

## Accumulator Pin Kits

### 54250-03K

10 Oversized Accumulator Pins  
20 E-Clips  
10 Accumulator Piston Seals  
1 Reamer

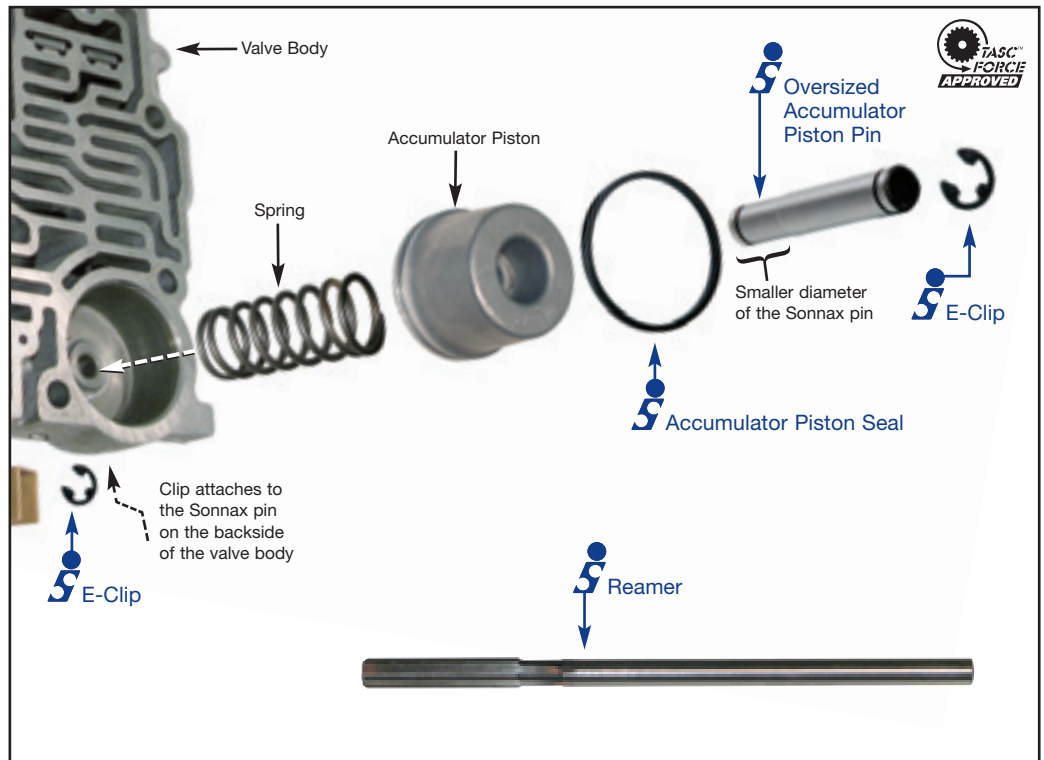
### 54250-02K

4 Oversized Accumulator Pins  
8 E-Clips  
4 Accumulator Piston Seals

### 54250-02SK

10 Accumulator Piston Seals

**NOTE:** The early model TH180 has a removable e-clip retainer holding the accumulator piston and spring in place. The late model TH180 has a non-removable fixed head holding the accumulator piston and spring in place. The Sonnax pin will work with either of these applications.



### INSTALLATION

1. Remove the original pin and retaining clip (if applicable) from the valve body.
2. Remove and discard the original piston seal/ring from the accumulator piston and replace with the supplied seal.
3. Press the smaller diameter of the replacement **54250-02K** pin into the valve body.  
**NOTE:** Avoid hammering the end of the pin as this will swell the end of the pin and cause the piston to bind during installation. If possible, use an arbor press to push the pin into the valve body. If it is necessary to use a hammer, turn the old pin upside down and use as a driver.
4. Install the retaining e-clip into the accumulator pin groove on the outside of the valve body.
5. Ream the bore of the accumulator piston with the Sonnax reamer. Avoid hand-held drill. If possible use a drill press or lathe.
6. Assemble spring and piston into the valve body and install the remaining retaining e-clip into the accumulator pin.