

GM 200-4R

Super Hold Servo Kit

Part No.
K65703

- Cover (purple anodized)
- Piston
- Servo Pin
- Spacer
- Shim
- Spring
- E-clip
- O-Ring Seal (2)
- Lip Seal (2)
- Seal Ring (2)

Patent No. 6,907,974 & 7,047,611

Super Hold Servo Kit

Part No.
K65703-1

- Cover (non-anodized)
- Piston
- Servo Pin
- Spacer
- Shim
- Spring
- E-clip
- O-Ring Seal (2)
- Lip Seal (2)
- Seal Ring (2)

Replacement Seal Kit

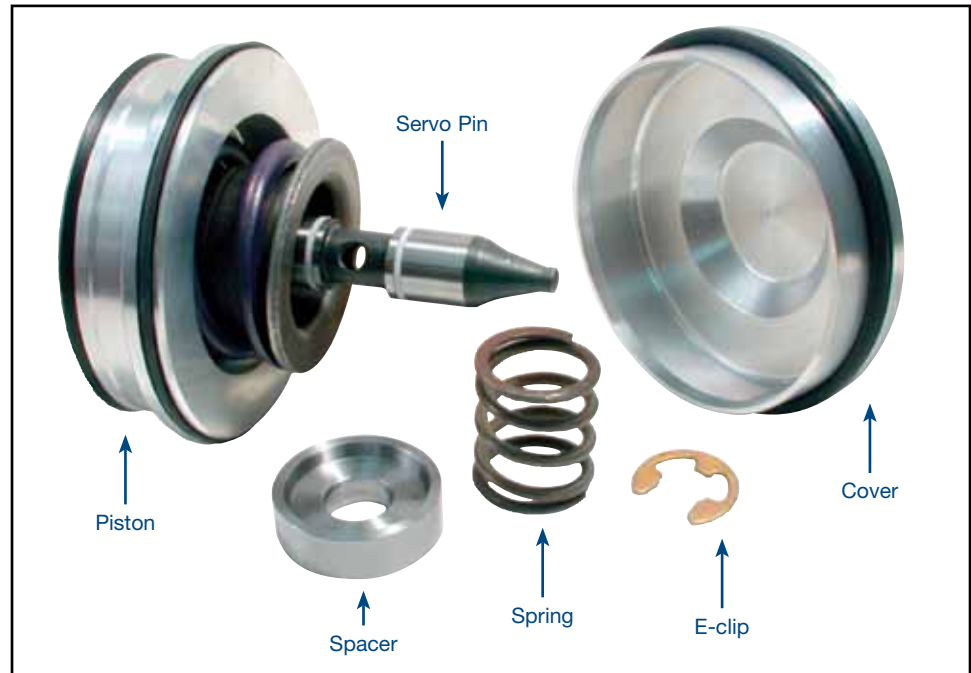
Part No.
65703-SK

- Seal Ring (2)
- Lip Seal (2)
- O-Ring Seal (2)

Replacement Servo Pin Kit

Part No.
65703-14K

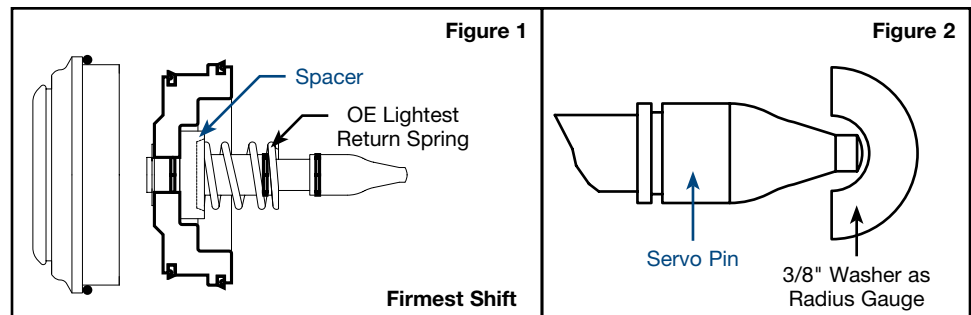
- Servo Pin
- E-clip



1. Set Servo Pin Travel

- a. Remove OE servo assembly. Discard everything except the springs and bell-shaped spring retainer.
- b. Assemble replacement pin, spacer, piston, E-clip and cover (**Figure 1**).
NOTE: Do not install any seals or the large spring at this time.
- c. Place small return spring on the pin and install assembly with cover and retaining ring into case.
- d. Check servo travel by pushing on cover. Grind tip of servo pin as necessary to achieve desired travel (about .110").

NOTE: It is important to maintain the spherical tip radius when grinding the pin. The inner hole of a 3/8" flat washer cut in half makes a good gauge for this (**Figure 2**).



2. Select Servo Configuration

Recommended Set-up Procedure

Install all parts which come in kit with OE cushion spring, the bell-shaped spring retainer and the Sonnax return spring. Do not use thick spacer (**Figure 3**).

For the Firmest Shift Set-up Procedure

For the firmest 1-2 and 2-3 shift, install the Sonnax solid spacer in place of the cushion spring with the bell shaped retainer. Select the lightest OE return spring (**Figure 1**).

CAUTION: Using the firmest shift setup can cause excessively hard shifts which lead to broken parts.

Spring Options for Shift Tuning

Cushion Spring (larger spring)

Lightest: Common yellow spring OE # 8628109

Heaviest: Red spring OE # 8639264 (some models)

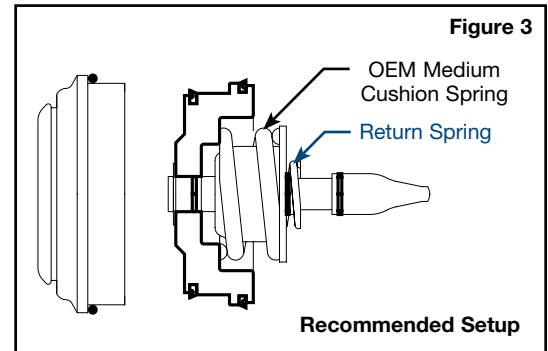
NOTE: The shim supplied with the Sonnax servo kit is optional. Add the shim to increase the cushion spring rate.

Return Spring (smaller spring)

Lightest: Common original spring (pink) OE # 8632661

Medium: Sonnax spring (included in kit)

Heaviest: Uncommon spring (black) OE # 8632147



3. Install Servo

Install seals on pin, on piston and cover. Lubricate with assembly gel and install servo assembly into case.

4. Air Test Servo

Leak test the 2nd apply and 3rd release sides of the servo with 1/4" O.D. tubing and a short piece of rubber vacuum line (**Figure 4**).