

## Replacement Accumulator Piston and Pins

### 75921-01K

1 Standard Accumulator Piston  
1 Standard Accumulator Pin



### 75921-02K

4 Oversized Accumulator Pins

### 75921-03K

10 Oversized Accumulator Pins  
1 Reamer

### 75921-01K Instructions

Replace the worn piston and pin with the Sonnax kit, following standard rebuild procedures.

### 75921-02K & -03K Instructions

1. Remove OEM accumulator pin and piston from the channel plate casting. Discard the OEM pin.
2. Chuck the piston in a lathe or clamp in a drill press vise on the 1.600" diameter (see Figure 1).
3. Feed the reamer into the piston from the side opposite the spring pocket. Allow the existing chamfer to guide the reamer into the bore (see Figure 2).
4. It is recommended to use 500-700 RPM spindle speed. Use plenty of cutting fluid and a steady feed rate. It should take between 30-45 seconds to ream this bore.
5. Inspect reamed bore. Make sure that the reamer cleaned all the bore surfaces. If this bore did not clean completely the OEM piston was too worn to be salvaged.
6. If required, buff the bore using a 320 grit emery cloth on a slotted rod to get a better surface finish (see Figure 3).
7. Install the oversized accumulator pin into the channel casting. The smaller pin diameter goes into the case and the larger diameter fits the piston.
8. Install the piston, seal, and spring following normal rebuilding procedures.

