

Upgraded Piston Retainer

22754N-01K

Standard Diameter 46-47RH/RE
6-Bolt Piston Retainer

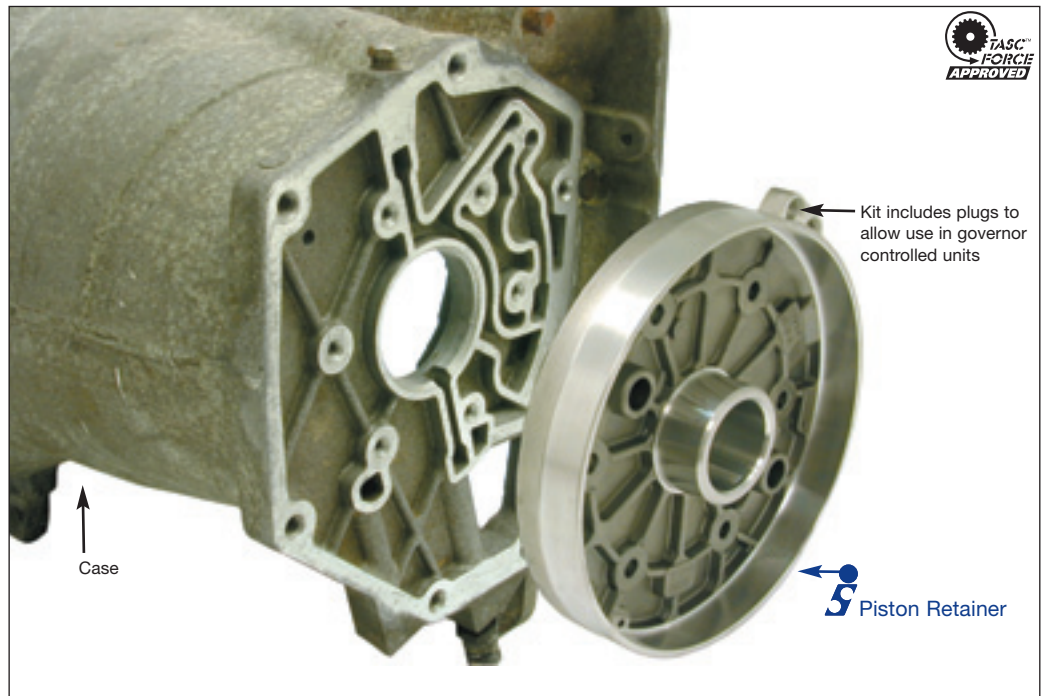
22754N-02K

Oversized Diameter
46-47RH/RE
6-Bolt Piston Retainer



Note: Oversized diameter allows damaged reverse drum to be 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 2.1885"/2.1875". 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 a RE unit, press the two aluminum plugs into the governor tube holes (see Figure 2).
5. Assemble the transmission following normal procedures.
6. The SonnaFlow® should be used to verify cooler flow after the rebuild (see Figure 3).

Figure 1

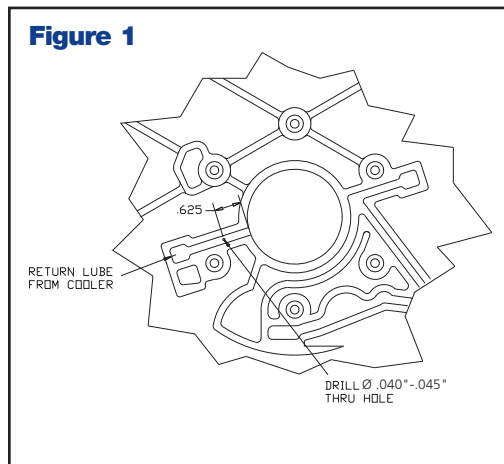
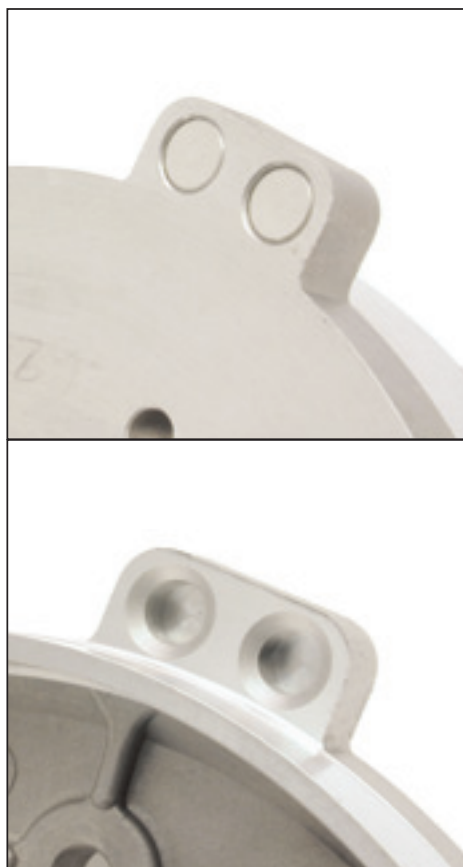


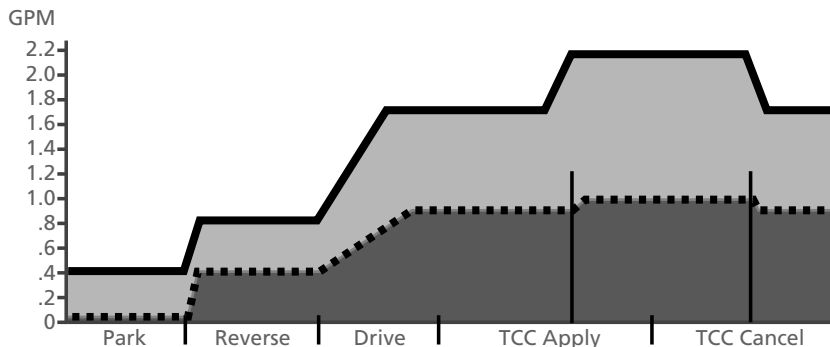
Figure 2



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

Figure 3

Problems Diagnosed by SonnaFlow™



47RE Poor
Restricted Radiator
OEM Valving

47RE Good ———
New Radiator
Updated Valves



Some cases vary in the size of their bore where the area below the o-ring rides. You should 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.