

4th Accumulator Repair Kit

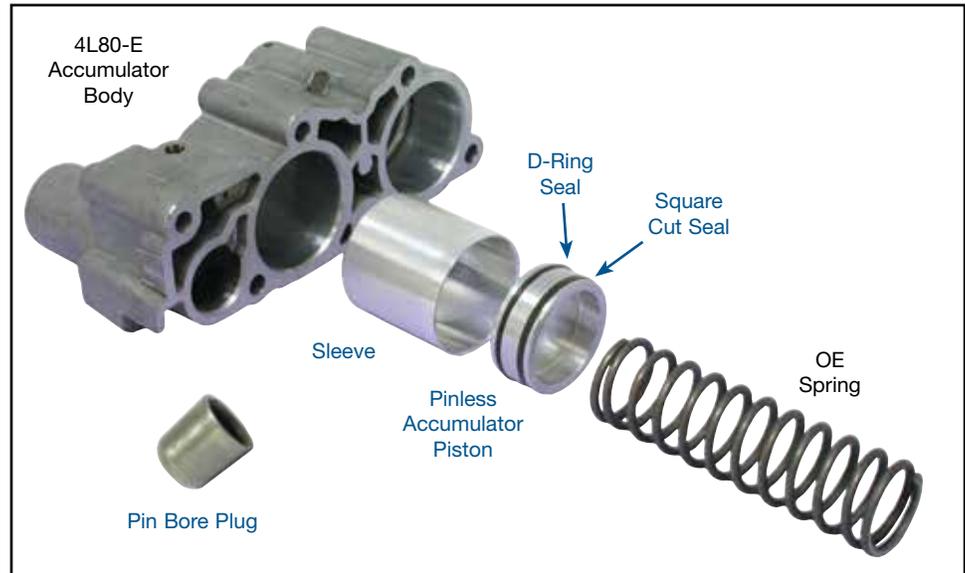
Part No.

34805-01K

- Sleeve
- Pinless Accumulator Piston
- Square Cut Seal PTFE
- D-Ring Seal Rubber
- Pin Bore Plug

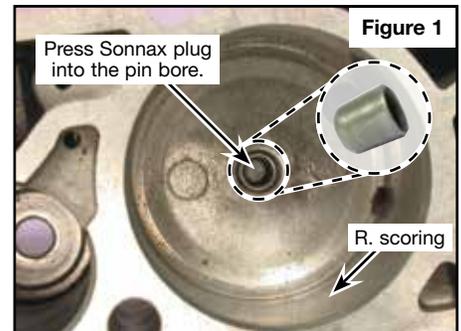
Patent 6,899,211

GM 4L80-E, 4L85-E



1. Disassembly & Repair

- Remove OE piston and pin.
- Press Sonnax plug into the pin bore (**Figure 1**).
- Remove any raised material from within the piston bore.
- Thoroughly clean the bore and repair sleeve with a Loctite® compatible solvent.
- Apply Loctite® 609 (or equivalent) to the O.D. of the sleeve and to the housing bore.



2. Installation

- Press Sonnax sleeve into bore with an arbor press, and an appropriately sized arbor. The sleeve will sit .070-.095" above the surface of the accumulator housing (**Figures 2 & 3**).
- Remove any excess Loctite®.
- Install Sonnax PTFE square cut seal into the open end groove of the piston and Sonnax D-ring into the closed end groove of the piston (**Figures 2 & 3**).
- Lubricate Sonnax seals with Transjel® or equivalent.
- Install Sonnax pinless accumulator piston into the sleeve.

