PART NUMBERS 75921-01K, 75921-02K, 75921-03K

# **Replacement Accumulator Piston and Pins**

### 75921-01K

1 Standard Accumulator Piston 1 Standard Accumulator Pin



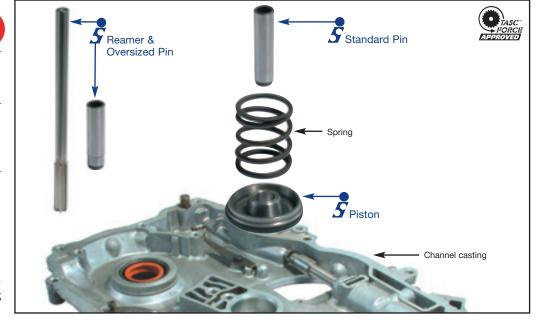
### 75921-02K

4 Oversized Accumulator Pins

# 75921-03K

10 Oversized Accumulator Pins

1 Reamer



# 75921-01K Instructions

Replace the worn piston and pin with the Sonnax kit, following standard rebuild procedures.

#### 75921-02K & -03K Instructions

- 1. Remove OEM accumulator pin and piston from the channel plate casting. Discard the OEM pin.
- 2. Chuck the piston in a lathe or clamp in a drill press vise on the 1.600" diameter (see Figure 1).
- 3. Feed the reamer into the piston from the side opposite the spring pocket. Allow the exsisting chamfer to guide the reamer into the bore (see Figure 2).
- 4. It is recommended to use 500-700 RPM spindle speed. Use plenty of cutting fluid and a steady feed rate. It should take between 30-45 seconds to ream this bore.
- 5. Inspect reamed bore. Make sure that the reamer cleaned all the bore surfaces. If this bore did not clean completely the OEM piston was too worn to be salvaged.
- 6. If required, buff the bore using a 320 grit emery cloth on a slotted rod to get a better surface finish (see Figure 3).
- 7. Install the oversized accumulator pin into the channel casting. The smaller pin diameter goes into the case and the larger diameter fits the piston.
- 8. Install the piston, seal, and spring following normal rebuilding procedures.





