

Oversized Seal Rings

Part No.

34716-01

- Seal Rings (2)

Recommended

Sizing Tool

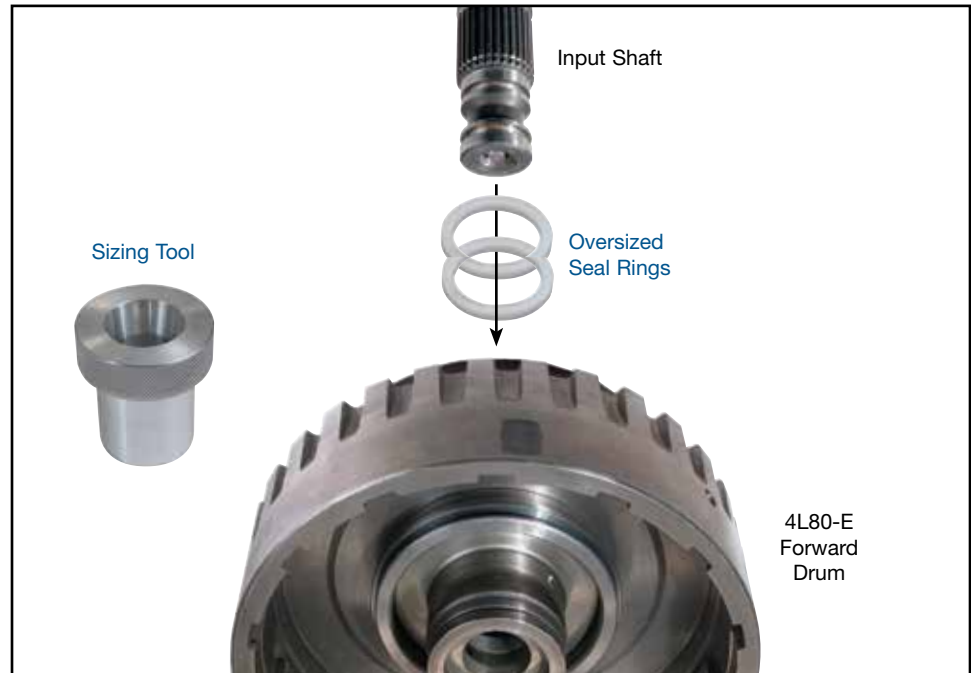
Part No.

34716-TL

NOTE: This tool is not required but is highly recommended to prevent damage to the new oversized sealing rings when inserting the input shaft into the machined forward drum I.D. bore.

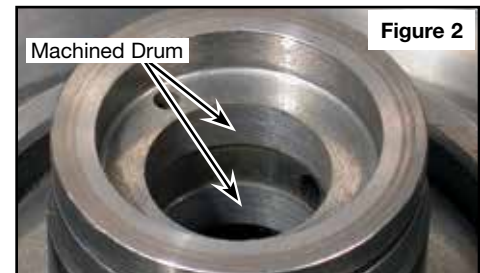
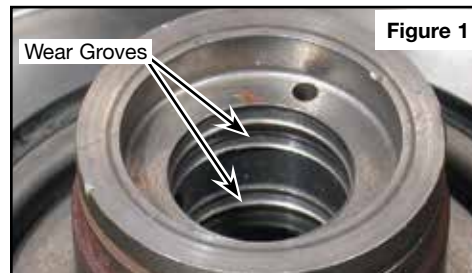
WARNING: Recommended tool kit 34716-TL is no longer in production. Check with your distributor for availability.

GM 4L80-E, 4L85-E



1. Inspection

Look for grooves worn into both sealing ring journals inside forward drum I.D. (Figures 1 & 2).



2. Installation

- Bore the forward drum ID to $.900" \pm .001"$. A surface finish $RA = 32$ micro-inch or better is recommended for optimal performance. Remove any sharp edges or burrs from the oil feed hole or machined bore.

NOTE: We recommend staining the end of the bore with Dykem® before machining. This will help to identify drums that are bored oversized and ensure assembly with the correct seals.

- Install the Sonnax oversized seal rings onto the input shaft.

NOTE: It is best to install the seals AFTER the input shaft has been installed in the overdrive planet. If seals are installed before, take extra care when inserting the input shaft through the O.D. planet splines to ensure the larger diameter sealing rings are not damaged by the O.D. planet splines.

- Place sizing tool over seal rings on the input shaft. Wait at least one minute. Remove sizing tool and insert input shaft into forward drum bore. Do not force the shaft into drum.