting cover | Mounting rubber face                                                                                                                                           | $\frac{5}{16}$ "   | $\frac{5}{16}$ " x 18UNC-through   | 5 CRU         | 5 CBB        | 3585-5CN x $\frac{5}{8}$ " | 3551-5          | 3580-5                  |

Insert removal tools are available: For inserts  $\frac{1}{8}$ " to  $\frac{3}{8}$ " inclusive. Part No. 1227-6.  
For inserts  $\frac{7}{16}$ " to 1.0" inclusive. Part No. 1227-16.