

Upgraded Piston Retainer

Standard Diameter 42RH/RE

12962N-01K

6-Bolt Piston Retainer

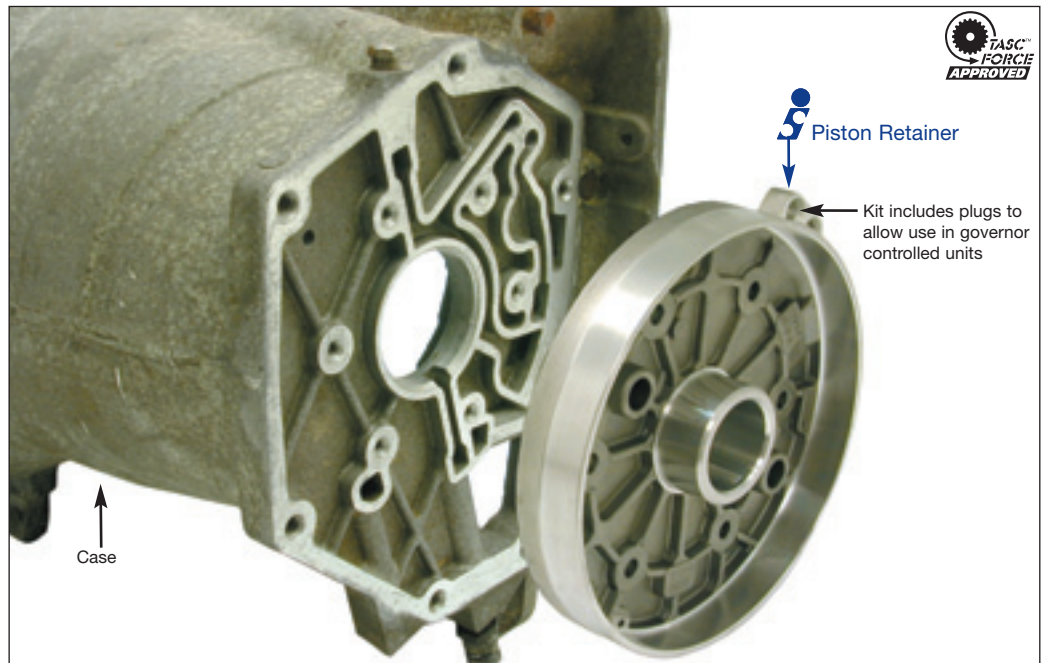
Oversized 42RH/RE

12962N-02K

6-Bolt Piston Retainer

Allows damaged reverse drum to be machined and salvaged

Note: U.S. Patent No. 6,810,771



Installation Instructions

1. If the oversized support (larger diameter where drum rides) is being used, turn the reverse drum I.D. to 1.966"/1.967". It is important to achieve a surface finish of 16 Ra (comparable to a ground finish) or smoother to increase the life of the unit.
2. It is recommended that you drill a small .040"-.045" hole in the case to help lubricate the low roller clutch. See Figure 1 for the exact location of the hole. This process is not a requirement to use the Sonnax retainer.
3. Install the o-ring into the o-ring groove and lubricate with TransJel®.
4. If the retainer is being installed on an 46RE unit, press the two aluminum plugs into the governor tube holes (See Figure 2).
5. Assemble the transmission following normal procedures.
6. The Sonnaflo™ should be used to verify cooler flow after the rebuild (See Figure 3).

Figure 1

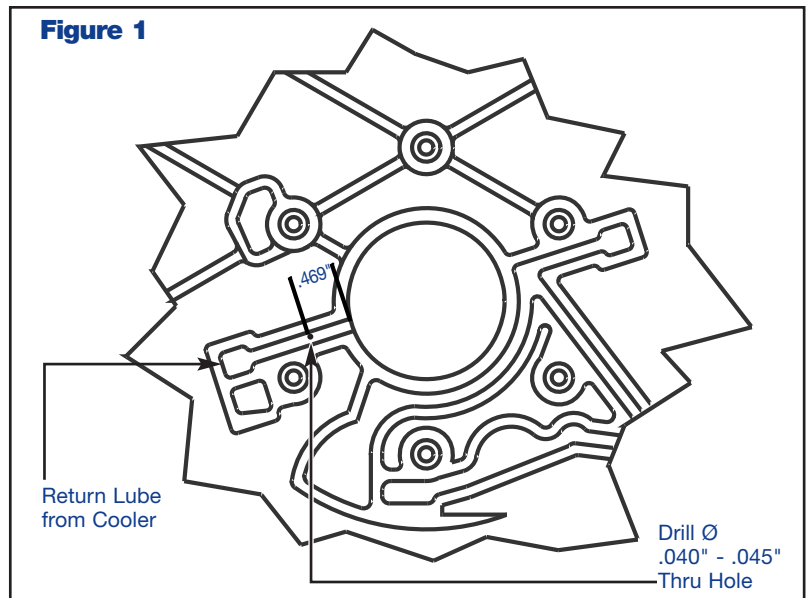
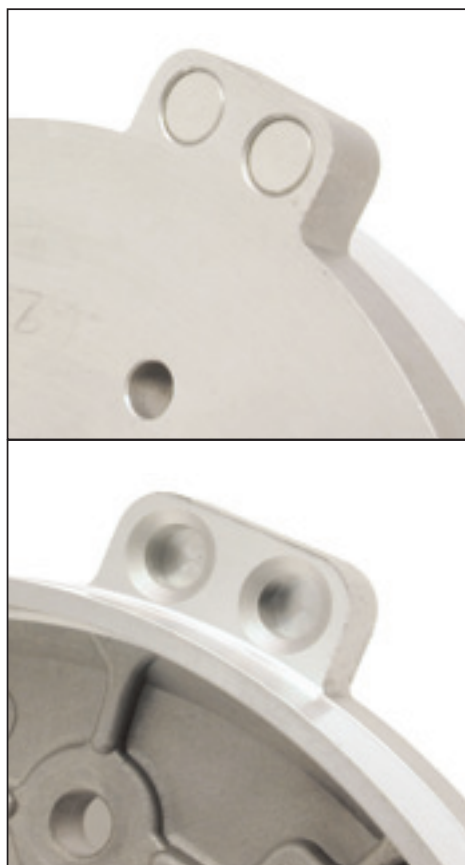


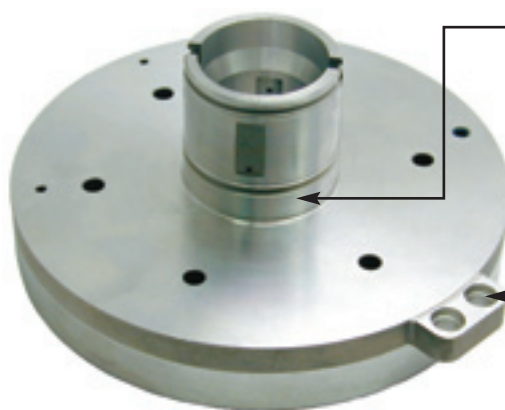
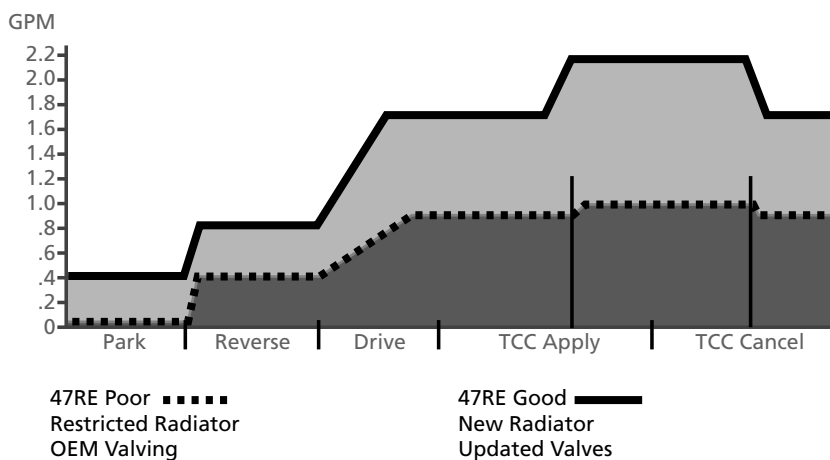
Figure 2



Installing the two plugs included with the retainer allows for use on an RE (computer-controlled units).

Figure 3

Problems Diagnosed by SonnaFlow™



Some cases vary in the size of their bore where the area below the o-ring rides. Do not try to drive or press the support into the case. If the support will not fit by hand (you may need a little pressure), you will have to hone about .005" off the I.D. of the case bore.

Do not to stake the plugs: staking the plugs can cause leaks between the support and case.