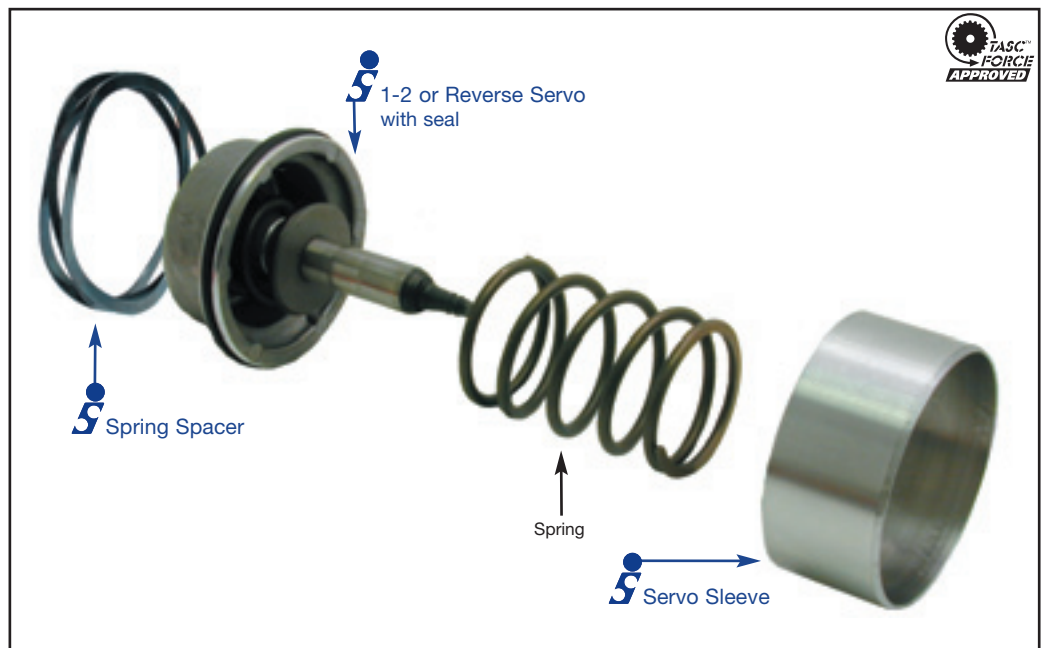


## 1-2 or Reverse Servo & Sleeve Kit

### 84791-01K

4T60: 1-2 or reverse servo  
4T60-E: Reverse servo only

- 1 Servo Sleeve
- 1 Servo Piston
- 1 Seal
- 1 Spring Spacer



### Instructions

Warning: Do not insert servo sleeve into case until it is ready to be installed. The sleeve is a precision fit with the case bore and may slide in and then bind and be very difficult to remove.

1. Before you install the kit, you need to preset the seal on the servo piston, install the Sonnax seal ring into the groove on the Sonnax servo piston, and then let it set inside the Sonnax sleeve for about 15 minutes.
2. Machine a small amount of material from the old servo piston so that the old piston can be used to drive the new sleeve into the case (see illustration).
3. Remove any burrs or raised areas from the servo bore, and lightly scrub with 120/150 abrasive cloth to provide the proper surface finish for the Loctite®.  
Note: There is no need to buff or polish the O.D. of the sleeve. It has the proper surface finish of 16 Ra.
4. Clean entire servo bore and remove all oil residue with a solvent that is Loctite® compatible.
5. Remove the piston/seal assembly from the sleeve.
6. Apply an even coat of Loctite® sleeve retainer #609 (green) or #660 (silver) to both the servo bore and to the outside of the servo sleeve, following Loctite® instructions on application of Loctite®.
7. Install the Sonnax sleeve in the case (chamfer end first), press the sleeve into the case using the modified old piston until the end of the sleeve makes contact with the bottom of the bore.
8. Remove residual Loctite®.
9. Assemble spring retainer on end of large spring
  - a. Install into the servo piston (piston cavity in the up position).
  - b. Drop small spring inside of large spring.
  - c. Add the washer to the pin (hub up).
  - d. Insert pin into servo piston.
  - e. Install clip on the end of the pin. This should hold everything together.
  - f. Lubricate the Sonnax sleeve and the Sonnax seal ring and with Transjel™.
  - g. Install this assembly into the case.
  - h. Add the Sonnax spring spacer, the cover and retaining ring.
10. Allow to cure according to Loctite® instructions.

# 4T60 & E

PART NUMBER 84791-01K

**1-2 or Reverse Servo & Sleeve Kit**

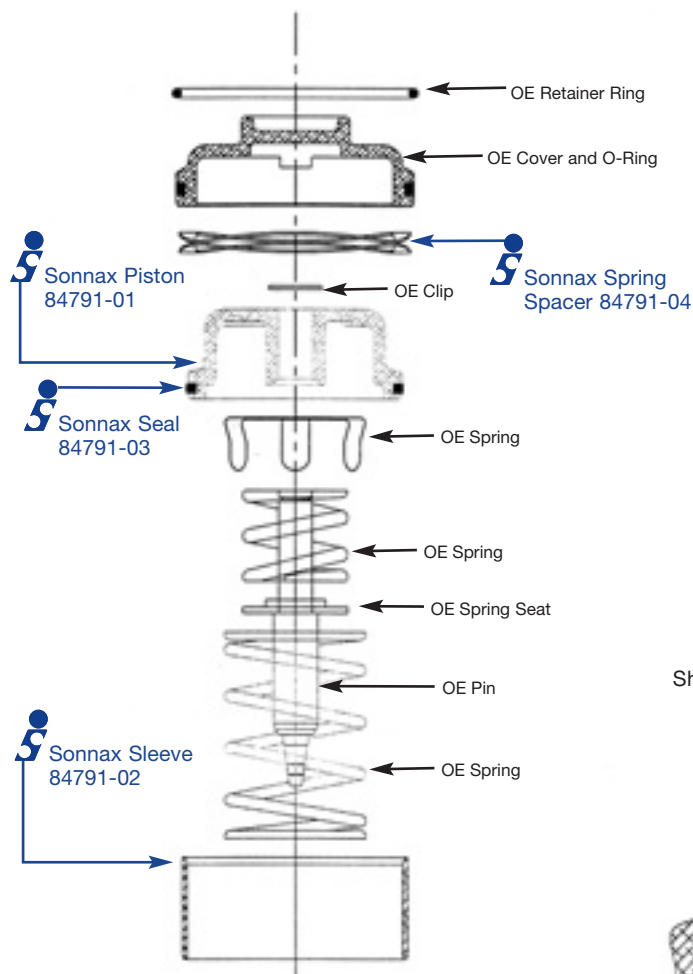
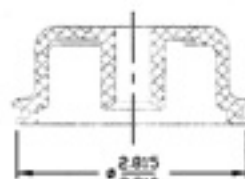


Illustration of machining old piston

For use as installation tool



Shown with old piston in sleeve

