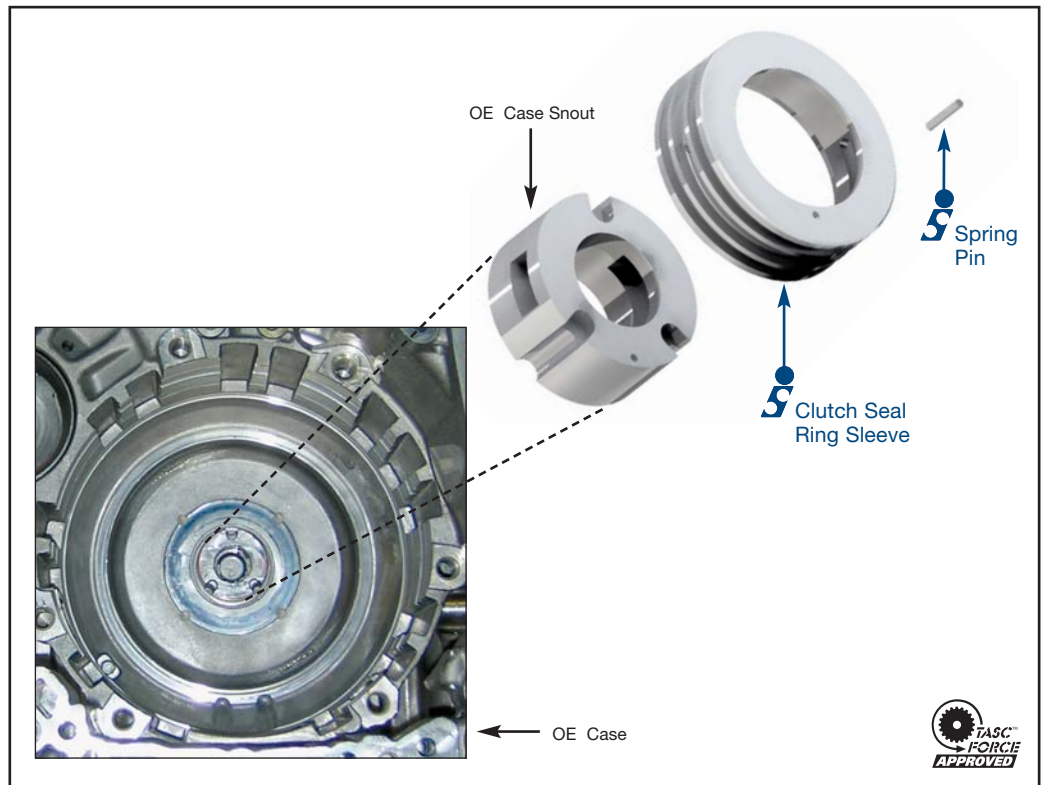


K-2 Clutch Seal Ring Sleeve

15759-01K

1 Clutch Seal Ring Sleeve
1 Spring Pin

Note: Fits BMW (6F21A) and
VW/Audi (09G, 09K, 09M).



Disassembly:

If the OE sleeve is not loose, heat the steel sleeve and remove it.

Installation Sleeve:

1. Index the case, so the valve body location and the two ports to lube and K-2 clutch will be at 6:00.
2. Place an ink mark across the aluminum casting (9:00 to 3:00) to identify the location of the feed slots (see Figure 1).
3. Place a similar mark across the Sonnax sleeve (see Figure 2).
4. If you chose to use Loctite or similar sealant, clean/prep both the case and the sleeve.
5. Apply sealant to the case.
6. Prepare your press and case fixture, prior to heating the sleeve.



Figure 1

Place ink marks on the aluminum casting at 9:00 & 3:00 to line up with feed slots.

7. Pre-heat the sleeve to 150 to 175°F (65.5 – 79.4c.).
8. Index the sleeve so your ink marks will lay over the case marks and the anti-spin pin, will be at 6:00 position (see Figure 2).
9. Start the sleeve by tapping it down, to insure it starts straight.
10. Then support the back of the case and using a press, continue until the flange on the sleeve has bottomed on the aluminum tower. This takes some force.

Installation Anti-Spin Pin:

1. Using the hole as a guide, drill a .062" (1.58mm) hole to depth of .380" (9.65mm).

Note: This guide hole should be at the 6:00 o'clock position!

2. Drive in the pin, until flush and remove any burrs at the pin area.

Final Verification Steps:

Air Test

Verify the sleeve is installed properly by air testing the lube & K-2 ports.

Using Soap Solution

If you supply air into lube and plug the bushing area, there should not be cross leakage into K-2 or around the base of the sleeve.

Using ATF

Install assembled K-2 drum. Supply air/ATF into K-2 circuit. Should not have cross leak into lube circuit.



Figure 2

Line up ink marks on aluminum casting and Sonnax sleeve, keeping the anti-spin pinhole at the 6:00 position.