

## 2nd Apply Servo Saver Sleeve & Piston Bore Seal

### 77911-01

5 Servo Saver Sleeves

### 77911-02

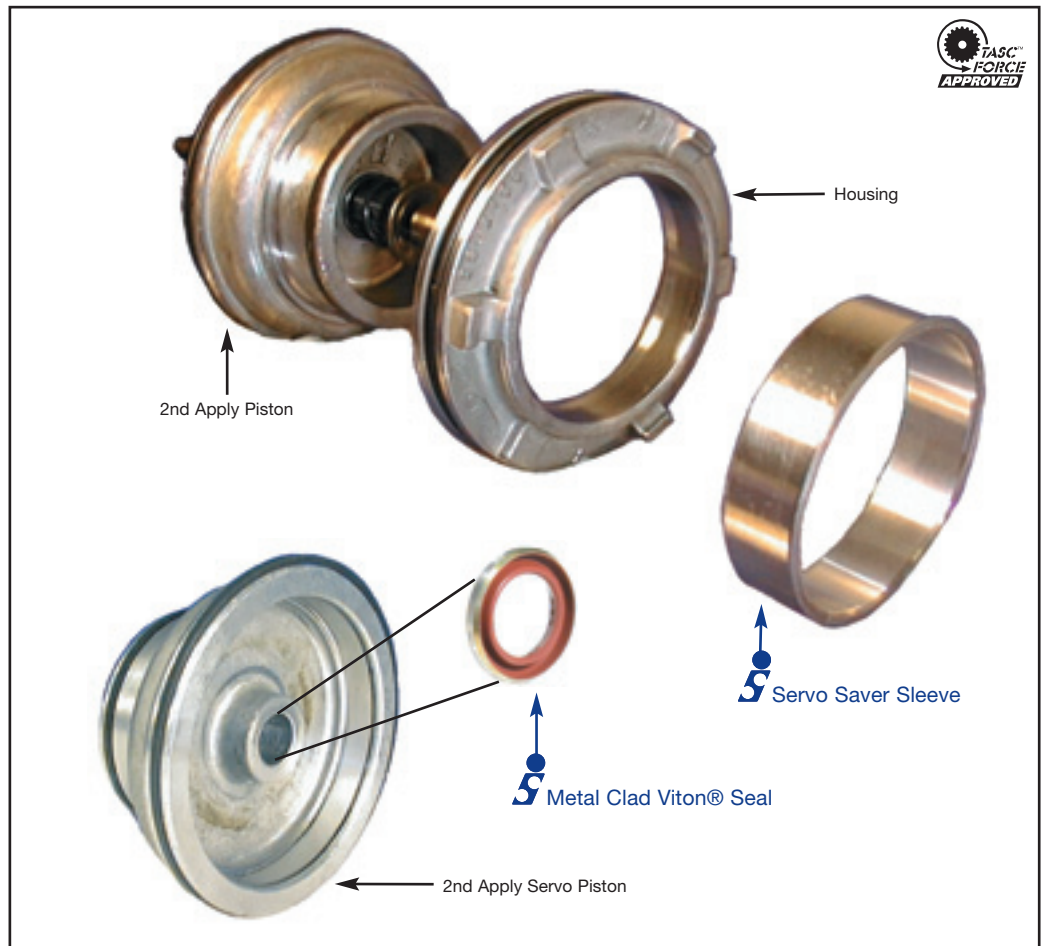
5 Metal Clad Viton® Seals

Also Available:

**77754-01K**

**77754-02K**

Accumulator Pin Kits



### Sonnax Part Summary Cont.

Complaints of no 3rd gear, 2-4 band applying in 3rd gear, and burned clutches and bands can be caused by normal wear at the 2nd apply servo piston at the steel pin area. Sonnax offers a press-in metal clad Viton® seal, 77911-02, that will restore the hydraulic integrity at the piston/pin interface. This will prevent 3rd accumulator oil from exhausting past a worn piston. Slight machining of the servo piston is necessary to accommodate the seal.

### Installation Instructions for Servo Saver Sleeve

To convert a #554 Servo Assembly to a #553 Version:

1. Chuck the #554 piston in a lathe, assuring that the 2.484" journal diameter is properly centered and has minimal total runout.
2. Machine the 2.484" original journal diameter to the new 2.300"/2.290" diameter.
3. Machine the original seal groove diameter to 2.150"/2.146".
4. Press the Sonnax Servo Saver Sleeve into the #554 inner housing, as shown. Loctite™ may be used for added security.
5. Verify that the pressed-in sleeve is flush with inner housing surfaces or the piston may bind.

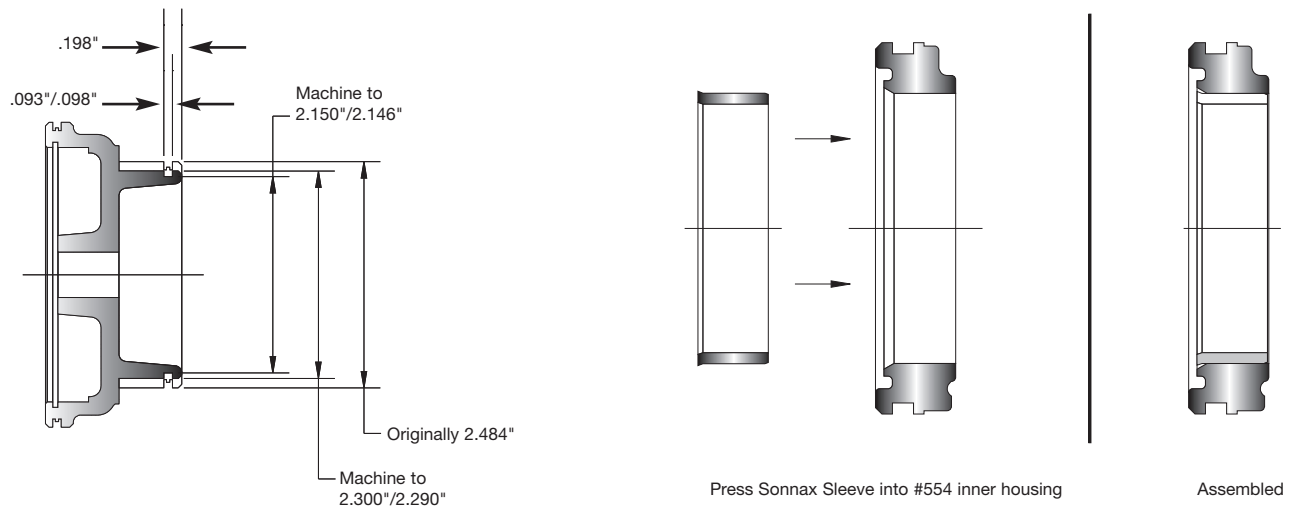
**Note:** A 440 driven gear makes a nice installation tool.

# 4L60 & E

PART NUMBERS 77911-01, 77911-02

## 2nd Apply Servo Saver Sleeve & Piston Bore Seal

### 2nd Apply Servo Saver Sleeve



### Installation Instructions for Viton Seal

1. Locating from the existing bore diameter, machine a pocket .200\"
2. Remove any burrs and chips from the piston.
3. Press the metal clad seal into the piston pocket so that the flat metal portion of the seal seats at the bottom of the pocket.
4. Chamfer and/or deburr the sharp edge of the servo pin to prevent cutting the seal.
5. With the seal installed in the piston, carefully spin the pin through the seal to prevent lip damage.
6. Install the spring plate and snap ring as the final step. Do not try to force the pin through the seal when the spring plate is fixed to the piston, as seal damage will result.

### 2nd Apply Servo Piston Bore Seal

