

## Oversized Actuator Feed Accumulator Piston Kit

**Part No.**  
**124740-40K**

- Accumulator Pistons (3)
- Springs (3)



## Tool Kit

**Part No.**  
**124740-TL40**

- Wing Nuts (4)
- Washers (6)
- Bolts (6)
- Jig Plate
- Reamer Jig
- Guide Pin
- Reamer



**NOTE:** Original release 124740-TL40 with shown jig plate works in Gen. 1 only. To update to work in Gen. 2 applications requires purchase of jig plate 124740-JP40 below.

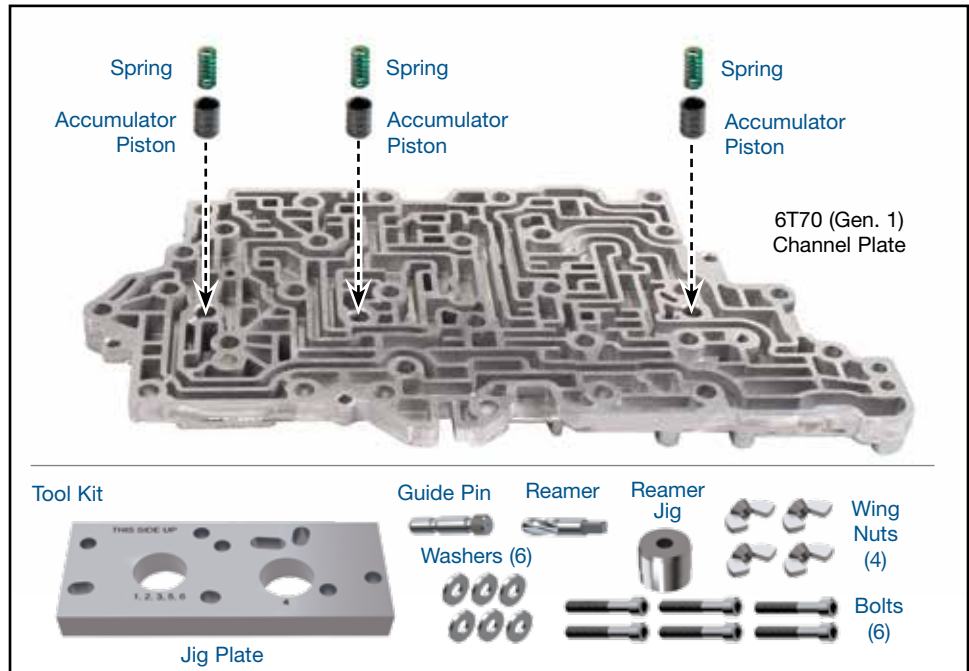
All new release 124740-TL40 tool kits include the updated jig plate 124740-JP40, so will work in Gen. 1 & Gen. 2 applications.

## Jig Plate

**Part No.** Works with Gen. 1 & 2  
**124740-JP40**



## GM 6T70/75 (Gen. 1)

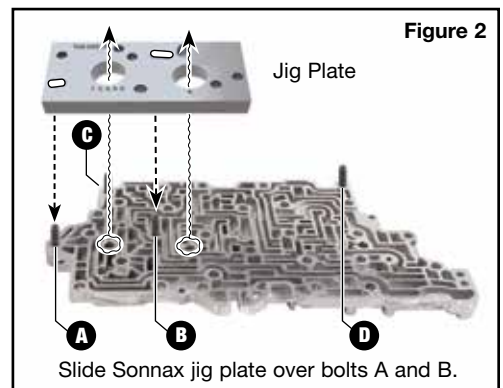
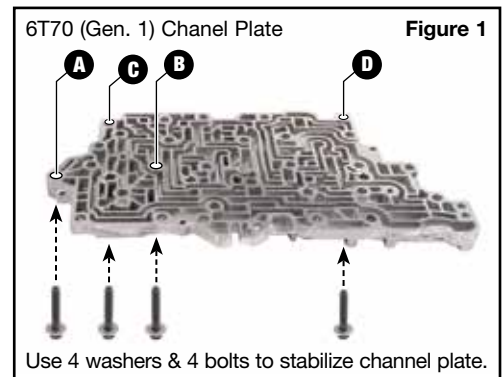


### 1. Disassembly

Remove and discard all three OE accumulator pistons and springs.

### 2. Bore Reaming

- Place OE channel plate on bench with OE accumulator bores facing upwards.
- Fit four washers, over four bolts and slide them up, through channel plate holes A-D to stabilize casting (**Figure 1**).
- Place Sonnax jig plate over bolts A and B, aligning two large plate holes over two casting accumulator bores (**Figure 2**).
- Place and securely tighten wing nuts on bolts C and D. Place and loosely tighten wing nuts on bolts A and B (**Figure 3**).
- Recommend using small plate and clamp to secure casting to bench (**Figure 3**).
- Install Sonnax reamer jig into left plate hole (**Figure 3**).
- Slide Sonnax guide pin through reamer jig and into casting accumulator bore until bottomed (**Figure 4**).



## 2. Bore Reaming (continued)

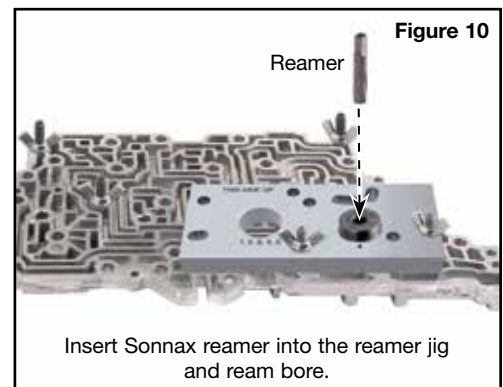
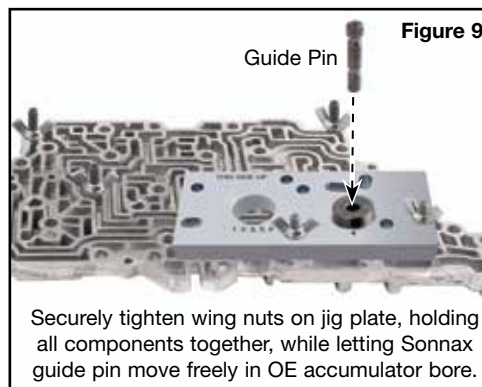
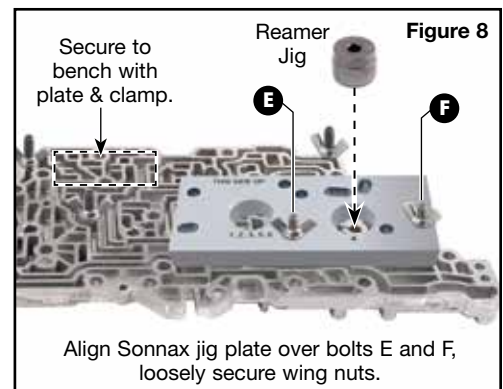
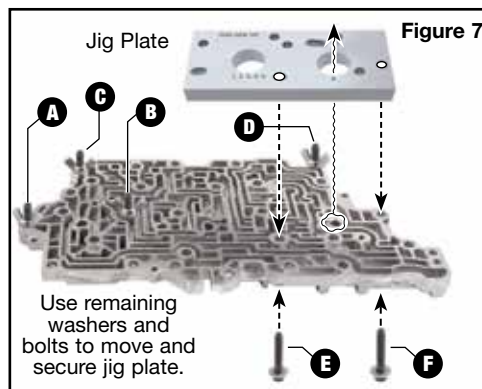
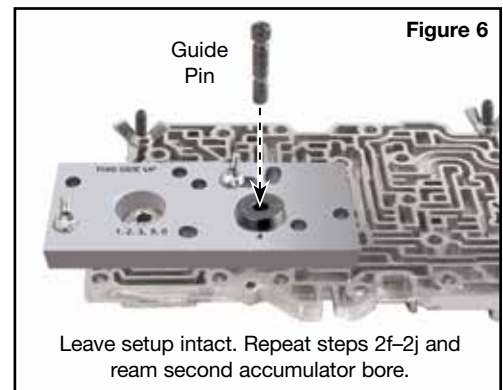
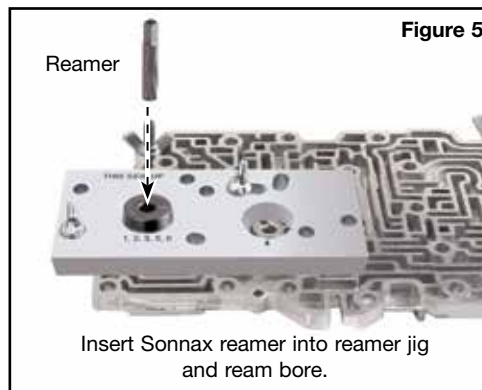
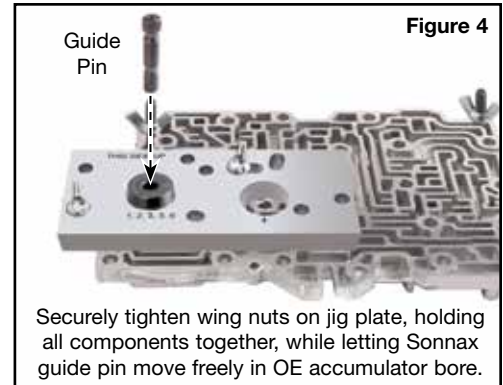
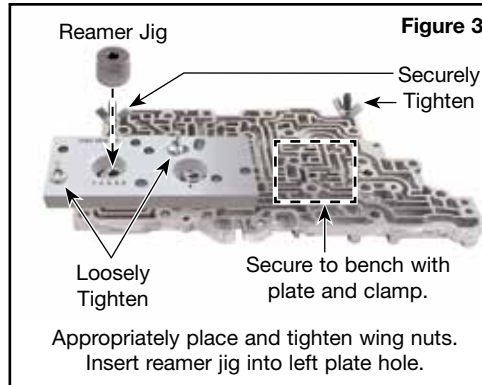
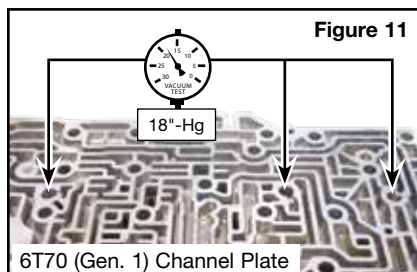
- h. Once guide pin, reamer jig and jig plate are aligned with bore to be reamed, securely tighten wing nuts. Ensure jig plate is tightly held in place while allowing guide pin to stroke freely in reamer jig and casting bore (Figure 4).
- i. Remove guide pin and insert Sonnax reamer into reamer jig (Figure 5).
- j. Ream bore with steady, clockwise rotation using either speed handle or regulated air drill. Once reaming is complete, spin the reamer a few more times to burnish and improve surface finish (for full reaming instructions/reamer care, please visit [www.sonnax.com](http://www.sonnax.com)).
- k. Leaving setup intact, repeat steps 2f-2j for second accumulator bore in channel plate (Figure 6).
- l. Reposition jig plate, clamp and plate, and add washers and bolts E and F as shown (Figures 7-8). Repeat steps 2f-2j to ream third accumulator bore (Figures 8-10).
- m. If necessary, deburr bore entrances slightly to facilitate assembly of the oversized accumulators.
- n. Thoroughly clean the channel plate after reaming.

## 3. Installation & Assembly

- a. Install Sonnax accumulator pistons, pocket side up.
- b. Install Sonnax springs into pistons (main image).

## 4. Final Testing

Vacuum testing at the port(s) indicated holds the recommended minimum 18 in-Hg (Figure 11).



## Oversized Actuator Feed Accumulator Piston Kit

Part No.  
**124740-65K**

- Accumulator Pistons (6)
- Springs (6)

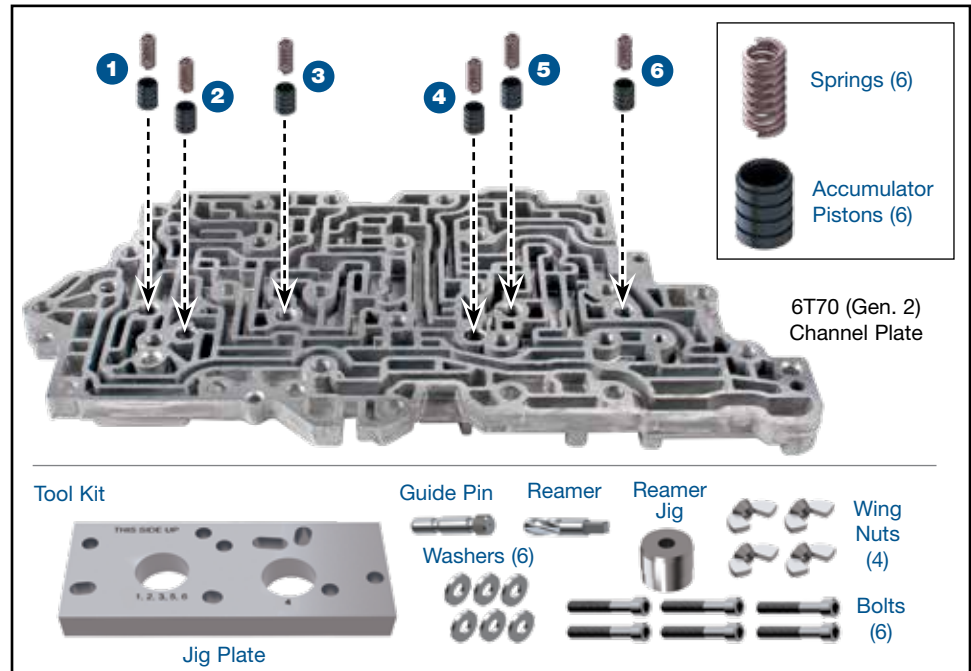


## Tool Kit

Part No.  
**124740-TL40**

- Wing Nuts (4)
- Washers (6)
- Bolts (6)
- Jig Plate
- Reamer Jig
- Guide Pin
- Reamer

## GM 6T70/75/80 (Gen. 2)

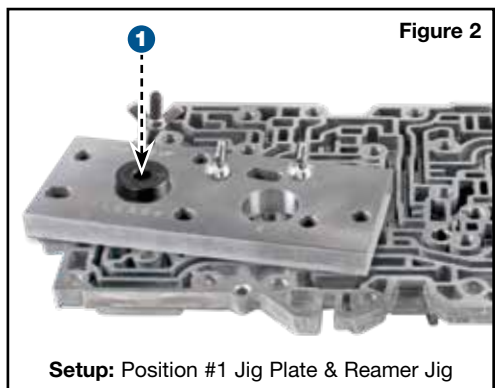
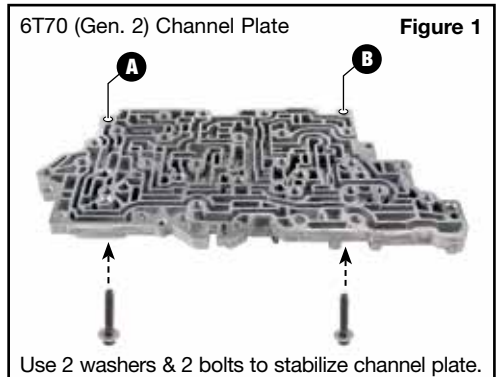


### 1. Disassembly

Remove and discard all six OE accumulator pistons and springs.

### 2. Bore Reaming

- Place OE channel plate on bench with OE accumulator bores facing upwards.
- If necessary to level and stabilize channel plate, fit two washers over two bolts and slide them up through channel plate holes (A & B; Figure 1).
- Position Sonnax jig plate and use the wing nuts and bolts to gently hold it in place (Figures 2 - 7).
- Recommend using small plate and clamp to secure casting to bench, ensuring not to damage machined surfaces of the casting (Figure 8).
- Install Sonnax reamer jig into specified hole (Figures 2 - 7).
- Slide Sonnax guide pin through reamer jig and into casting accumulator bore until bottomed.



## 2. Bore Reaming (continued)

- g. Once guide pin, reamer jig and jig plate are aligned with bore to be reamed, securely tighten wing nuts, ensuring jig plate is tightly held in place while allowing guide pin to stroke freely in reamer jig and casting bore (**Figure 9**).
- h. Remove guide pin and insert Sonnax reamer into reamer jig (**Figure 10**).
- i. Ream bore with steady, clockwise rotation using either speed handle or regulated air drill. Once reaming is complete, spin the reamer a few more times to burnish and improve surface finish (for full reaming instructions/reamer care, please visit [www.sonnax.com](http://www.sonnax.com)).
- j. Repeat steps 2c–2i for remaining accumulator bores in channel plate.
- k. If necessary, deburr bore entrances slightly to facilitate assembly of the oversized accumulators.
- l. Thoroughly clean the channel plate after reaming.

## 3. Installation & Assembly

- a. Install Sonnax accumulator pistons, pocket side up.
- b. Install Sonnax springs into pistons (**main image**).

## 4. Final Testing

Vacuum testing at the port(s) indicated holds the recommended minimum 18 in-Hg (**Figure 11**).

