sonnax®

TRANSMISSION PARTS

Instructions

GM 400, 4L80-E, 4L85-E

Direct Drum Sleeve Kit

Part No.
34838-01K

- Sleeve
- Spring Pin

NOTE: In 4L80-E units, part can be used in either early or late-model drums.

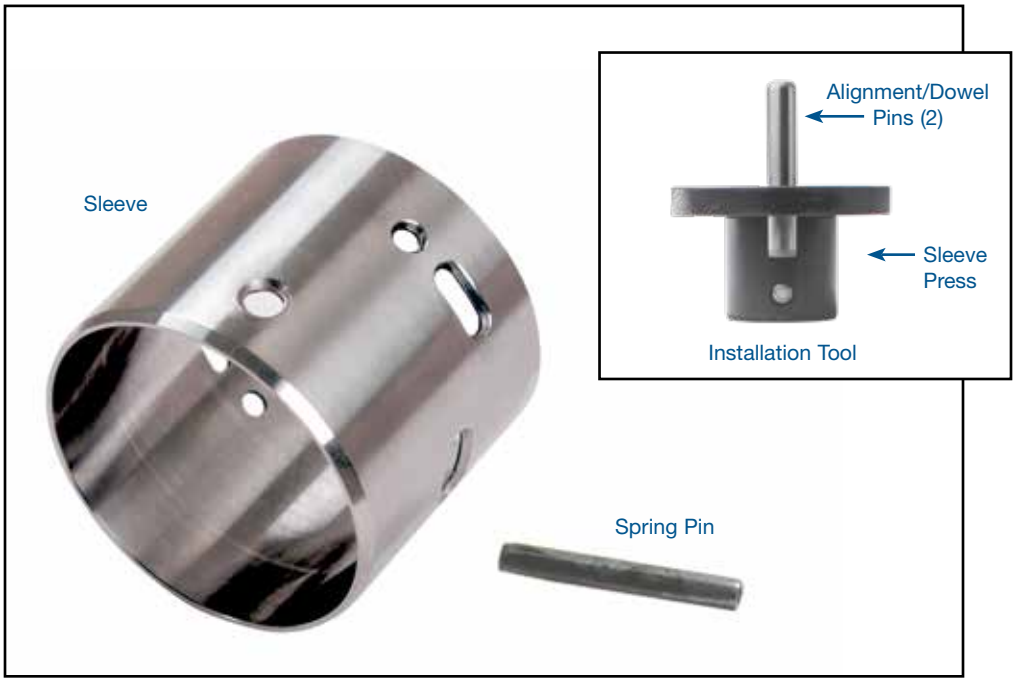
Recommended

Installation Tool

Part No.
34838-TL

- Sleeve Press/Installation Tool
- Alignment/Dowel Pins (2)

WARNING: This tool kit is no longer in production. Check with your distributor for availability.



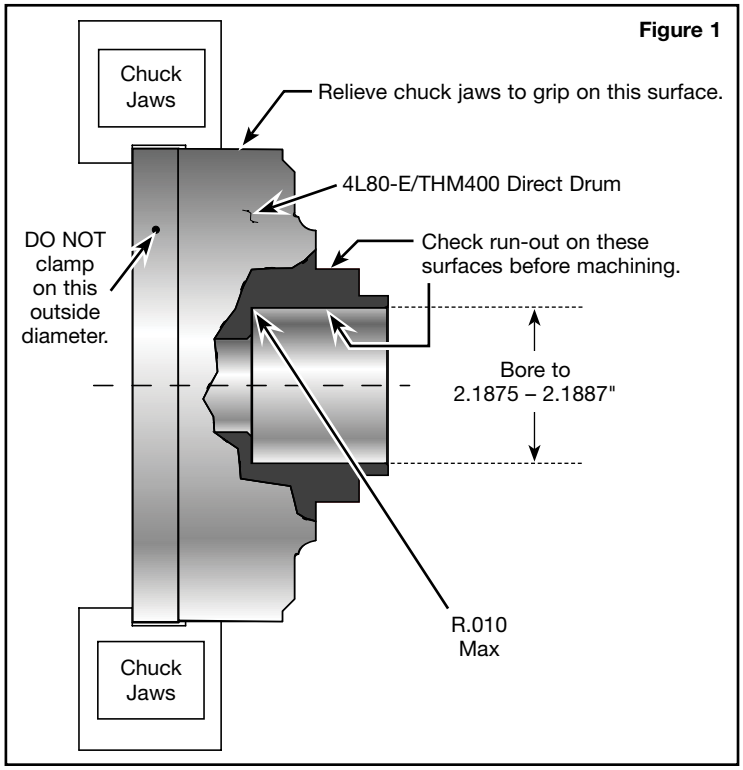
1. Machining Instructions

a. Fixture the direct drum in a 3-jaw chuck, with the center support bore facing outward.

b. Using a .0005" reading test indicator, check the run-out of the drum on both the bore and the race surface. Run-out of the drum installed in the lathe must be less than .001" TIR. If the observed run-out is greater than .001" TIR, realign chuck or re-fixture the drum as necessary.

c. Turn drum bore to a diameter of 2.1875 – 2.1887". The resized bore must have a 63-microinch or better surface finish.

Figure 1



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2. Installation & Assembly

NOTE: Use of the Sonnax sleeve installation tool is recommended to ensure proper alignment of the sleeve in the bore.

a. Slide and align the sleeve over the installation tool hub until the .218" diameter sleeve hole has engaged the spring plunger ball on the tool hub (**Figure 2**).

b. Place the two .500" diameter alignment pins vertically on the direct drum so that they are mated with the machined crescents on the direct drum (**Figure 2**).

c. Locate the 3rd/Reverse apply feed hole in the drum, which will be aligned with one of the machined crescents.

d. Postition the sleeve/tool assembly over the drum bore, sleeve side down, rotate the tool until the spring plunger ball is aligned with the 3rd/Reverse apply hole. The center of the clutch feed hole is located approximately 1.4" from face A (**Figure 2**). The dowel pin holes in the tool hub should now be aligned with the two dowel pins (**Figure 3**).

e. Lubricate the outside diameter of the sleeve to aid installation. Using an arbor press, press directly on the installation tool, install the repair sleeve into the drum.

f. The installation tool flange should bottom against the drum hub surface. Remove the installation tool.

g. After installing the new sleeve, drill a 1/16" x .525" - .535" deep hole between the sleeve O.D. and the direct drum I.D. Apply a drop of Loctite® into the hole and then press in the spring pin provided. The spring pin must be flush with or below the carrier surface.

h. Ensure the hole is deeper than the spring pin and the pin does not install with excess force. If it does, the sleeve may deform in that area.

3. Sleeve Surface Finish

a. If using PTFE piston rings, the sleeve surface finish is correct as supplied.

b. If using either cast iron or Peek® piston rings, the sleeve surface finish should be roughened slightly. Using Scotch-Brite®, mar the surface to obtain the equivalent of a 63-microinch surface finish.

Figure 2

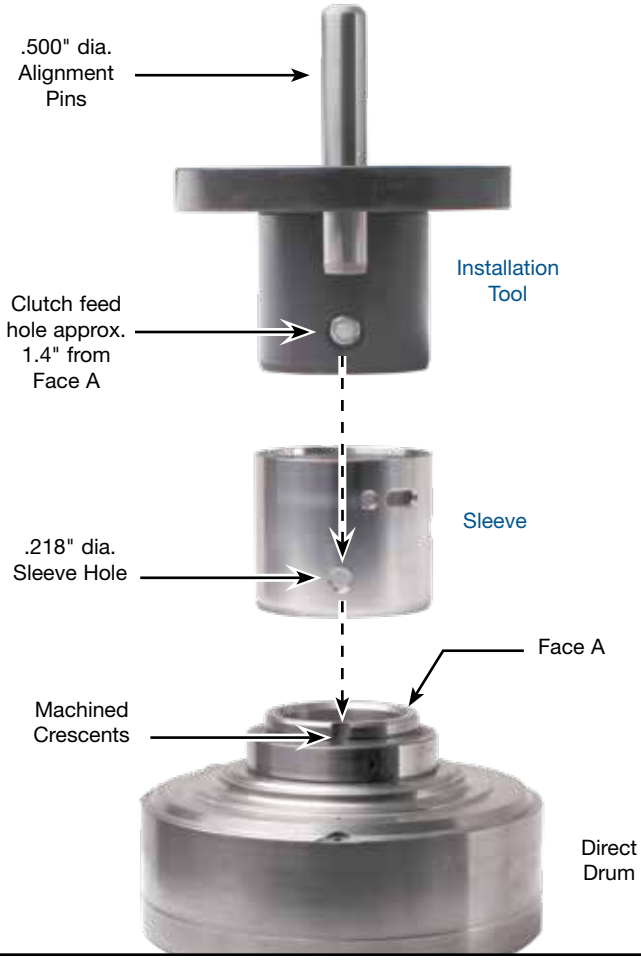

Figure 3