

## Piston/Damper Repair Sleeve

Part No.  
**BW-DS-2**

### Borg Warner 310mm LU (A618, 47RH/RE, 48RE)



1. Chuck the piston plate in a lathe on either the I.D. or O.D. (Figure 1).
2. Bore the I.D. to 2.5500"/2.5515" and add chamfer to accept Sonnax sleeve (Figure 2).
3. Remove from lathe and remove all burrs.
4. Insert sleeve on the damper side, being sure that Sonnax sleeve is held firmly against the plate using a Sonnax **GM-HT-9HS** turbine hub as a locating fixture (Figure 2).
5. After the sleeve is welded and cooled, remove the fixture, then lightly clean the inside diameter with 600-grit emery cloth.

