

## 3-4 Accumulator Sleeve Kit

### Part No.

# 77998-01K

- Sleeve
- Piston
- O-Ring
- Accumulator Pin

Fluorocarbon

## GM 4L60, 4L60-E, 4L65-E, 4L70-E



### 1. Disassembly

- Remove any burrs or raised areas from accumulator bore.
- Clean out all chips and dirt from within the bore.
- Remove any grease with a Loctite® compatible solvent.

### 2. Installation & Assembly

- Apply Loctite 609 to Sonnax sleeve O.D. following Loctite instructions.

**NOTE:** The Sonnax sleeve I.D. has a surface of 16 Ra. There is no need to buff or scuff the sleeve I.D. before piston assembly.

- Place end of Sonnax sleeve with the O.D. chamfer into bore and press in sleeve until it makes contact with the bottom of the bore (**Figure 1**).

**NOTE:** The top edge of Sonnax sleeve will sit approximately .05-.09" below the case surface (**Figure 2**).

- Install Sonnax O-ring into the groove of Sonnax piston and lubricate with Transjel™.
- Assemble Sonnax accumulator piston and pin with OE spring as you would normally.

