

#### REPLACEMENT SEAL KIT INSTRUCTIONS:

#### Part No.

**77767K-SK**

Replacement Seal Kit

1. Remove the Sonnax "Super-Hold" Servo from the transmission case.
2. Disassemble the servo assembly by removing the snap ring and both pistons.
3. Replace the worn seal ring or D-ring in the large piston with the new D-ring from the seal kit.
4. If the small piston has the original square cross-section seal ring, modify the groove diameter to 1.950" as shown in Figure 2 and install the small D-ring. If your servo assembly already has the D-ring, the new D-ring will fit without modification. (See identification information below.)
5. Replace the O-ring in the inside groove of the separator housing and on the OD of the cover and reassemble per diagram in Figure 3.
6. If you are installing the servo into a different transmission it may be necessary to readjust servo pin travel:
  - a. To measure servo pin travel, remove the outer O-ring from the servo assembly and slide the assembly into the case. Measure the distance the servo cover travels from the lock ring to the point where the band bottoms out on the drum when the servo cover is pushed into the case.
  - b. Change servo pins or grind the tip of the servo pin to achieve desired pin travel (typically .125").
  - c. Once desired servo pin travel has been verified, install outer O-ring onto servo cover and reinstall the Sonnax servo assembly.

#### HOW TO IDENTIFY THE EARLY OR LATE DESIGN SERVO:

The early Sonnax design servo used PTFE square cross-section sealing rings on each of the two pistons in the assembly. The later Sonnax design servo replaces these seals with Viton® D-rings for improved seal performance. The large D-ring replaces the seal ring on the larger of the two pistons and fits the groove on all versions without modification. If the smaller piston has the original square cross-section seal ring and has the raised groove diameter, you must machine the groove diameter to 1.950" in order to use the new D-ring.

Illustrations below refer to different seals and grooves on small piston only.

