

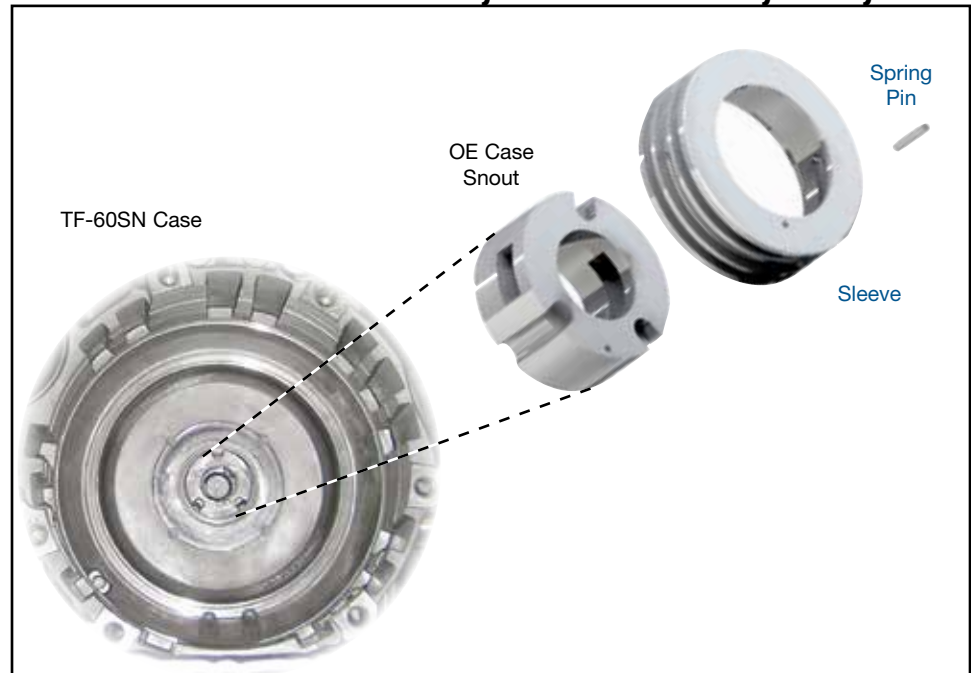
K2 Clutch Seal Ring Sleeve Kit

Part No.

15759-01K

- Sleeve
- Spring Pin

**Aisin AW TF-60SN;
Mini 6F21WA; VW/Audi 09G, 09K, 09M**

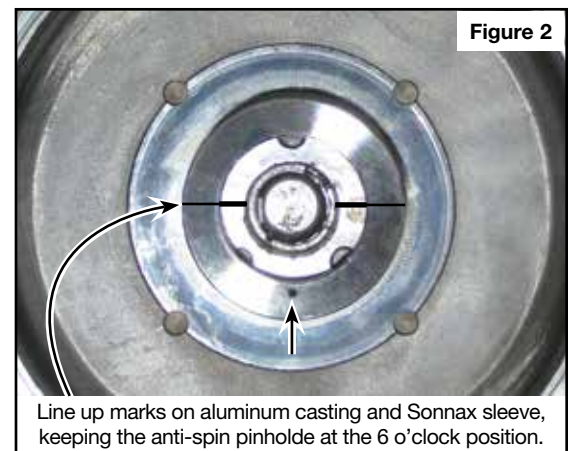
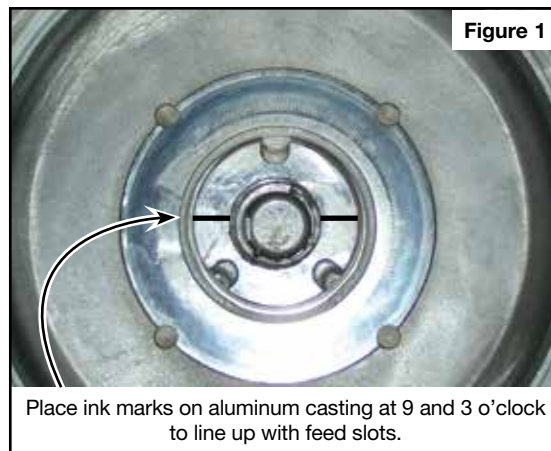


1. Disassembly

Remove OE sleeve. If OE sleeve is not loose, heat and remove it.

2. Installation & Assembly

- Index OE case, so the valve body location and the two ports to lube and K2 clutch will be at 6 o'clock.
- Place an ink mark across the aluminum casting at 9 and 3 o'clock to identify the location of the feed slots (**Figure 1**).
- Place a similar mark across the Sonnax sleeve (**Figure 2**).



2. Installation & Assembly (continued)

- d. If you chose to use Loctite® or similar sealant, clean/prep both OE case and Sonnax sleeve.
- e. Apply sealant to OE case.
- f. Prepare your press and case fixture, prior to heating Sonnax sleeve.
- g. Preheat Sonnax sleeve to 150–175°F.
- h. Index Sonnax sleeve so ink marks will lay over OE case marks and Sonnax spring pin will be at 6 o'clock position (**Figure 2**).
- i. Start Sonnax sleeve by tapping it down to insure it starts straight.
- j. Support the back of OE case and using a press, continue until the flange on Sonnax sleeve has bottomed on the aluminum tower. This takes some force.

3. Installation Spring Pin

- a. Using Sonnax hole as a guide, drill a .062" hole to depth of .380".



NOTE: The guide hole should be at the 6:00 o'clock position.

- b. Drive Sonnax spring pin in until flush. Remove any burrs at the pin area.

4. Final Verification Steps

Air Test

Verify Sonnax sleeve is installed properly by air testing the lube and K2 ports.

Using Soap Solution

If you supply air in to the lube passage and plug the bushing area, there should not be cross-leakage into K2 or around the base of the sleeve.

Using ATF

Install assembled K2 drum. Supply air/ATF into K2 circuit. There should not be cross-leakage into lube circuit.