

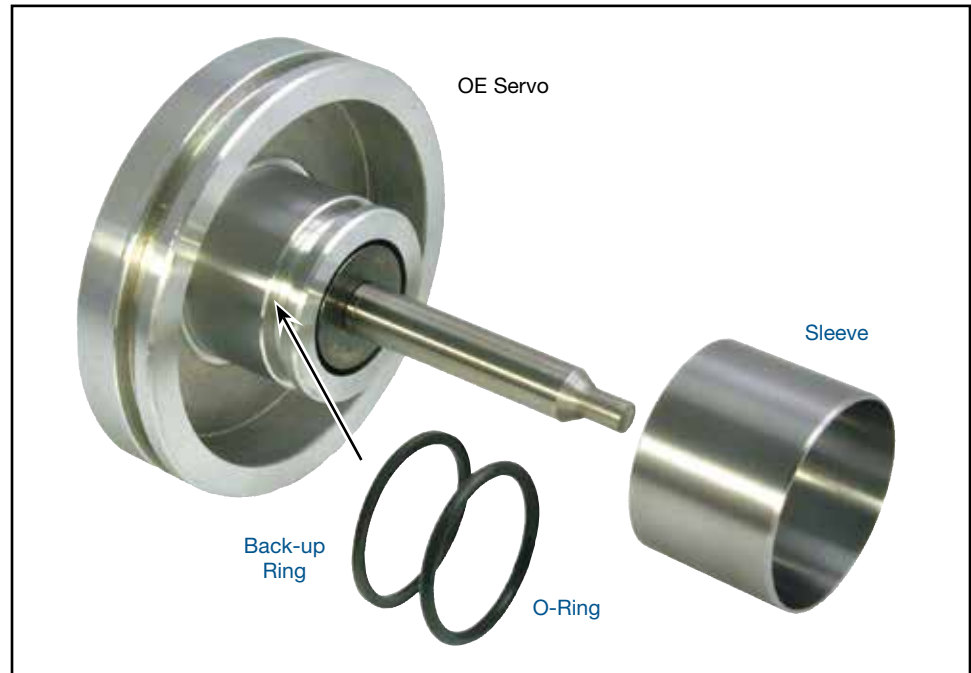
Reverse Servo Sleeve Kit

Part No.
56532-01K

- Sleeve
- Back-up Ring
- O-Ring

NOTE: Machining of the servo is required.

Ford 4R44E, 4R55E, 5R44E, 5R55E, A4LD, C3

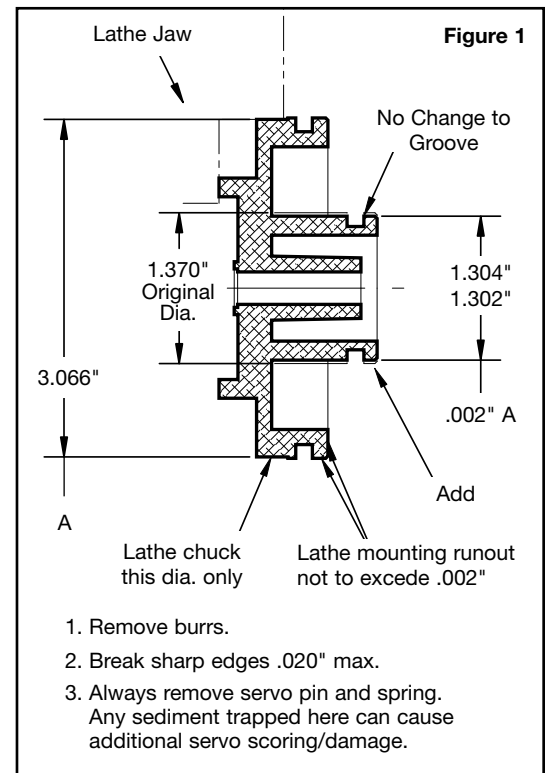


1. Disassembly

- Remove the servo piston from the transmission case.
- Remove the two piston O-rings.
- Remove the pin and springs.
- Mount the piston in a lathe (**Figure 1**).

2. Installation & Assembly

- Turn the inner piston O.D. to the dimensions shown.
- Install the O-ring and back-up ring (**Figure 2**).
- Check the fit of the piston and the sleeve.
- Roughen up the surface of the bore with an abrasive pad or sandpaper (remove any high spots caused by scoring).
- Clean the worn case bore and sleeve with solvent to remove any oil or debris.



2. Installation & Assembly (continued)

- f. Apply Loctite 609® or 660® around the sleeve.
- g. Insert the sleeve in the case (Figure 2).
- h. Allow the adhesive time to cure.
- i. Stake the sleeve in place (Figure 3).
- j. Reassemble.

