AXOD & E AX4N, AX4S, 4F50N

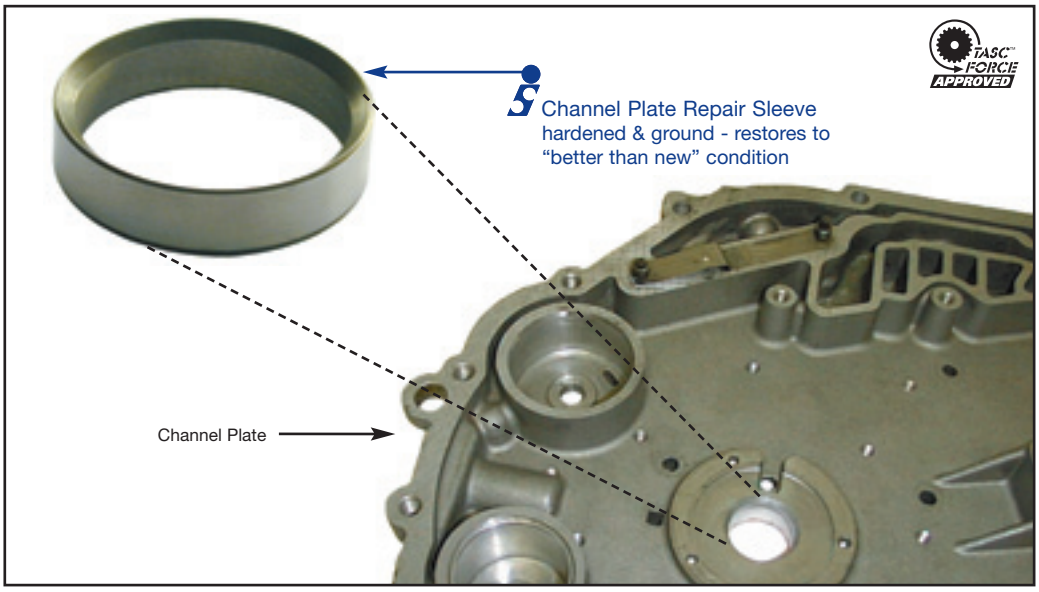
PART NUMBER **96803**

Channel Plate Repair Sleeve

96803

5 Repair Sleeves

Note: This repair sleeve requires machining.



Also Available:

Accumulator Bore Sleeve Kits

96511K (N-D) AXOD & E, AX4S only
96512K (3-4) All applications
96513K (1-2) AXOD & E, AX4S only

Each kit includes the following

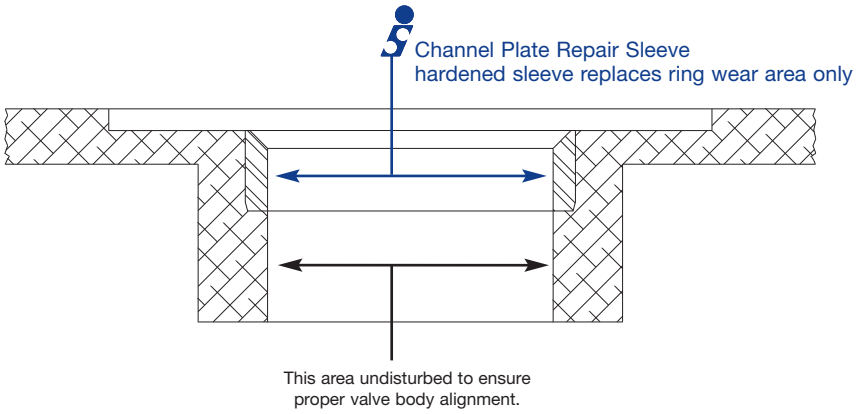
1 Sleeve
1 Piston
1 Viton® O-Ring

965123K

1 each of the kits above

Required Tools

Bridgeport type milling machine, 2-inch precision boring head, carbide-tipped boring bar, pair of 1-2-3 blocks, toe clamp set, indicol indicator holder, tenth reading test indicator, depth micrometer, bore gauge, 1.1562 (1 1/32) inch diameter ring gauge, solvent, Loctite® 609.



Instructions

1. With 1-2-3 blocks supporting the chain cover, toe clamp the chain cover to the mill table, case mounting surface side up.
2. Using the tenth reading indicator, align the mill spindle within .0005 inches TIR to the seal bore. Make certain the indicated surface is not worn.
3. Counterbore the seal bore to a diameter of 1.1562-1.1567 inches and a depth of .276-.286 inches. Inside radius at bottom of counterbore not to exceed .01 inches. Requires a sharp carbide boring bar and a fine feed rate to maintain size tolerance.
4. Remove machining burrs and break the top edge corner, .01 inches maximum. Thoroughly clean the repair sleeve and counterbore surfaces with a solvent compatible with Loctite® use.
5. Apply Loctite 609® retaining compound to O.D. of sleeve. With sleeve I.D. chamfer facing up, press sleeve into place with mill spindle. Wipe off excess Loctite 609®.

96803 Rev:A, 96511K Rev:-, 96512K Rev:-, 96513K Rev:-, 965123K Rev:-, 96803(in) 04-04-07
800-843-2600 • 802-463-9722 • F: 802-463-4059 • www.sonnax.com • info@sonnax.com