

Front Servo Piston and Sleeve Kit

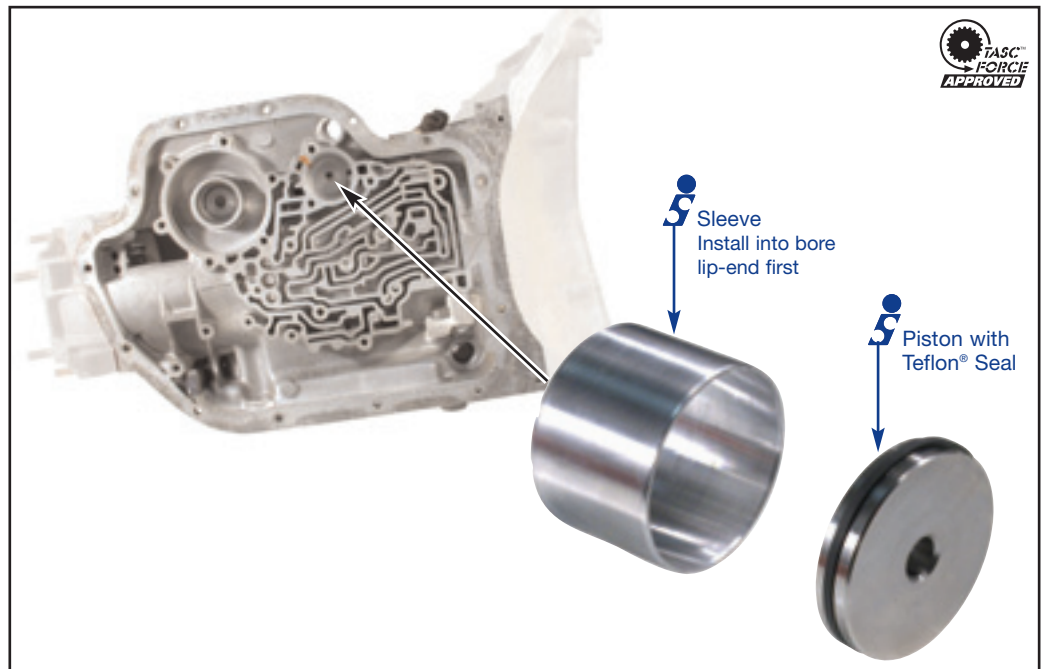
34989-06K

1 Sleeve
1 Piston
1 Teflon® Seal Ring

Also Available:

34989-SK

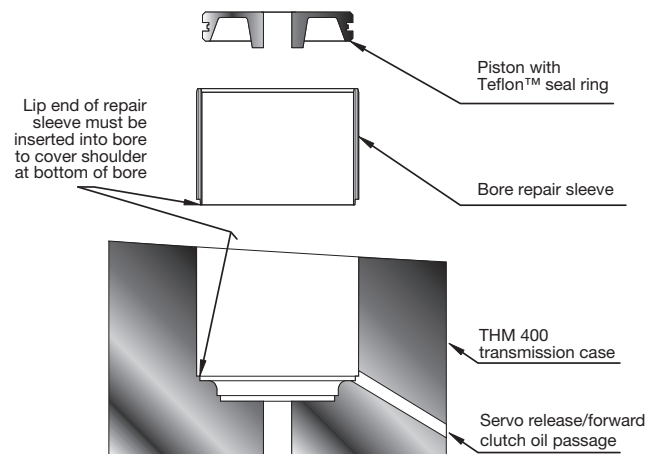
5 Teflon® Seal Ring



Installation:

1. Remove any raised material from damaged case bore.
2. Roughen both case bore AND sleeve outer diameter with sandpaper, etc.
3. Clean the case bore and sleeve outer diameter with a clean rag and Loctite-compatible solvent (e.g., brake cleaner or isopropyl alcohol).
4. Apply an even coat of Loctite 609® sleeve retainer (or equivalent) to both the case bore and the outer diameter of the sleeve.
5. Insert the repair sleeve into the bore lip-end first (see figure at right). Using the old servo piston as a drift and a light hammer, tap the repair sleeve down until the lip contacts the bottom of the bore. Do not damage the inside diameter of the sleeve during installation.
6. Check the servo release/forward clutch oil passage in the bottom of the bore. If it is more than 50% covered by the sleeve, use a file or die grinder to open the feed hole in the case. Do not file or grind away the sleeve.
7. Remove any excess Loctite from the bore.
8. Some aftermarket 2-3 accumulator pistons (located in the valve body) have larger outside diameters and may contact the bore sleeve inner diameter. To check for contact/interference, place separator plate and valve body onto case using two threaded alignment pins. If the 2-3 accumulator piston contacts the sleeve, machine the outer diameter of the accumulator piston or use a 1971-1991 OE 2-3 accumulator piston.
9. Install the Teflon® seal onto the new replacement servo piston.
10. Lubricate the seal with assembly lube and install the servo assembly using normal rebuild procedures.

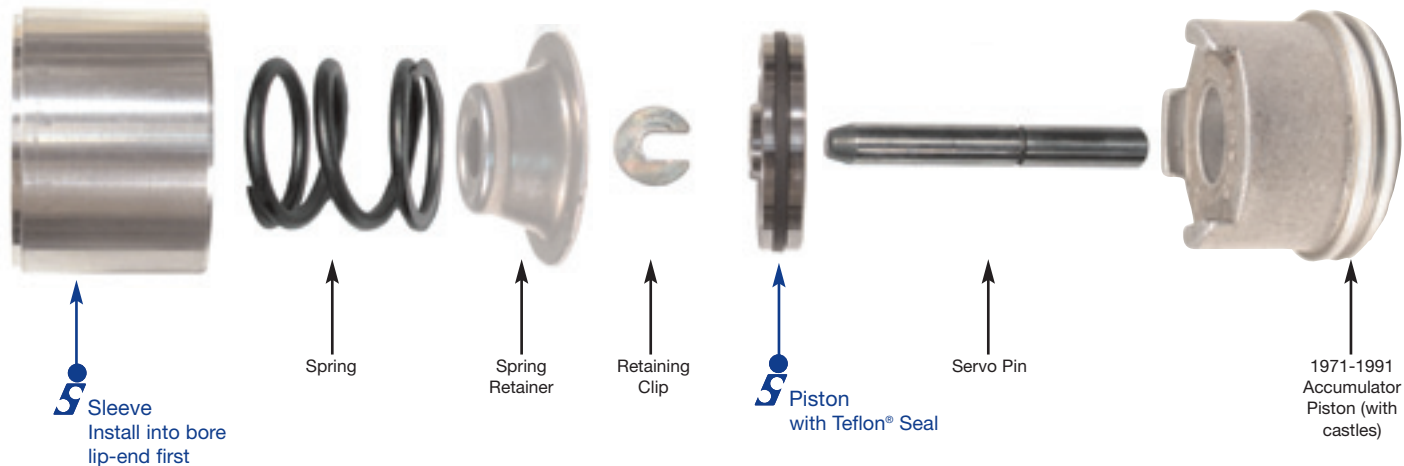
Note: Allow 24 hours cure time before running transmission or use Loctite accelerator/primer for faster cure times.



THM 400, 3L80, 4L80-E

PART NUMBER 34989-06K

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This servo piston and sleeve kit is NOT compatible with 1965-1970 valve body 2-3 accumulator pistons. The early piston is flat on top (as shown at right). If installing this kit into a 1965-1970 transmission, change the valve body 2-3 accumulator piston to the later 1971-1991 version piston with "castles" on top (as shown at top right). The remaining 1965-1970 pin, spacer, washer and spring can used with this kit.

1965-1970 Flat Top Accumulator Piston



Flat top accumulator piston is not compatible. Replace with castelated piston