



THM 4T60-E 1-2 AND 2-3 ACCUMULATOR SPRING IDENTIFICATION AND PROPER ASSEMBLY PROCEDURE

Since the introduction of the 4T60-E transaxle in 1991, there have been three different design levels of the 1-2 Accumulator Piston used, and some of them are installed in different directions. The 2-3 Accumulator Piston has been the same through out the same period. Refer to Figure 1 for the three different design levels of the 1-2 Accumulator Piston and their part numbers.

The accumulator spring charts used in this information have been prepared using the "Broadcast Code" off of the identification tag on the transaxle, and is mandatory information for these charts to be accurate. The information below will refer you to a Chart number for component identification, and a Figure number for the proper assembly procedure based on the OEM transaxle identification code.

I.D. Codes 1A7W, 1AYW, 2A7W, 2AYW,
Use Chart Number 1 for component identification and Figure 3 for proper assembly procedure.

**I.D. Codes 1BTW, 1CWW, 1YMW, 1YPW, 1YZW,
2B1W, 2B2W, 2BTW, 2BYW, 2C1W, 2C2W, 2C3W, 2C4W, 2C5W, 2C6W, 2CLW, 2CTW,
2CWW, 2CXW, 2CZW, 2P1W, 2PHW, 2W1W, 2WAW, 2Y1W, 2Y2W, 2Y4W, 2YLW, 2YMW,
2YXW,
3B1W, 3B2W, 3BTW, 3BYW, 3C1W, 3C2W, 3C3W, 3C4W, 3C5W, 3CLW, 3CMW, 3CSW,
3CTW, 3CWW, 3CXW, 3CZW, 3P1W, 3PHW, 3W1W, 3WAW, 3Y1W, 3Y2W, 3Y3W, 3YLW,
3YMW, 3YRW, 3YZW,
4PBW,
5A1W, 5ACW, 5B2W, 5B3W, 5BKW, 5BXW, 5C1W, 5CAW, 5PBW,**
Use Chart Number 2 for component identification and Figure 2 for proper assembly procedure.

**I.D. Codes 1A2W, 1AMW,
2A1W, 2A2W, 2A3W, 2A5W, 2A8W,
3ABW, 3AMW, 3ANW, 3AQW, 3AVW, 3AZW,**
Use Chart Number 3 for component identification and Figure 3 for proper assembly procedure.

**I.D. Codes 1A4W, 1APW,
2A4W, 2A6W,
3APW, 3AWW,**
Use Chart Number 4 for component identification and Figure 3 for proper assembly procedure.

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I.D. Codes 3BHW, 4AFW, 5AFW,
Use Chart Number 5 for component identification and Figure 3 for proper assembly procedure.

I.D. Codes 4ATW, 5ATW,
Use Chart Number 6 for component identification and Figure 3 for proper assembly procedure.

I.D. Codes 4YMW,
5Y3W, 5YMW, 5YQW,
7AWW,
Use Chart Number 7 for component identification and Figure 4 for proper assembly procedure.

I.D. Codes 4BLW, 4KUW, 4P1W, 4PFW, 4PMW, 4W1W, 4WAW, 4YZW,
5BLW, 5KUW, 5PMW, 5Y4W, 5YZW,
Use Chart Number 8 for component identification and Figure 2 for proper assembly procedure.

I.D. Codes 4KHW, 4YCW,
5B1W, 5BFW, 5Y1W, 5Y2W, 5YDW, 5YNW,
6CTW, 6YLW, 6YRW,
Use Chart Number 9 for component identification and Figure 2 for proper assembly procedure.

I.D. Codes 4CWW,
Use Chart Number 10 for component identification and Figure 2 for proper assembly procedure.

I.D. Codes 4PAW, 4WSW,
5WFW,
6BSW, 6WFW,
Use Chart Number 11 for component identification and Figure 2 for proper assembly procedure.

I.D. Codes 4CLW, 4PHW,
5PCW,
6CUW,
7CUW,
8BSW, 8CUW,
Use Chart Number 12 for component identification and Figure 2 for proper assembly procedure.

I.D. Codes 4CMW,
Use Chart Number 13 for component identification and Figure 4 for proper assembly procedure.

I.D. Codes 4AJW,
5AJW,
Use Chart Number 14 for component identification and Figure 4 for proper assembly procedure.

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*I.D. Codes 5A2W, 5AQW, 5ASW,
Use Chart Number 15 for component identification and Figure 4 for proper assembly procedure.*

*I.D. Codes 5PAW,
Use Chart Number 16 for component identification and Figure 2 for proper assembly procedure.*

*I.D. Codes 6AFW,
Use Chart Number 17 for component identification and Figure 3 for proper assembly procedure.*

*I.D. Codes 6PBW,
Use Chart Number 18 for component identification and Figure 4 for proper assembly procedure.*

*I.D. Codes 6ACW, 6ASW, 6BXW, 6CAW, 6HBW, 6QSW,
7ACW, 7ASW, 7BXW, 7HBW,
Use Chart Number 19 for component identification and Figure 4 for proper assembly procedure.*

*I.D. Codes 6PAW,
Use Chart Number 20 for component identification and Figure 4 for proper assembly procedure.*

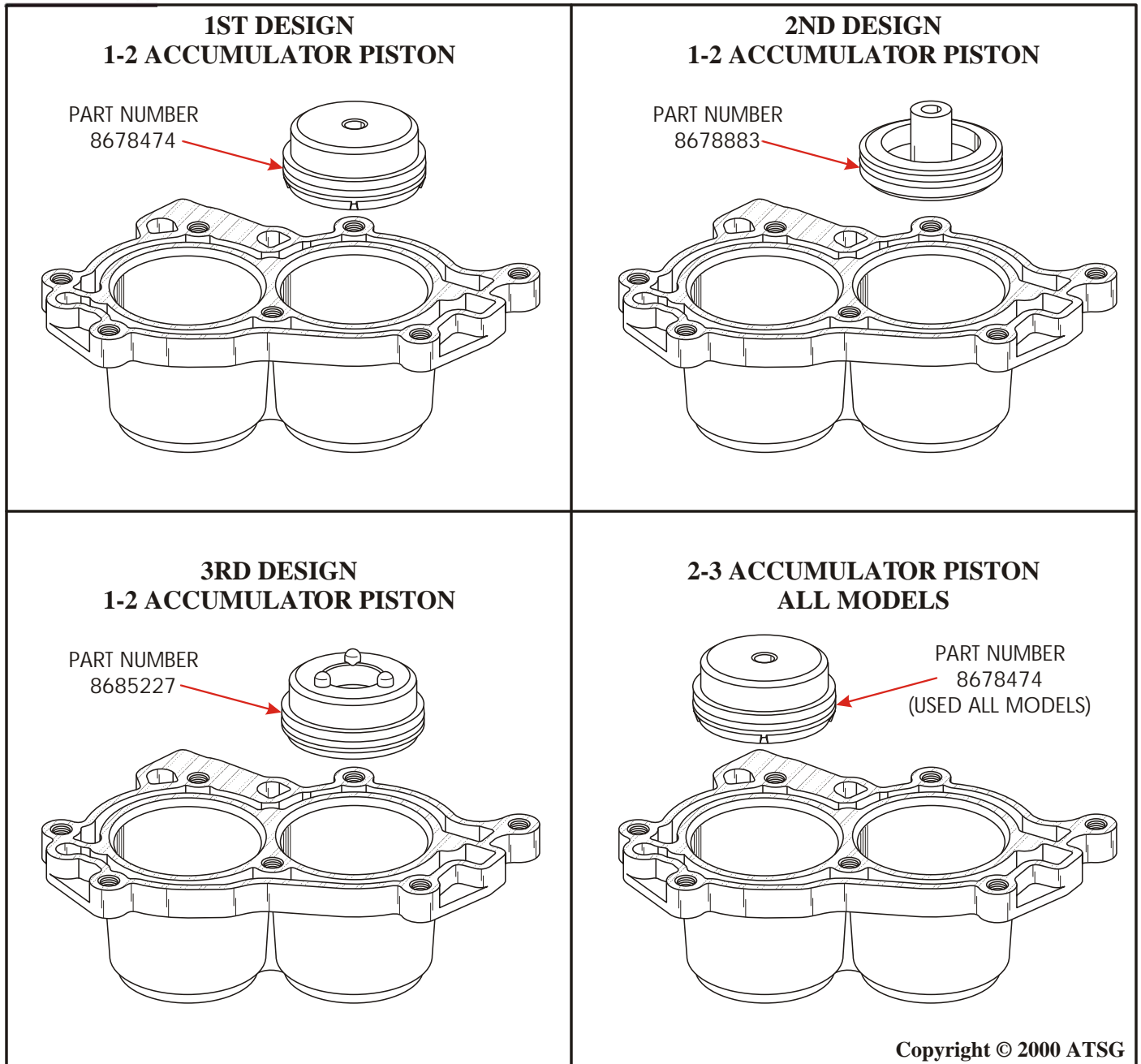
*I.D. Codes 6PKW,
7YAW,
Use Chart Number 21 for component identification and Figure 4 for proper assembly procedure.*

*I.D. Codes 7AFW, 7AHW,
Use Chart Number 22 for component identification and Figure 3 for proper assembly procedure.*

*I.D. Codes 7BSW,
Use Chart Number 23 for component identification and Figure 2 for proper assembly procedure.*

*I.D. Codes 8AHW,
9AHW,
Use Chart Number 24 for component identification and Figure 3 for proper assembly procedure.*

*I.D. Codes 8DKW,
Use Chart Number 25 for component identification and Figure 2 for proper assembly procedure.*



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Figure 1



Technical Service Information

CHART NUMBER 1 (Assembly Number 8681206)

<i>Part Name</i>	<i>Part Number</i>	<i>Identification</i>
<i>Accumulator Housing</i>	<i>8677163</i>	<i>Used On All Models</i>
<i>1-2 Accum. Outer Spring</i>	<i>8679540</i>	<i>Lt Blue/Violet Or Pink/Violet</i>
<i>1-2 Accum. Inner Spring</i>	<i>8677661</i>	<i>Lt Green/Orange</i>
<i>Accumulator Piston Seals</i>	<i>8678473</i>	<i>2 Required</i>
<i>1-2 Accum. Piston</i>	<i>8678883</i>	<i>Goes In Upside Down</i>
<i>Accumulator Piston Pins</i>	<i>8644298</i>	<i>2 Required</i>
<i>2-3 Accum. Outer Spring</i>	<i>8668487</i>	<i>White/Lt Green</i>
<i>2-3 Accum. Inner Spring</i>	<i>None Used</i>	<i>None Used</i>
<i>2-3 Accum. Piston</i>	<i>8678474</i>	<i>Used On All Models</i>
<i>Spacer Plate And Gasket Assem.</i>	<i>8682085</i>	<i>Used On All Models</i>
<i>Accumulator Cover</i>	<i>8651533</i>	<i>Used On All Models</i>
<i>Accumulator Cover Bolts</i>	<i>8651722</i>	<i>Used On All Models</i>

"2ND DESIGN" Use Figure 3 For Assembly Procedure

CHART NUMBER 2 (Assembly Number 8681209)

<i>Part Name</i>	<i>Part Number</i>	<i>Identification</i>
<i>Accumulator Housing</i>	<i>8677163</i>	<i>Used On All Models</i>
<i>1-2 Accum. Outer Spring</i>	<i>8649091</i>	<i>No Color Or Orange</i>
<i>1-2 Accum. Inner Spring</i>	<i>None Used</i>	<i>None Used</i>
<i>Accumulator Piston Seals</i>	<i>8678473</i>	<i>2 Required</i>
<i>1-2 Accum. Piston</i>	<i>8678474</i>	<i>Same As 2-3 Accum Piston</i>
<i>Accumulator Piston Pins</i>	<i>8644298</i>	<i>2 Required</i>
<i>2-3 Accum. Outer Spring</i>	<i>8668487</i>	<i>White/Lt Green</i>
<i>2-3 Accum. Inner Spring</i>	<i>8681456</i>	<i>No Color</i>
<i>2-3 Accum. Piston</i>	<i>8678474</i>	<i>Used On All Models</i>
<i>Spacer Plate And Gasket Assem.</i>	<i>8682085</i>	<i>Used On All Models</i>
<i>Accumulator Cover</i>	<i>8651533</i>	<i>Used On All Models</i>
<i>Accumulator Cover Bolts</i>	<i>8651722</i>	<i>Used On All Models</i>

"1ST DESIGN" Use Figure 2 For Assembly Procedure

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CHART NUMBER 3 (Assembly Number 8681211)

<i>Part Name</i>	<i>Part Number</i>	<i>Identification</i>
<i>Accumulator Housing</i>	<i>8677163</i>	<i>Used On All Models</i>
<i>1-2 Accum. Outer Spring</i>	<i>8679540</i>	<i>Lt Blue/Violet Or Pink/Violet</i>
<i>1-2 Accum. Inner Spring</i>	<i>8651774</i>	<i>White</i>
<i>Accumulator Piston Seals</i>	<i>8678473</i>	<i>2 Required</i>
<i>1-2 Accum. Piston</i>	<i>8678883</i>	<i>Goes In Upside Down</i>
<i>Accumulator Piston Pins</i>	<i>8644298</i>	<i>2 Required</i>
<i>2-3 Accum. Outer Spring</i>	<i>8668487</i>	<i>White/Lt Green</i>
<i>2-3 Accum. Inner Spring</i>	<i>8681456</i>	<i>No Color</i>
<i>2-3 Accum. Piston</i>	<i>8678474</i>	<i>Used On All Models</i>
<i>Spacer Plate And Gasket Assem.</i>	<i>8682085</i>	<i>Used On All Models</i>
<i>Accumulator Cover</i>	<i>8651533</i>	<i>Used On All Models</i>
<i>Accumulator Cover Bolts</i>	<i>8651722</i>	<i>Used On All Models</i>

"2ND DESIGN" Use Figure 3 For Assembly Procedure

CHART NUMBER 4 (Assembly Number 8681212)

<i>Part Name</i>	<i>Part Number</i>	<i>Identification</i>
<i>Accumulator Housing</i>	<i>8677163</i>	<i>Used On All Models</i>
<i>1-2 Accum. Outer Spring</i>	<i>8677427</i>	<i>Lt Blue/Dark Blue</i>
<i>1-2 Accum. Inner Spring</i>	<i>8651774</i>	<i>White</i>
<i>Accumulator Piston Seals</i>	<i>8678473</i>	<i>2 Required</i>
<i>1-2 Accum. Piston</i>	<i>8678883</i>	<i>Goes In Upside Down</i>
<i>Accumulator Piston Pins</i>	<i>8644298</i>	<i>2 Required</i>
<i>2-3 Accum. Outer Spring</i>	<i>8668487</i>	<i>White/Lt Green</i>
<i>2-3 Accum. Inner Spring</i>	<i>8681456</i>	<i>No Color</i>
<i>2-3 Accum. Piston</i>	<i>8678474</i>	<i>Used On All Models</i>
<i>Spacer Plate And Gasket Assem.</i>	<i>8682085</i>	<i>Used On All Models</i>
<i>Accumulator Cover</i>	<i>8651533</i>	<i>Used On All Models</i>
<i>Accumulator Cover Bolts</i>	<i>8651722</i>	<i>Used On All Models</i>

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CHART NUMBER 5 (Assembly Number 8686138)

<i>Part Name</i>	<i>Part Number</i>	<i>Identification</i>
<i>Accumulator Housing</i>	<i>8677163</i>	<i>Used On All Models</i>
<i>1-2 Accum. Outer Spring</i>	<i>8682700</i>	<i>No Color</i>
<i>1-2 Accum. Inner Spring</i>	<i>8668631</i>	<i>Lt Green</i>
<i>Accumulator Piston Seals</i>	<i>8678473</i>	<i>2 Required</i>
<i>1-2 Accum. Piston</i>	<i>8678883</i>	<i>Goes In Upside Down</i>
<i>Accumulator Piston Pins</i>	<i>8644298</i>	<i>2 Required</i>
<i>2-3 Accum. Outer Spring</i>	<i>8668487</i>	<i>White/Lt Green</i>
<i>2-3 Accum. Inner Spring</i>	<i>8681456</i>	<i>No Color</i>
<i>2-3 Accum. Piston</i>	<i>8678474</i>	<i>Used On All Models</i>
<i>Spacer Plate And Gasket Assem.</i>	<i>8682085</i>	<i>Used On All Models</i>
<i>Accumulator Cover</i>	<i>8651533</i>	<i>Used On All Models</i>
<i>Accumulator Cover Bolts</i>	<i>8651722</i>	<i>Used On All Models</i>

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CHART NUMBER 6 (Assembly Number 8685217)

<i>Part Name</i>	<i>Part Number</i>	<i>Identification</i>
<i>Accumulator Housing</i>	<i>8677163</i>	<i>Used On All Models</i>
<i>1-2 Accum. Outer Spring</i>	<i>8679540</i>	<i>Lt Blue/Violet Or Pink/Violet</i>
<i>1-2 Accum. Inner Spring</i>	<i>8651774</i>	<i>White</i>
<i>Accumulator Piston Seals</i>	<i>8678473</i>	<i>2 Required</i>
<i>1-2 Accum. Piston</i>	<i>8678883</i>	<i>Goes In Upside Down</i>
<i>Accumulator Piston Pins</i>	<i>8644298</i>	<i>2 Required</i>
<i>2-3 Accum. Outer Spring</i>	<i>8685219</i>	<i>White/Pink</i>
<i>2-3 Accum. Inner Spring</i>	<i>8685218</i>	<i>White/Dk Blue</i>
<i>2-3 Accum. Piston</i>	<i>8678474</i>	<i>Used On All Models</i>
<i>Spacer Plate And Gasket Assem.</i>	<i>8682085</i>	<i>Used On All Models</i>
<i>Accumulator Cover</i>	<i>8651533</i>	<i>Used On All Models</i>
<i>Accumulator Cover Bolts</i>	<i>8651722</i>	<i>Used On All Models</i>

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CHART NUMBER 7 (Assembly Number 8685505)

<i>Part Name</i>	<i>Part Number</i>	<i>Identification</i>
<i>Accumulator Housing</i>	<i>8677163</i>	<i>Used On All Models</i>
<i>1-2 Accum. Outer Spring</i>	<i>8649091</i>	<i>No Color Or Orange</i>
<i>1-2 Accum Cushion Spring & Retainer</i>	<i>8685229</i>	<i>On Top Of Piston, Retainer Up</i>
<i>1-2 Accum. Inner Spring</i>	<i>None Used</i>	<i>None Used</i>
<i>Accumulator Piston Seals</i>	<i>8678473</i>	<i>2 Required</i>
<i>1-2 Accum. Piston</i>	<i>8685227</i>	<i>"Bumps" On Top</i>
<i>Accumulator Piston Pins</i>	<i>8644298</i>	<i>2 Required</i>
<i>2-3 Accum. Outer Spring</i>	<i>8668487</i>	<i>White/Lt Green</i>
<i>2-3 Accum. Inner Spring</i>	<i>8681456</i>	<i>No Color</i>
<i>2-3 Accum. Piston</i>	<i>8678474</i>	<i>Used On All Models</i>
<i>Spacer Plate And Gasket Assem.</i>	<i>8682085</i>	<i>Used On All Models</i>
<i>Accumulator Cover</i>	<i>8651533</i>	<i>Used On All Models</i>
<i>Accumulator Cover Bolts</i>	<i>8651722</i>	<i>Used On All Models</i>

"3RD DESIGN" Use Figure 4 For Assembly Procedure

CHART NUMBER 8 (Assembly Number 8683186)

<i>Part Name</i>	<i>Part Number</i>	<i>Identification</i>
<i>Accumulator Housing</i>	<i>8677163</i>	<i>Used On All Models</i>
<i>1-2 Accum. Outer Spring</i>	<i>8649091</i>	<i>No Color Or Orange</i>
<i>1-2 Accum. Inner Spring</i>	<i>None Used</i>	<i>None Used</i>
<i>Accumulator Piston Seals</i>	<i>8678473</i>	<i>2 Required</i>
<i>1-2 Accum. Piston</i>	<i>8678474</i>	<i>Same As 2-3 Accum Piston</i>
<i>Accumulator Piston Pins</i>	<i>8644298</i>	<i>2 Required</i>
<i>2-3 Accum. Outer Spring</i>	<i>8649091</i>	<i>No Color Or Orange</i>
<i>2-3 Accum. Inner Spring</i>	<i>8681456</i>	<i>No Color</i>
<i>2-3 Accum. Piston</i>	<i>8678474</i>	<i>Used On All Models</i>
<i>Spacer Plate And Gasket Assem.</i>	<i>8682085</i>	<i>Used On All Models</i>
<i>Accumulator Cover</i>	<i>8651533</i>	<i>Used On All Models</i>
<i>Accumulator Cover Bolts</i>	<i>8651722</i>	<i>Used On All Models</i>

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CHART NUMBER 9 (Assembly Number 8685648)

<i>Part Name</i>	<i>Part Number</i>	<i>Identification</i>
<i>Accumulator Housing</i>	<i>8677163</i>	<i>Used On All Models</i>
<i>1-2 Accum. Outer Spring</i>	<i>8649091</i>	<i>No Color Or Orange</i>
<i>1-2 Accum. Inner Spring</i>	<i>None Used</i>	<i>None Used</i>
<i>Accumulator Piston Seals</i>	<i>8678473</i>	<i>2 Required</i>
<i>1-2 Accum. Piston</i>	<i>8678474</i>	<i>Same As 2-3 Accum Piston</i>
<i>Accumulator Piston Pins</i>	<i>8644298</i>	<i>2 Required</i>
<i>2-3 Accum. Outer Spring</i>	<i>8685219</i>	<i>White/Pink</i>
<i>2-3 Accum. Inner Spring</i>	<i>8685218</i>	<i>White/Dk Blue</i>
<i>2-3 Accum. Piston</i>	<i>8678474</i>	<i>Used On All Models</i>
<i>Spacer Plate And Gasket Assem.</i>	<i>8682085</i>	<i>Used On All Models</i>
<i>Accumulator Cover</i>	<i>8651533</i>	<i>Used On All Models</i>
<i>Accumulator Cover Bolts</i>	<i>8651722</i>	<i>Used On All Models</i>

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CHART NUMBER 10 (Assembly Number 8683576)

<i>Part Name</i>	<i>Part Number</i>	<i>Identification</i>
<i>Accumulator Housing</i>	<i>8677163</i>	<i>Used On All Models</i>
<i>1-2 Accum. Outer Spring</i>	<i>8682513</i>	<i>Dark Green</i>
<i>1-2 Accum. Inner Spring</i>	<i>None Used</i>	<i>None Used</i>
<i>Accumulator Piston Seals</i>	<i>8678473</i>	<i>2 Required</i>
<i>1-2 Accum. Piston</i>	<i>8678474</i>	<i>Same As 2-3 Accum Piston</i>
<i>Accumulator Piston Pins</i>	<i>8644298</i>	<i>2 Required</i>
<i>2-3 Accum. Outer Spring</i>	<i>8668487</i>	<i>White/Lt Green</i>
<i>2-3 Accum. Inner Spring</i>	<i>8681456</i>	<i>No Color</i>
<i>2-3 Accum. Piston</i>	<i>8678474</i>	<i>Used On All Models</i>
<i>Spacer Plate And Gasket Assem.</i>	<i>8682085</i>	<i>Used On All Models</i>
<i>Accumulator Cover</i>	<i>8651533</i>	<i>Used On All Models</i>
<i>Accumulator Cover Bolts</i>	<i>8651722</i>	<i>Used On All Models</i>

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CHART NUMBER 11 (Assembly Number 8685427)

Part Name	Part Number	Identification
<i>Accumulator Housing</i>	<i>8677163</i>	<i>Used On All Models</i>
<i>1-2 Accum. Outer Spring</i>	<i>8682513</i>	<i>Dark Green</i>
<i>1-2 Accum. Inner Spring</i>	<i>None Used</i>	<i>None Used</i>
<i>Accumulator Piston Seals</i>	<i>8678473</i>	<i>2 Required</i>
<i>1-2 Accum. Piston</i>	<i>8678474</i>	<i>Same As 2-3 Accum Piston</i>
<i>Accumulator Piston Pins</i>	<i>8644298</i>	<i>2 Required</i>
<i>2-3 Accum. Outer Spring</i>	<i>8668487</i>	<i>White/Lt Green</i>
<i>2-3 Accum. Inner Spring</i>	<i>8677661</i>	<i>Lt Green/Orange</i>
<i>2-3 Accum. Piston</i>	<i>8678474</i>	<i>Used On All Models</i>
<i>Spacer Plate And Gasket Assem.</i>	<i>8682085</i>	<i>Used On All Models</i>
<i>Accumulator Cover</i>	<i>8651533</i>	<i>Used On All Models</i>
<i>Accumulator Cover Bolts</i>	<i>8651722</i>	<i>Used On All Models</i>

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CHART NUMBER 12 (Assembly Number 8685444)

Part Name	Part Number	Identification
<i>Accumulator Housing</i>	<i>8677163</i>	<i>Used On All Models</i>
<i>1-2 Accum. Outer Spring</i>	<i>8646400</i>	<i>White/Red</i>
<i>1-2 Accum. Inner Spring</i>	<i>None Used</i>	<i>None Used</i>
<i>Accumulator Piston Seals</i>	<i>8678473</i>	<i>2 Required</i>
<i>1-2 Accum. Piston</i>	<i>8678474</i>	<i>Same As 2-3 Accum Piston</i>
<i>Accumulator Piston Pins</i>	<i>8644298</i>	<i>2 Required</i>
<i>2-3 Accum. Outer Spring</i>	<i>8668487</i>	<i>White/Lt Green</i>
<i>2-3 Accum. Inner Spring</i>	<i>8681456</i>	<i>No Color</i>
<i>2-3 Accum. Piston</i>	<i>8678474</i>	<i>Used On All Models</i>
<i>Spacer Plate And Gasket Assem.</i>	<i>8682085</i>	<i>Used On All Models</i>
<i>Accumulator Cover</i>	<i>8651533</i>	<i>Used On All Models</i>
<i>Accumulator Cover Bolts</i>	<i>8651722</i>	<i>Used On All Models</i>

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CHART NUMBER 13 (Assembly Number 24200236)

<i>Part Name</i>	<i>Part Number</i>	<i>Identification</i>
<i>Accumulator Housing</i>	<i>8677163</i>	<i>Used On All Models</i>
<i>1-2 Accum. Outer Spring</i>	<i>8682513</i>	<i>Dark Green</i>
<i>1-2 Accum Cushion Spring & Retainer</i>	<i>24200220</i>	<i>Top Of Piston, Retainer Up</i>
<i>1-2 Accum. Inner Spring</i>	<i>None Used</i>	<i>None Used</i>
<i>Accumulator Piston Seals</i>	<i>8678473</i>	<i>2 Required</i>
<i>1-2 Accum. Piston</i>	<i>8685227</i>	<i>"Bumps" On Top Of Piston</i>
<i>Accumulator Piston Pins</i>	<i>8644298</i>	<i>2 Required</i>
<i>2-3 Accum. Outer Spring</i>	<i>8668487</i>	<i>White/Lt Green</i>
<i>2-3 Accum. Inner Spring</i>	<i>8681456</i>	<i>No Color</i>
<i>2-3 Accum. Piston</i>	<i>8678474</i>	<i>Used On All Models</i>
<i>Spacer Plate And Gasket Assem.</i>	<i>8682085</i>	<i>Used On All Models</i>
<i>Accumulator Cover</i>	<i>8651533</i>	<i>Used On All Models</i>
<i>Accumulator Cover Bolts</i>	<i>8651722</i>	<i>Used On All Models</i>

"3RD DESIGN" Use Figure 4 For Assembly Procedure

CHART NUMBER 14 (Assembly Number 24200572)

<i>Part Name</i>	<i>Part Number</i>	<i>Identification</i>
<i>Accumulator Housing</i>	<i>8677163</i>	<i>Used On All Models</i>
<i>1-2 Accum. Outer Spring</i>	<i>8646400</i>	<i>White/Red</i>
<i>1-2 Accum Cushion Spring & Retainer</i>	<i>8685229</i>	<i>Top Of Piston, Retainer Up</i>
<i>1-2 Accum. Inner Spring</i>	<i>None Used</i>	<i>None Used</i>
<i>Accumulator Piston Seals</i>	<i>8678473</i>	<i>2 Required</i>
<i>1-2 Accum. Piston</i>	<i>8685227</i>	<i>"Bumps" On Top Of Piston</i>
<i>Accumulator Piston Pins</i>	<i>8644298</i>	<i>2 Required</i>
<i>2-3 Accum. Outer Spring</i>	<i>8668487</i>	<i>White/Lt Green</i>
<i>2-3 Accum. Inner Spring</i>	<i>8677661</i>	<i>Lt Green/Orange</i>
<i>2-3 Accum. Piston</i>	<i>8678474</i>	<i>Used On All Models</i>
<i>Spacer Plate And Gasket Assem.</i>	<i>8682085</i>	<i>Used On All Models</i>
<i>Accumulator Cover</i>	<i>8651533</i>	<i>Used On All Models</i>
<i>Accumulator Cover Bolts</i>	<i>8651722</i>	<i>Used On All Models</i>

"3RD DESIGN" Use Figure 4 For Assembly Procedure

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CHART NUMBER 15 (Assembly Number 24201826)

<i>Part Name</i>	<i>Part Number</i>	<i>Identification</i>
<i>Accumulator Housing</i>	<i>8677163</i>	<i>Used On All Models</i>
<i>1-2 Accum. Outer Spring</i>	<i>8649091</i>	<i>No Color Or Orange</i>
<i>1-2 Accum Cushion Spring & Retainer</i>	<i>24200220</i>	<i>Top Of Piston, Retainer Up</i>
<i>1-2 Accum. Inner Spring</i>	<i>None Used</i>	<i>None Used</i>
<i>Accumulator Piston Seals</i>	<i>8678473</i>	<i>2 Required</i>
<i>1-2 Accum. Piston</i>	<i>8685227</i>	<i>"Bumps" On Top Of Piston</i>
<i>Accumulator Piston Pins</i>	<i>8644298</i>	<i>2 Required</i>
<i>2-3 Accum. Outer Spring</i>	<i>8649091</i>	<i>No Color Or Orange</i>
<i>2-3 Accum. Inner Spring</i>	<i>8685218</i>	<i>White/Dk Blue</i>
<i>2-3 Accum. Piston</i>	<i>8678474</i>	<i>Used On All Models</i>
<i>Spacer Plate And Gasket Assem.</i>	<i>8682085</i>	<i>Used On All Models</i>
<i>Accumulator Cover</i>	<i>8651533</i>	<i>Used On All Models</i>
<i>Accumulator Cover Bolts</i>	<i>8651722</i>	<i>Used On All Models</i>

"3RD DESIGN" Use Figure 4 For Assembly Procedure

CHART NUMBER 16 (Assembly Number 24201454)

<i>Part Name</i>	<i>Part Number</i>	<i>Identification</i>
<i>Accumulator Housing</i>	<i>8677163</i>	<i>Used On All Models</i>
<i>1-2 Accum. Outer Spring</i>	<i>8649091</i>	<i>No Color Or Orange</i>
<i>1-2 Accum. Inner Spring</i>	<i>None Used</i>	<i>None Used</i>
<i>Accumulator Piston Seals</i>	<i>8678473</i>	<i>2 Required</i>
<i>1-2 Accum. Piston</i>	<i>8678474</i>	<i>Same As 2-3 Accum Piston</i>
<i>Accumulator Piston Pins</i>	<i>8644298</i>	<i>2 Required</i>
<i>2-3 Accum. Outer Spring</i>	<i>8668487</i>	<i>White/Lt Green</i>
<i>2-3 Accum. Inner Spring</i>	<i>8677661</i>	<i>Lt Green/Orange</i>
<i>2-3 Accum. Piston</i>	<i>8678474</i>	<i>Used On All Models</i>
<i>Spacer Plate And Gasket Assem.</i>	<i>8682085</i>	<i>Used On All Models</i>
<i>Accumulator Cover</i>	<i>8651533</i>	<i>Used On All Models</i>
<i>Accumulator Cover Bolts</i>	<i>8651722</i>	<i>Used On All Models</i>

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CHART NUMBER 17 (Assembly Number 24204014)

<i>Part Name</i>	<i>Part Number</i>	<i>Identification</i>
<i>Accumulator Housing</i>	<i>8677163</i>	<i>Used On All Models</i>
<i>1-2 Accum. Outer Spring</i>	<i>8682700</i>	<i>No Color</i>
<i>1-2 Accum. Inner Spring</i>	<i>8668631</i>	<i>Lt Green</i>
<i>Accumulator Piston Seals</i>	<i>8678473</i>	<i>2 Required</i>
<i>1-2 Accum. Piston</i>	<i>8678883</i>	<i>Goes In Upside Down</i>
<i>Accumulator Piston Pins</i>	<i>8644298</i>	<i>2 Required</i>
<i>2-3 Accum. Outer Spring</i>	<i>8668487</i>	<i>White/Lt Green</i>
<i>2-3 Accum. Inner Spring</i>	<i>8651774</i>	<i>White</i>
<i>2-3 Accum. Piston</i>	<i>8678474</i>	<i>Used On All Models</i>
<i>Spacer Plate And Gasket Assem.</i>	<i>8682085</i>	<i>Used On All Models</i>
<i>Accumulator Cover</i>	<i>8651533</i>	<i>Used On All Models</i>
<i>Accumulator Cover Bolts</i>	<i>8651722</i>	<i>Used On All Models</i>

"2ND DESIGN" Use Figure 3 For Assembly Procedure

CHART NUMBER 18 (Assembly Number 24204313)

<i>Part Name</i>	<i>Part Number</i>	<i>Identification</i>
<i>Accumulator Housing</i>	<i>8677163</i>	<i>Used On All Models</i>
<i>1-2 Accum. Outer Spring</i>	<i>8668487</i>	<i>White/Lt Green</i>
<i>1-2 Accum Cushion Spring & Retainer</i>	<i>8685229</i>	<i>Top Of Piston, Retainer Up</i>
<i>1-2 Accum. Inner Spring</i>	<i>None Used</i>	<i>None Used</i>
<i>Accumulator Piston Seals</i>	<i>8678473</i>	<i>2 Required</i>
<i>1-2 Accum. Piston</i>	<i>8685227</i>	<i>"Bumps" On Top Of Piston</i>
<i>Accumulator Piston Pins</i>	<i>8644298</i>	<i>2 Required</i>
<i>2-3 Accum. Outer Spring</i>	<i>8685219</i>	<i>White/Pink</i>
<i>2-3 Accum. Inner Spring</i>	<i>8685218</i>	<i>White/Dk Blue</i>
<i>2-3 Accum. Piston</i>	<i>8678474</i>	<i>Used On All Models</i>
<i>Spacer Plate And Gasket Assem.</i>	<i>8682085</i>	<i>Used On All Models</i>
<i>Accumulator Cover</i>	<i>8651533</i>	<i>Used On All Models</i>
<i>Accumulator Cover Bolts</i>	<i>8651722</i>	<i>Used On All Models</i>

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CHART NUMBER 19 (Assembly Number 24204045)

<i>Part Name</i>	<i>Part Number</i>	<i>Identification</i>
<i>Accumulator Housing</i>	<i>8677163</i>	<i>Used On All Models</i>
<i>1-2 Accum. Outer Spring</i>	<i>8682513</i>	<i>Dark Green</i>
<i>1-2 Accum Cushion Spring & Retainer</i>	<i>8685229</i>	<i>Top Of Piston, Retainer Up</i>
<i>1-2 Accum. Inner Spring</i>	<i>None Used</i>	<i>None Used</i>
<i>Accumulator Piston Seals</i>	<i>8678473</i>	<i>2 Required</i>
<i>1-2 Accum. Piston</i>	<i>8685227</i>	<i>"Bumps" On Top Of Piston</i>
<i>Accumulator Piston Pins</i>	<i>8644298</i>	<i>2 Required</i>
<i>2-3 Accum. Outer Spring</i>	<i>8649091</i>	<i>No Color Or Orange</i>
<i>2-3 Accum. Inner Spring</i>	<i>8685218</i>	<i>White/Dk Blue</i>
<i>2-3 Accum. Piston</i>	<i>8678474</i>	<i>Used On All Models</i>
<i>Spacer Plate And Gasket Assem.</i>	<i>8682085</i>	<i>Used On All Models</i>
<i>Accumulator Cover</i>	<i>8651533</i>	<i>Used On All Models</i>
<i>Accumulator Cover Bolts</i>	<i>8651722</i>	<i>Used On All Models</i>

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CHART NUMBER 20 (Assembly Number 24203618)

<i>Part Name</i>	<i>Part Number</i>	<i>Identification</i>
<i>Accumulator Housing</i>	<i>8677163</i>	<i>Used On All Models</i>
<i>1-2 Accum. Outer Spring</i>	<i>8649091</i>	<i>No Color Or Orange</i>
<i>1-2 Accum Cushion Spring & Retainer</i>	<i>8685229</i>	<i>Top Of Piston, Retainer Up</i>
<i>1-2 Accum. Inner Spring</i>	<i>None Used</i>	<i>None Used</i>
<i>Accumulator Piston Seals</i>	<i>8678473</i>	<i>2 Required</i>
<i>1-2 Accum. Piston</i>	<i>8685227</i>	<i>"Bumps" On Top Of Piston</i>
<i>Accumulator Piston Pins</i>	<i>8644298</i>	<i>2 Required</i>
<i>2-3 Accum. Outer Spring</i>	<i>8668487</i>	<i>White/Lt Green</i>
<i>2-3 Accum. Inner Spring</i>	<i>8677661</i>	<i>Lt Green/Orange</i>
<i>2-3 Accum. Piston</i>	<i>8678474</i>	<i>Used On All Models</i>
<i>Spacer Plate And Gasket Assem.</i>	<i>8682085</i>	<i>Used On All Models</i>
<i>Accumulator Cover</i>	<i>8651533</i>	<i>Used On All Models</i>
<i>Accumulator Cover Bolts</i>	<i>8651722</i>	<i>Used On All Models</i>

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CHART NUMBER 21 (Assembly Number 24205108)

<i>Part Name</i>	<i>Part Number</i>	<i>Identification</i>
<i>Accumulator Housing</i>	<i>8677163</i>	<i>Used On All Models</i>
<i>1-2 Accum. Outer Spring</i>	<i>8682513</i>	<i>Dark Green</i>
<i>1-2 Accum Cushion Spring & Retainer</i>	<i>8685229</i>	<i>Top Of Piston, Retainer Up</i>
<i>1-2 Accum. Inner Spring</i>	<i>None Used</i>	<i>None Used</i>
<i>Accumulator Piston Seals</i>	<i>8678473</i>	<i>2 Required</i>
<i>1-2 Accum. Piston</i>	<i>8685227</i>	<i>"Bumps" On Top Of Piston</i>
<i>Accumulator Piston Pins</i>	<i>8644298</i>	<i>2 Required</i>
<i>2-3 Accum. Outer Spring</i>	<i>8685219</i>	<i>White/Pink</i>
<i>2-3 Accum. Inner Spring</i>	<i>8685218</i>	<i>White/Dk Blue</i>
<i>2-3 Accum. Piston</i>	<i>8678474</i>	<i>Used On All Models</i>
<i>Spacer Plate And Gasket Assem.</i>	<i>8682085</i>	<i>Used On All Models</i>
<i>Accumulator Cover</i>	<i>8651533</i>	<i>Used On All Models</i>
<i>Accumulator Cover Bolts</i>	<i>8651722</i>	<i>Used On All Models</i>

"3RD DESIGN" Use Figure 4 For Assembly Procedure

CHART NUMBER 22 (Assembly Number 24208179)

<i>Part Name</i>	<i>Part Number</i>	<i>Identification</i>
<i>Accumulator Housing</i>	<i>8677163</i>	<i>Used On All Models</i>
<i>1-2 Accum. Outer Spring</i>	<i>8682701</i>	<i>Lt Brown</i>
<i>1-2 Accum. Inner Spring</i>	<i>8668631</i>	<i>Lt Green</i>
<i>Accumulator Piston Seals</i>	<i>8678473</i>	<i>2 Required</i>
<i>1-2 Accum. Piston</i>	<i>8668883</i>	<i>Goes In Upside Down</i>
<i>Accumulator Piston Pins</i>	<i>8644298</i>	<i>2 Required</i>
<i>2-3 Accum. Outer Spring</i>	<i>8668487</i>	<i>White/Lt Green</i>
<i>2-3 Accum. Inner Spring</i>	<i>8651774</i>	<i>White</i>
<i>2-3 Accum. Piston</i>	<i>8678474</i>	<i>Used On All Models</i>
<i>Spacer Plate And Gasket Assem.</i>	<i>8682085</i>	<i>Used On All Models</i>
<i>Accumulator Cover</i>	<i>8651533</i>	<i>Used On All Models</i>
<i>Accumulator Cover Bolts</i>	<i>8651722</i>	<i>Used On All Models</i>

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CHART NUMBER 23 (Assembly Number 24207199)

<i>Part Name</i>	<i>Part Number</i>	<i>Identification</i>
<i>Accumulator Housing</i>	<i>8677163</i>	<i>Used On All Models</i>
<i>1-2 Accum. Outer Spring</i>	<i>8646400</i>	<i>White/Red</i>
<i>1-2 Accum. Inner Spring</i>	<i>None Used</i>	<i>None Used</i>
<i>Accumulator Piston Seals</i>	<i>8678473</i>	<i>2 Required</i>
<i>1-2 Accum. Piston</i>	<i>8678474</i>	<i>Same As 2-3 Accum Piston</i>
<i>Accumulator Piston Pins</i>	<i>8644298</i>	<i>2 Required</i>
<i>2-3 Accum. Outer Spring</i>	<i>8668487</i>	<i>White/Lt Green</i>
<i>2-3 Accum. Inner Spring</i>	<i>8677661</i>	<i>Lt Green/Orange</i>
<i>2-3 Accum. Piston</i>	<i>8678474</i>	<i>Used On All Models</i>
<i>Spacer Plate And Gasket Assem.</i>	<i>8682085</i>	<i>Used On All Models</i>
<i>Accumulator Cover</i>	<i>8651533</i>	<i>Used On All Models</i>
<i>Accumulator Cover Bolts</i>	<i>8651722</i>	<i>Used On All Models</i>

"1ST DESIGN" Use Figure 2 For Assembly Procedure

CHART NUMBER 24 (Assembly Number 24210277)

<i>Part Name</i>	<i>Part Number</i>	<i>Identification</i>
<i>Accumulator Housing</i>	<i>8677163</i>	<i>Used On All Models</i>
<i>1-2 Accum. Outer Spring</i>	<i>8682701</i>	<i>Lt Brown</i>
<i>1-2 Accum. Inner Spring</i>	<i>8668631</i>	<i>Lt Green</i>
<i>Accumulator Piston Seals</i>	<i>8678473</i>	<i>2 Required</i>
<i>1-2 Accum. Piston</i>	<i>8668883</i>	<i>Goes In Upside Down</i>
<i>Accumulator Piston Pins</i>	<i>8644298</i>	<i>2 Required</i>
<i>2-3 Accum. Outer Spring</i>	<i>8682513</i>	<i>Dark Green</i>
<i>2-3 Accum. Inner Spring</i>	<i>8681456</i>	<i>No Color</i>
<i>2-3 Accum. Piston</i>	<i>8678474</i>	<i>Used On All Models</i>
<i>Spacer Plate And Gasket Assem.</i>	<i>8682085</i>	<i>Used On All Models</i>
<i>Accumulator Cover</i>	<i>8651533</i>	<i>Used On All Models</i>
<i>Accumulator Cover Bolts</i>	<i>8651722</i>	<i>Used On All Models</i>

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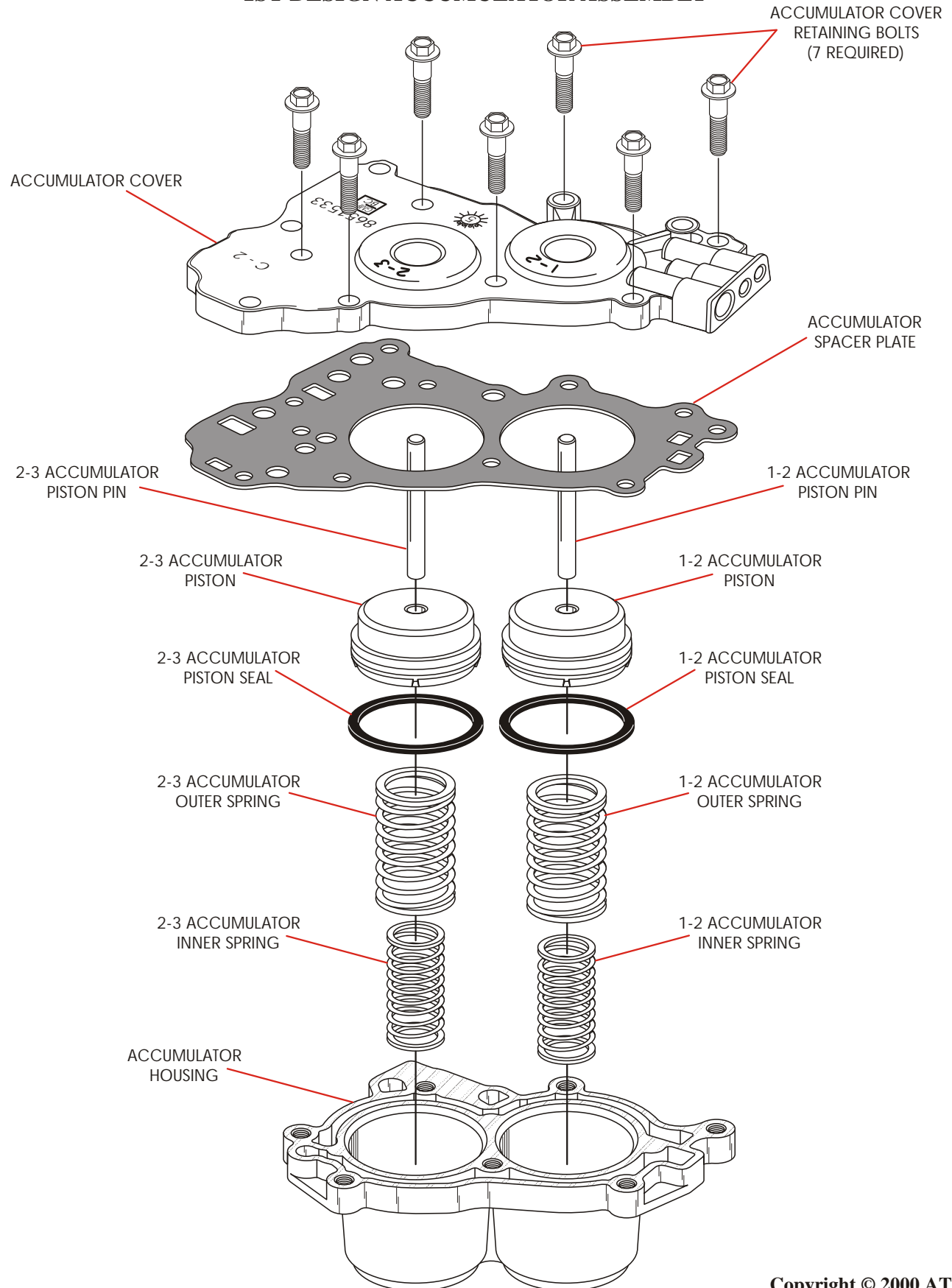
CHART NUMBER 25 (Assembly Number 24210296)

<i>Part Name</i>	<i>Part Number</i>	<i>Identification</i>
<i>Accumulator Housing</i>	<i>8677163</i>	<i>Used On All Models</i>
<i>1-2 Accum. Outer Spring</i>	<i>8646400</i>	<i>White/Red</i>
<i>1-2 Accum. Inner Spring</i>	<i>8651774</i>	<i>White</i>
<i>Accumulator Piston Seals</i>	<i>8678473</i>	<i>2 Required</i>
<i>1-2 Accum. Piston</i>	<i>8678474</i>	<i>Same As 2-3 Accum Piston</i>
<i>Accumulator Piston Pins</i>	<i>8644298</i>	<i>2 Required</i>
<i>2-3 Accum. Outer Spring</i>	<i>8685219</i>	<i>White/Pink</i>
<i>2-3 Accum. Inner Spring</i>	<i>8651774</i>	<i>White</i>
<i>2-3 Accum. Piston</i>	<i>8678474</i>	<i>Used On All Models</i>
<i>Spacer Plate And Gasket Assem.</i>	<i>8682085</i>	<i>Used On All Models</i>
<i>Accumulator Cover</i>	<i>8651533</i>	<i>Used On All Models</i>
<i>Accumulator Cover Bolts</i>	<i>8651722</i>	<i>Used On All Models</i>

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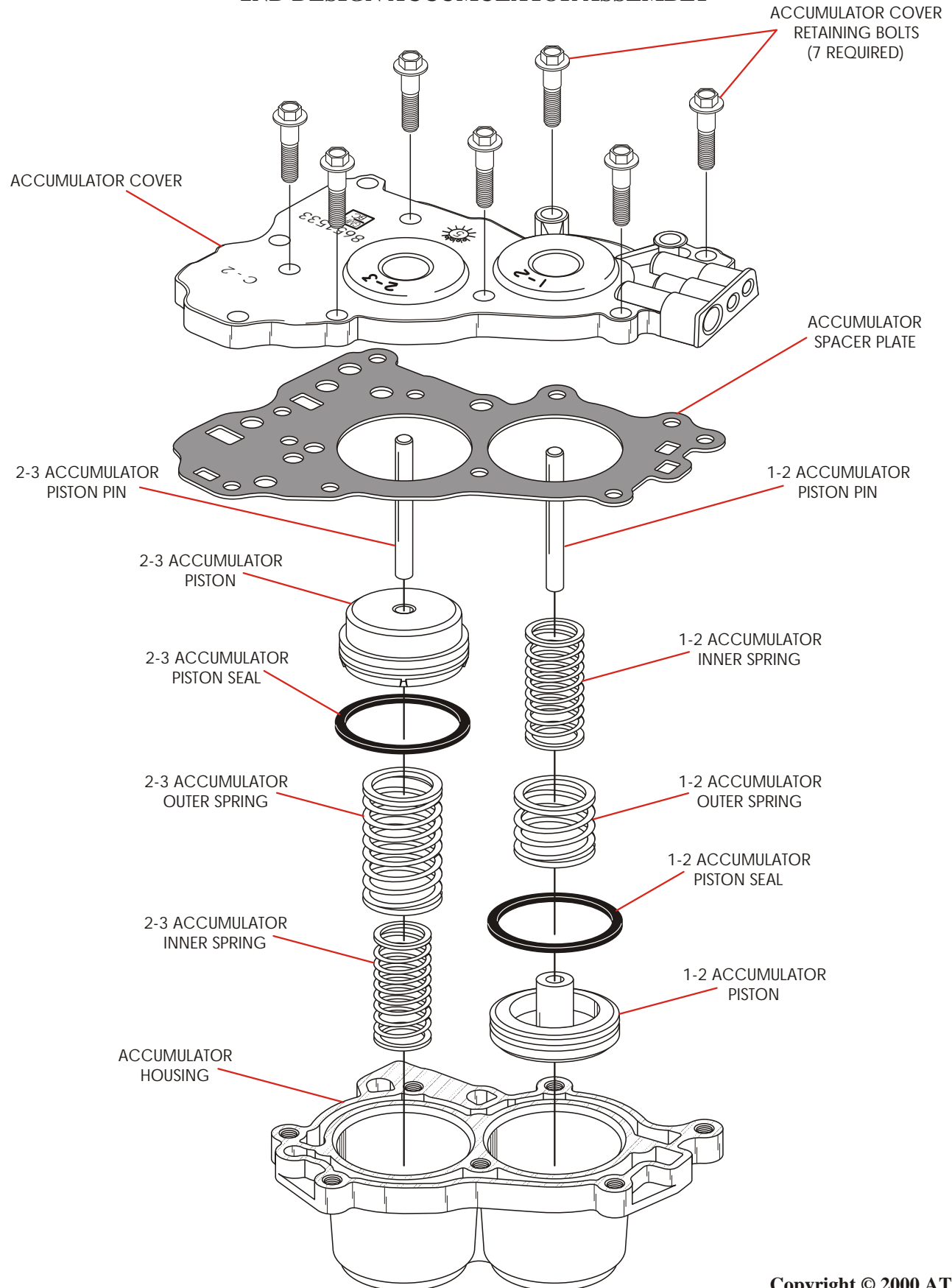
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Figure 2

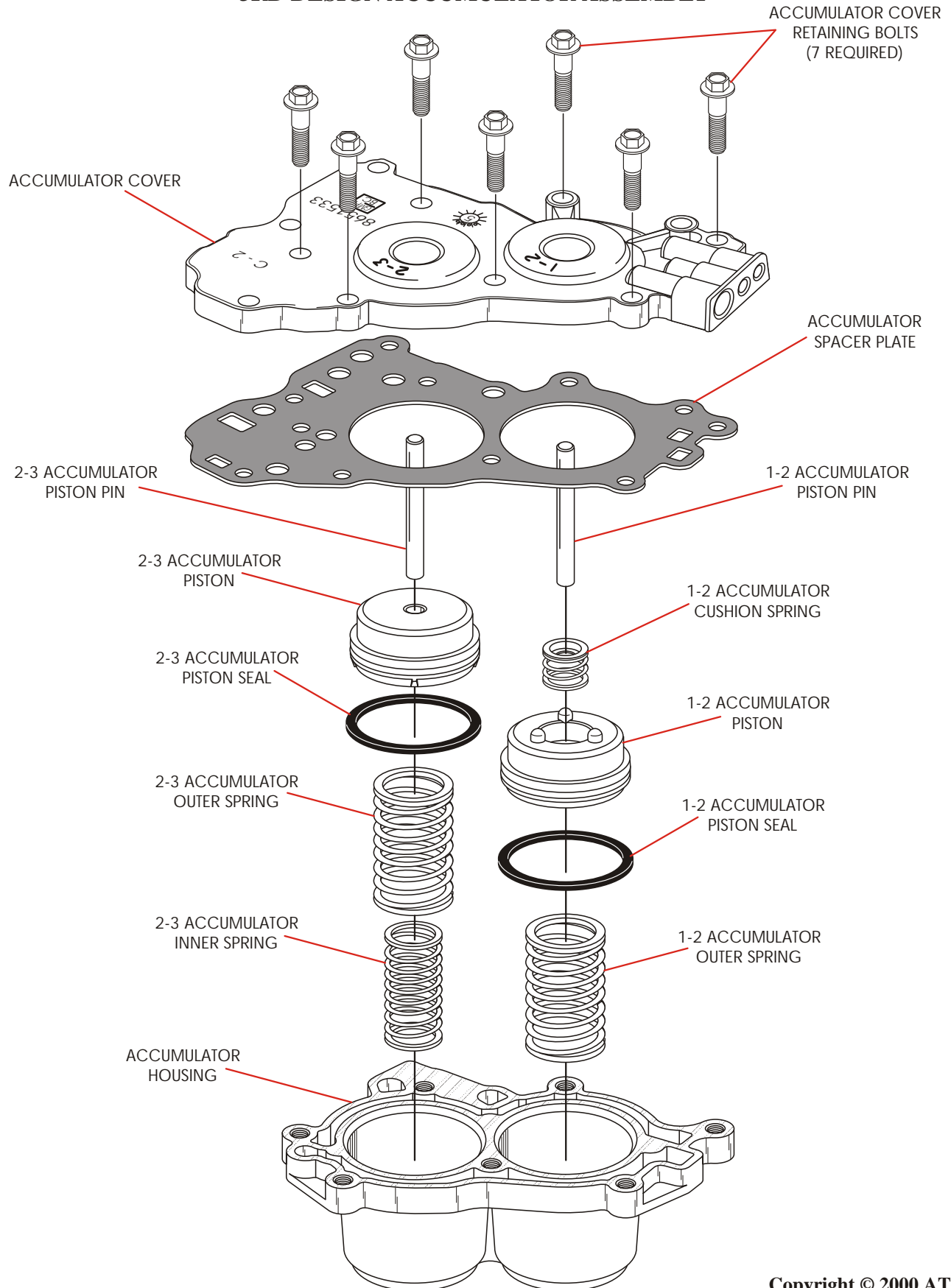
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Figure 3

3RD DESIGN ACCUMULATOR ASSEMBLY



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Figure 4