

### GM 200-4R

## Super Hold Servo Kit

### Part No. K65703

- Cover (purple anodized)
- Spring
- E-clip
- Piston
- O-Ring Seal (2)
- Servo Pin
- Lip Seal (2)
- Spacer
- Seal Ring (2)
- Shim

Patent No. 6,907,974 & 7,047,611

## Super Hold Servo Kit

### Part No. K65703-1

- Cover (non-anodized)
- Spring
- E-clip
- Piston
- O-Ring Seal (2)
- Servo Pin
- Lip Seal (2)
- Spacer
- Seal Ring (2)
- Shim

## Replacement Seal Kit

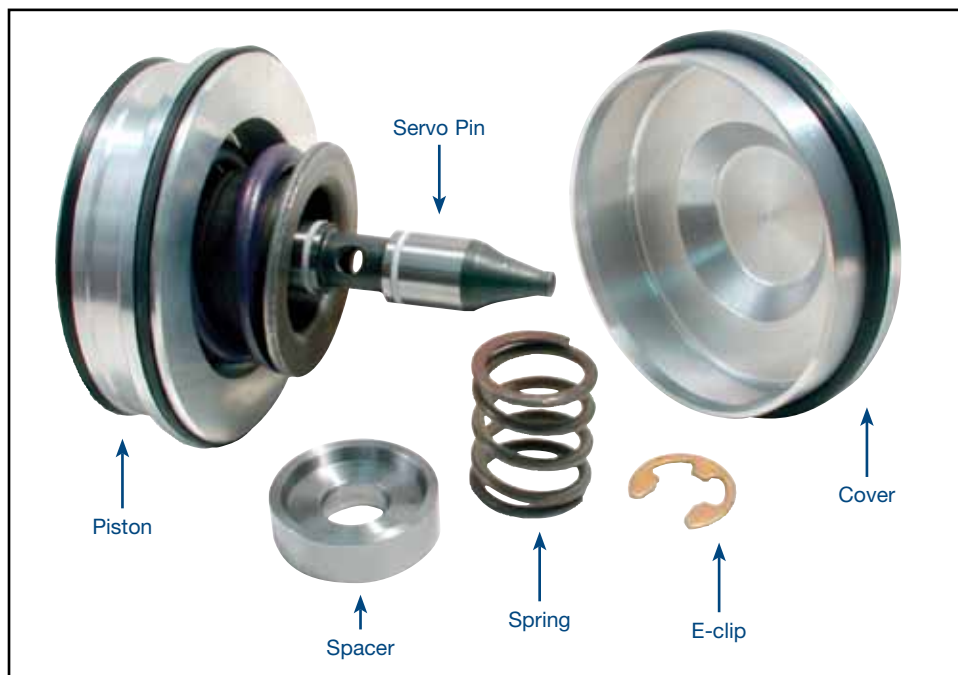
### Part No. 65703-SK

- Seal Ring (2)
- O-Ring Seal (2)
- Lip Seal (2)

## Replacement Servo Pin Kit

### Part No. 65703-14K

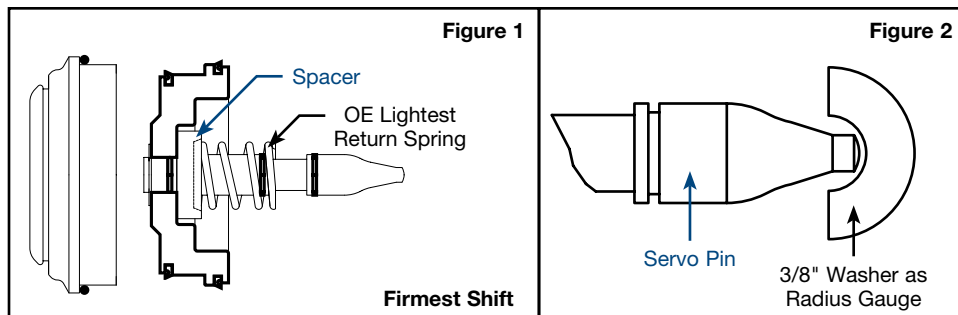
- Servo Pin
- E-clip



### 1. Set Servo Pin Travel

- Remove OE servo assembly. Discard everything except the springs and bell-shaped spring retainer.
- Assemble replacement pin, spacer, piston, E-clip and cover (**Figure 1**).  
**NOTE:** Do not install any seals or the large spring at this time.
- Place small return spring on the pin and install assembly with cover and retaining ring into case.
- Check servo travel by pushing on cover. Grind tip of servo pin as necessary to achieve desired travel (about .110").

**NOTE:** It is important to maintain the spherical tip radius when grinding the pin. The inner hole of a 3/8" flat washer cut in half makes a good gauge for this (**Figure 2**).



## 2. Select Servo Configuration

### Recommended Set-up Procedure

Install all parts which come in kit with OE cushion spring, the bell-shaped spring retainer and the Sonnax return spring. Do not use thick spacer (**Figure 3**).

### For the Firmest Shift Set-up Procedure

For the firmest 1-2 and 2-3 shift, install the Sonnax solid spacer in place of the cushion spring with the bell shaped retainer. Select the lightest OE return spring (**Figure 1**).

**CAUTION:** Using the firmest shift setup can cause excessively hard shifts which lead to broken parts.

### Spring Options for Shift Tuning

#### Cushion Spring (larger spring)

Lightest: Common yellow spring OE # 8628109

Heaviest: Red spring OE # 8639264 (some models)

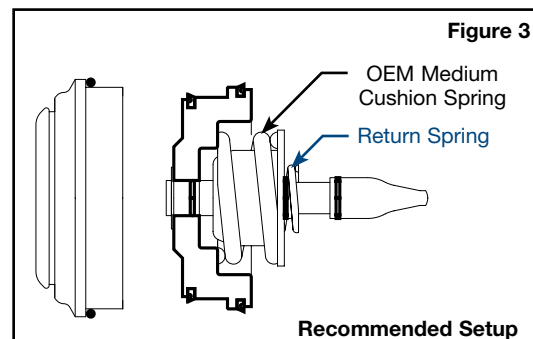
**NOTE:** The shim supplied with the Sonnax servo kit is optional. Add the shim to increase the cushion spring rate.

#### Return Spring (smaller spring)

Lightest: Common original spring (pink) OE # 8632661

Medium: Sonnax spring (included in kit)

Heaviest: Uncommon spring (black) OE # 8632147



## 3. Install Servo

Install seals on pin, piston and cover. Lubricate with assembly gel and install servo assembly into case.

## 4. Air Test Servo

Leak test the 2nd apply and 3rd release sides of the servo with 1/4" O.D. tubing and a short piece of rubber vacuum line (**Figure 4**).