4L80-E & 400

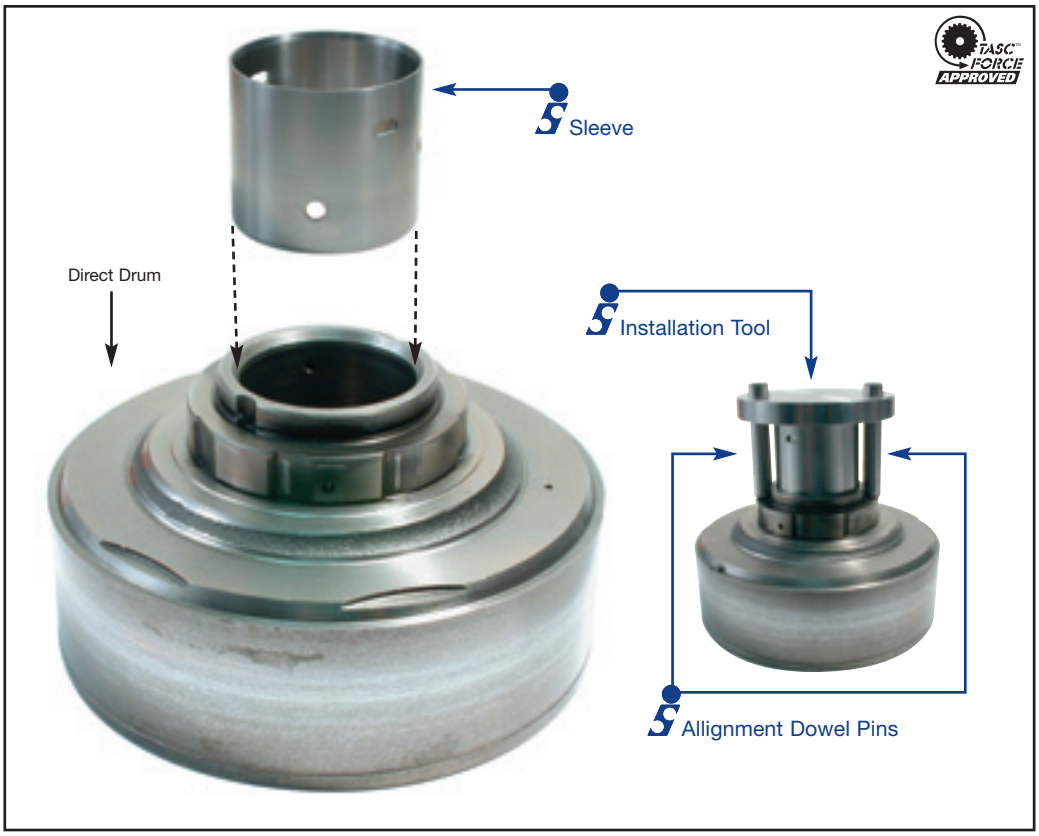
Part Number 34838-01K

Direct Drum Sleeve

34838-01K
1 Sleeve
1 Spring Pin

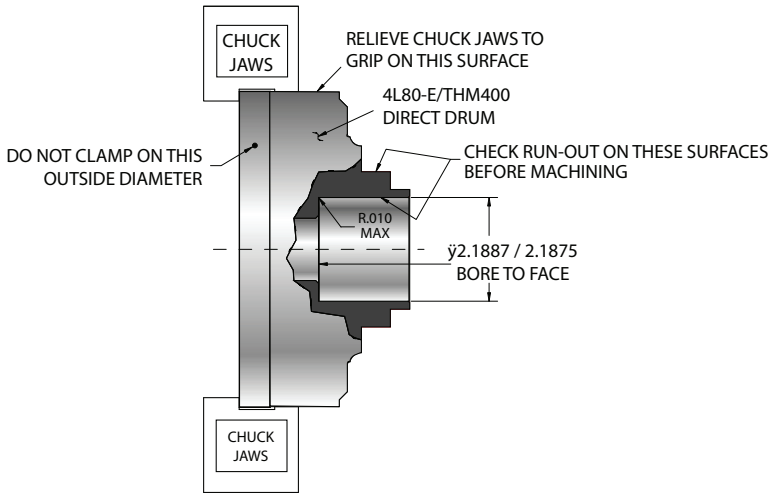
34838-TL
1 Sleeve Press/Installation Tool
2 Alignment/Dowel Pins

Note: Use of the installation tool is not required but is recommended.



Machining Instructions:

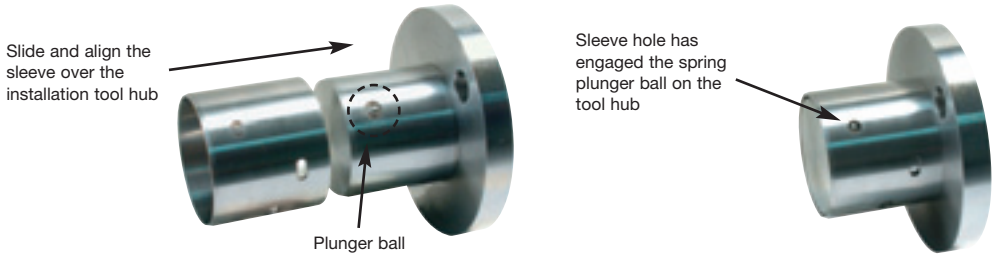
1. Fixture the direct drum in a 3-jaw chuck, with the center support bore facing outward.
2. Using a .0005" reading test indicator, check the run-out of the drum on both the bore and the race surface. The run-out of the drum installed in the lathe must be less than .001" TIR. If the observed run-out is greater than .001" TIR, align the chuck or refixture the drum as necessary.
3. Turn the worn drum bore to a diameter of 2.1875/2.1887 inches. The resized bore must have a 63-microinch or better surface finish.



Installation Instructions:

NOTE: Use of the Sonnax sleeve installation tool is recommended to ensure proper alignment of the sleeve in the bore.

1 Slide and align the sleeve over the installation tool hub until the .218" diameter sleeve hole has engaged the spring plunger ball on the tool hub, as shown in the figure below.



2. Place the two .500" diameter alignment pins vertically on the direct drum so that they are mated with the machined crescents on the direct drum as shown in Figure 1.
3. Locate the 3rd/reverse apply orifice in the drum, which will be aligned with one of the machined crescents.
4. Holding the sleeve/tool assembly over the drum bore, sleeve side down, rotate the tool until the spring plunger ball is aligned with the 3rd/reverse apply orifice. The holes in the tool hub should now be aligned with the two dowel pins.
5. Using an arbor press and pressing directly on the installation tool, install the repair sleeve into the drum.
6. The installation tool flange should bottom against the drum hub surface. Remove the installation tool.
7. After installing the new sleeve, drill a 1/16" x .525" - .535" deep hole between the sleeve O.D. and the direct drum I.D. Apply a drop of Loctite™ into the hole and then press in the spring pin provided. The spring pin must be flush or below with the carrier surface.
8. Ensure the hole is deeper than the spring pin and the pin does not install with excess force. If it does, the sleeve may deform in that area.

Figure 1

Align pins vertically on the direct drum so that they are mated with the machined crescents on the direct drum.

Sleeve Surface Finish:

If using Teflon® piston rings, the sleeve surface finish is correct as supplied.

If using either cast iron or Peek® piston-rings, the sleeve surface finish should be roughened slightly. Using Scotchbrite™, mar the surface to obtain the equivalent of a 63-microinch surface finish.