

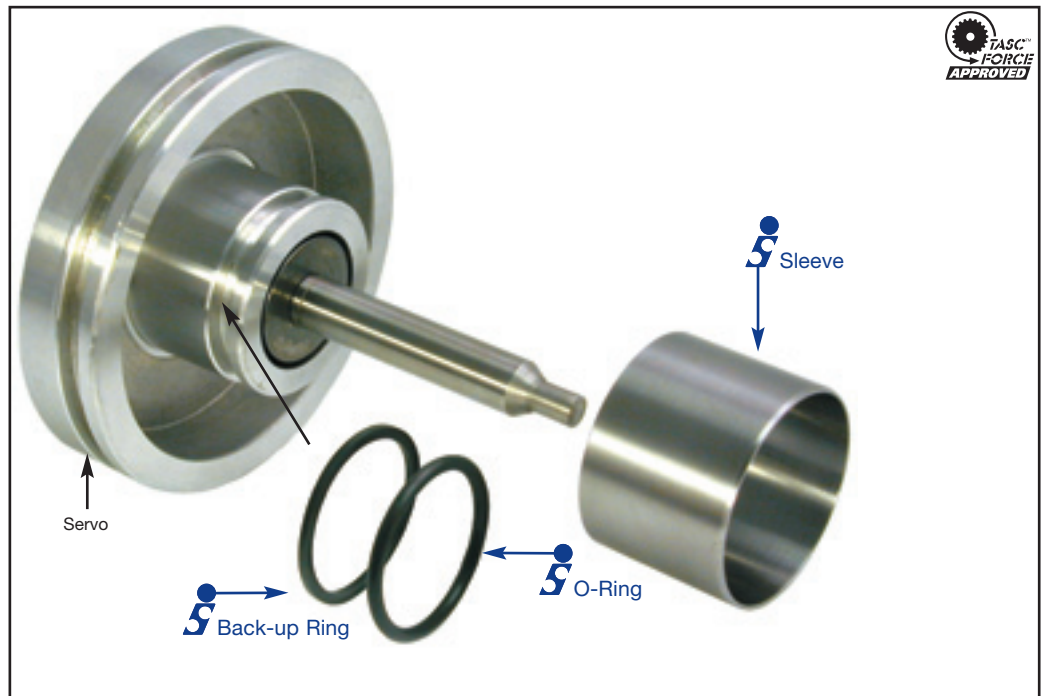
## Reverse Servo Sleeve Kit

### 56532-01K

1 Servo Sleeve  
1 Back-up Ring  
1 O-Ring



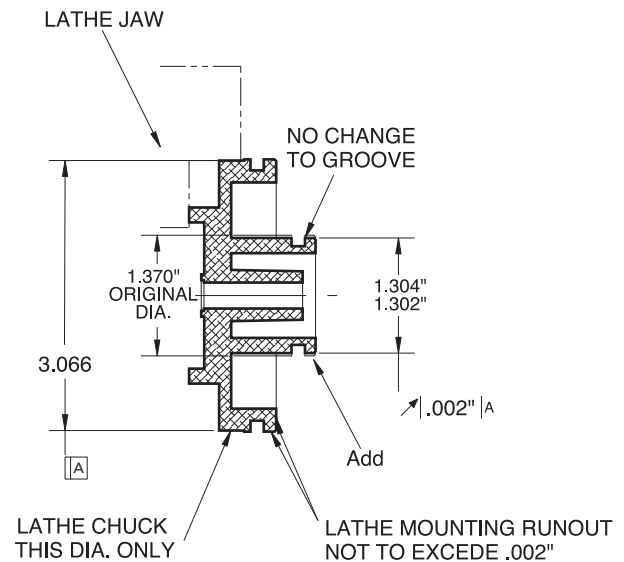
**Note:** Machining of the servo is required



### Installation Instructions

1. Remove the servo piston from the transmission case.
2. Remove the two piston o-rings.
3. Remove the pin and springs.
4. Mount the piston in a lathe as shown in Figure 1.

**Figure 1**



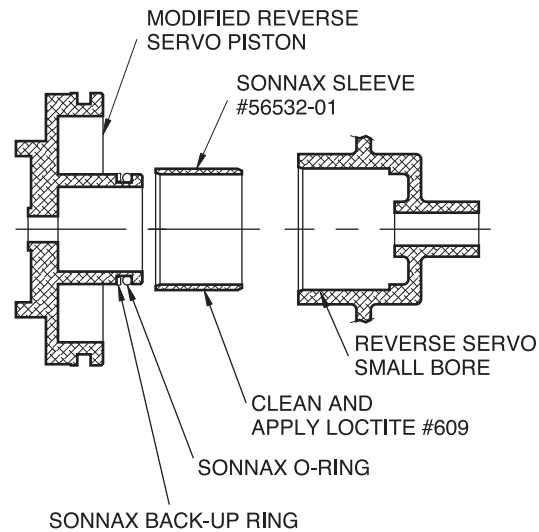
**NOTES:**

1. Remove burrs
2. Break sharp edges .020" max.
3. Always remove servo pin and spring. Any sediment trapped here can cause additional servo scoring/damage.

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5. Turn the inner piston O.D. to the dimensions shown.
6. Install the o-rings and back-up ring as shown.
7. Check the fit of the piston and the sleeve.
8. Roughen up the surface of the bore with an abrasive pad or sandpaper (remove any high spots caused by scoring).
9. Clean the worn case bore and sleeve with solvent to remove any oil or debris.
10. Apply Loctite 609® or 660® around the sleeve.
11. Insert the sleeve in the case as shown in Figure 2.
12. Allow the adhesive time to cure.
13. Stake the sleeve in place as shown in figure 3.
14. Reassemble.

**Figure 2**



**Figure 3**

