



TORQUE CONVERTER PARTS

AL-DS-1

PISTON DAMPER REPAIR SLEEVE

Application:

- Allison 1000/2000/2400 Series

Details:

- Repair sleeve for worn piston damper assemblies
- No disassembly of piston damper required
- Heat treated for longer life
- Machining and welding required

Associated Parts:

- AL-O-1, Piston Seal

Part No.

AL-DS-1

Piston Damper Repair Sleeve



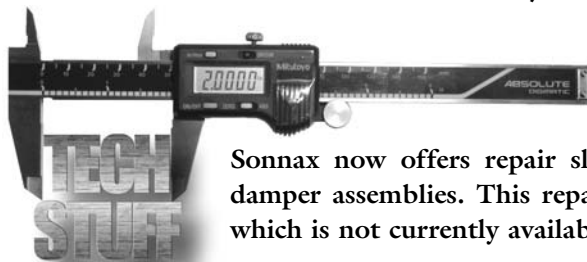
Sold in prepackaged quantities of 1 unit

Please refer to our

TORQUE CONVERTER PARTS CATALOG VOLUME 6 & ONLINE CATALOG AT WWW.SONNAX.COM

AL-DS-1 is:

Item Number 17.1 for Allison 1000/2000/2400 Series on page 40.



Sonnax now offers repair sleeve **AL-DS-1** for worn Allison 1000/2000/2400 Series piston damper assemblies. This repair sleeve allows you to salvage the OEM piston/damper assembly, which is not currently available to the aftermarket.



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AL-DS-1

PISTON DAMPER REPAIR SLEEVE

Bore Ø2.700/2.705" (68.58/68.71mm) through and machine surface flush



Figure 1

Weld 360° around sleeve flange Sonnax AL-DS-1 Repair Sleeve

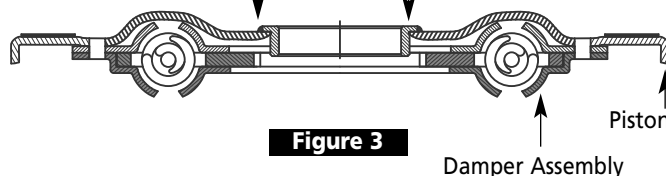


Figure 3

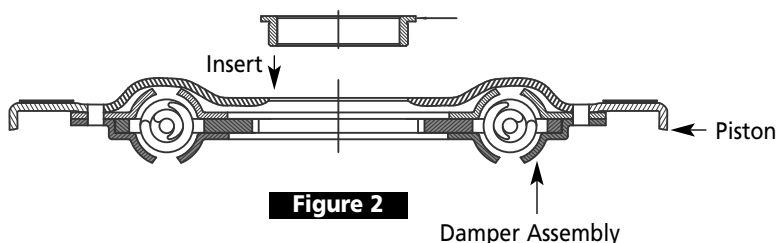


Figure 2

INSTALLATION INSTRUCTIONS

1. Chuck the piston plate in a lathe and indicate to insure that the friction material surface runs true.
2. Bore the inside diameter to 2.700"/2.705" to accept repair sleeve as shown in *Figure 1*.
3. Machine surface flush immediately adjacent to the ID bore, as shown in *Figure 1*. This will ensure a flat mating surface for the sleeve flange.
4. Remove from the lathe and remove all burrs.
5. Place repair sleeve **AL-DS-1** in the piston damper assembly, making sure the flange is pressed firmly against the machined surface, as shown in *Figure 3*.
6. Weld 360° around the flange OD. A GTAW (TIG) weld is preferred to ensure a strong, flat and leak-proof weld (see *Figure 3*).
7. After the sleeve has been welded, allow to cool. Lightly clean the inside diameter with 600-grit emery cloth. Make sure none of the weld is above the top edge of the flange.

NOTE: It is recommended that you balance the newly repaired piston damper assembly. Do not rely on balancing the converter to balance the piston damper as well. The piston damper, converter impeller and cover all rotate independently and thus must be balanced independently. Balancing can be done on a converter balancer using a turbine hub as a centering tool. Material may be removed or added to the piston. A weld bead may be enough to balance the assembly, but be careful not to overheat the friction ring if adding a weld bead to balance.