

Servo Piston Assembly

Part No.

22301B-01K

Servo Piston Assembly

Also Available:

Part No.

22825-01

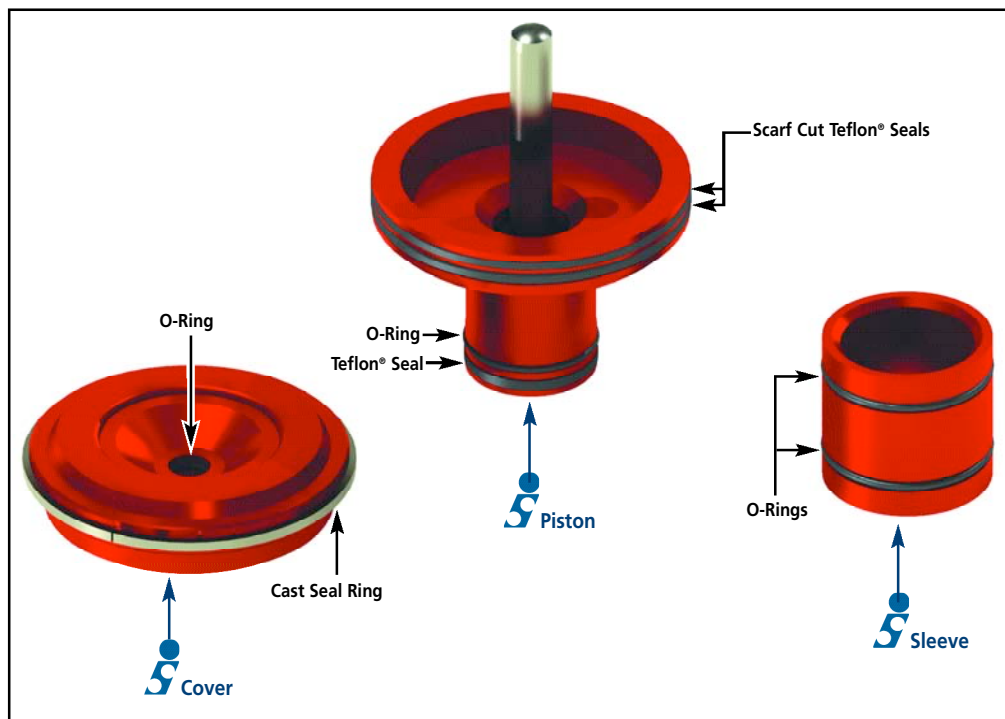
High Strength Band Strut

Part No.

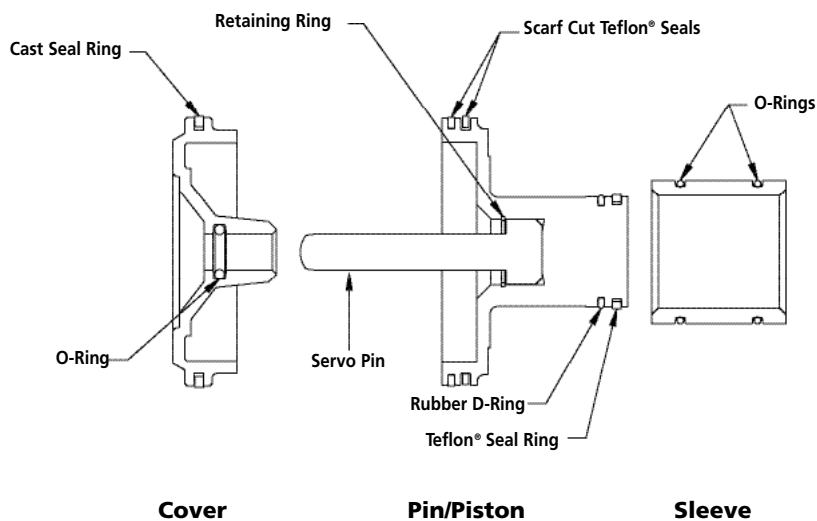
22841-04K

Accumulator Piston Kit

CHRYSLER A727, 46/47RH, 46/47/48RE



Assembly Instructions:



1. Refer to above drawing. Insert servo pin into servo piston, secure pin in place with supplied retaining ring.
2. Install small Teflon[®] seal and the small D-ring seal onto the small diameter of the apply piston as shown in the above drawing. The Teflon seal goes in the outer seal groove; the D-ring goes in the inner seal groove.

CHRYSLER A727, 46/47RH, 46/47/48RE

3. Use the sleeve to size the Teflon[®] seal by installing the sleeve over the Teflon[®] and rubber seals on the piston.
4. Install the 2 large rubber o-rings onto the sleeve.
5. Install the two large scarf cut Teflon[®] seals onto the large diameter of the piston. It is normal for the two grooves to have different depths.
6. Install the large cast seal ring onto the cover.
7. Install the small o-ring into the pin bore of the cover.
8. Lube the o-ring in the cover and temporarily install over the piston pin to confirm proper installation of the cover o-ring seal.

Installation Instructions (with valve body and band strut removed)

1. Remove the servo cover retaining ring and servo cover.
2. Remove servo piston assembly.
3. Apply assembly lube to the sleeve o-rings and install sleeve into the servo bore making sure it is bottomed out.
4. Apply assembly lube to the piston seals and insert piston into the case and pre-installed sleeve.
5. Install servo spring.
6. Place a mark on the outer face of the cover. Locate the ring end-gap of the metal sealing ring so that it lines up with your mark.
7. Insert new cover and secure with retaining ring; make sure retaining ring end gap is 180 degrees from mark on cover and sealing ring end gap.

Band Adjustment

Band adjustment specification depends largely on which lever is used. Factory specifications are:

Tighten band adjustment screw to 72 in-lb and back off	
Lever	Turns Out
2.5	2 7/8
3.8	1 7/8
5.0	1 1/2 - 1 3/4

An alternative method that works equally well regardless of which lever ratio is used is to measure the distance between the servo apply pin and the lever. Normal clearance is between .360" and .400" for all OEM levers. A 3/8" (.375") spacer can be used as a gauge block for setting this clearance.



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