

## COMPLAINT

Many worn servo pin bores cannot be repaired

## CAUSE

Many case servo pin bores sustain scoring and wear damage, but it has not been possible to index or fixture tooling as required to repair a wide variety of servo bores.

## CORRECTION

The Sonnax servo pin bore reaming fixture has been designed to provide a highly adaptable rigid mounting method that will locate and maintain the correct tool positioning required to repair servo pin bores in a wide range of transmissions.

## Servo Pin Bore Reaming Fixture

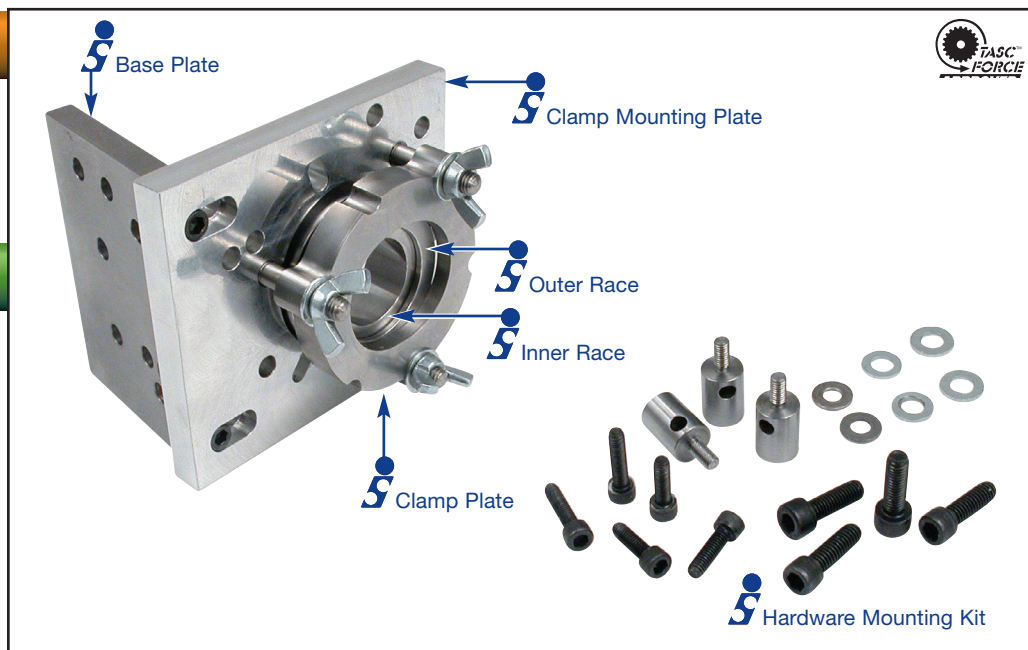
### SERVO-FIX

- 1 Base Plate
- 1 Clamp Mounting Plate
- 1 Clamp Plate
- 2 Outer Races
- 1 Inner Race
- 3 Studs
- 3 Washers
- 3 Wing Nuts
- 1 Hardware Mounting Kit

Patent Pending



Sonnax has designed special tool kits to service a specific servo pin bore, and they must be used in conjunction with the Servo Pin Bore Reaming Fixture, **SERVO-FIX**. Part numbers for these specially designed tool kits begin with an "S" to distinguish them from both the F-series tools that work with the **VB-FIX**, and the traditional Sonnax tool kits that can be used as standalone tools.



### Sonnax Part Summary

Wear and scoring of servo pin bores is a common problem in many automatic transmissions. In many instances, shift concerns and part failures due to leakage caused by the wear could only be corrected by replacing the case, because there was no way to locate and maintain tool concentricity with the pin bore centerline. The Sonnax servo pin bore reaming fixture establishes a rigid pilot for bore repair tooling. The fixture mounts to the case, and has a floating bearing guide to ensure proper pin centerline. This tool pilots off the OEM pin bore, so reaming is not affected by irregular piston or seal concentricity issues. The **SERVO-FIX** has been designed to offer a variety of mounting options for a wide range of transmission cases and multiple bores for each case, where required. Special tooling has been designed to work with the fixture to prepare the bore for whichever bore repair kit is required for the individual servo bore being serviced.

### Features & Benefits

- One rigid fixture adapts to many cases and applications.
- Pilot and reamer align from pin bore centerline, not servo piston bore.
- Salvages expensive cases.

**Pin bore repair sleeve kits and special tool kits have been designed for use with this fixture in a variety of applications:**

- 5R55N/W/S Overdrive & Intermediate Servo Repair Sleeves: **56361J-01K** & **S-56361J-TL**
- AODE, 4L30-E, 180 Master Servo Sleeve Kit: **76890-24K\*** & **S-76890-TL24\***  
AODE: Overdrive Servo Sleeve Kit  
4L30-E: 1-2 Servo Sleeve Kit  
180: Low Servo Sleeve Kit
- AXOD & E, AX4S & N, 4F50N Overdrive Servo Sleeve Kit: **96872-01K\*** & **S-96872-TL\***

*\* Available 2008*