sonnax®

TRANSMISSION PARTS

Instructions

GM 6T70/75/80 (Gen. 2)

Oversized Actuator Feed Accumulator Piston Kit

TOOL REQUIRED

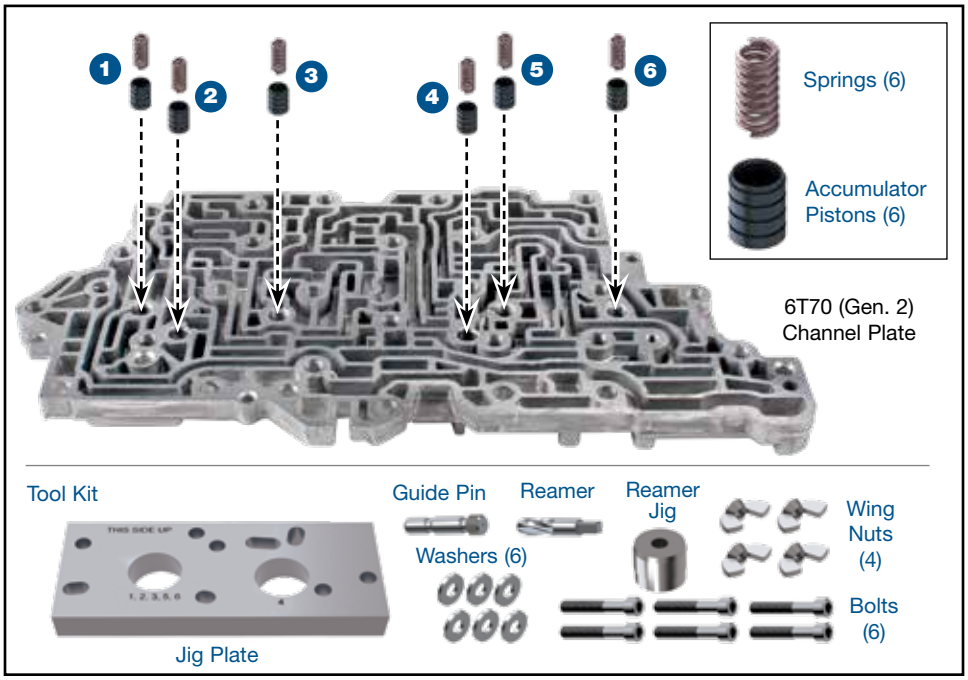
Part No.
124740-65K

- Accumulator Pistons (6)
- Springs (6)

Tool Kit

Part No.
124740-TL40

- Wing Nuts (4)
- Washers (6)
- Bolts (6)
- Jig Plate
- Reamer Jig
- Guide Pin
- Reamer



1. Disassembly

Remove and discard all six OE accumulator pistons and springs.

2. Bore Reaming

a. Place OE channel plate on bench with OE accumulator bores facing upwards.

b. If necessary to level and stabilize channel plate, fit two washers over two bolts and slide them up through channel plate holes (**A & B; Figure 1**).

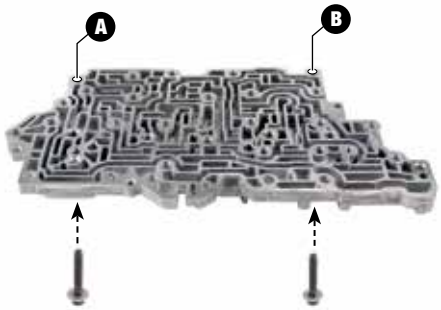
c. Position Sonnax jig plate and use the wing nuts and bolts to gently hold it in place (**Figures 2 – 7**).

d. Recommend using small plate and clamp to secure casting to bench, ensuring not to damage machined surfaces of the casting (**Figure 8**).

e. Install Sonnax reamer jig into specified hole (**Figures 2 – 7**).

f. Slide Sonnax guide pin through reamer jig and into casting accumulator bore until bottomed.

6T70 (Gen. 2) Channel Plate **Figure 1**



Use 2 washers & 2 bolts to stabilize channel plate.

Figure 2

Setup: Position #1 Jig Plate & Reamer Jig

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2. Bore Reaming (continued)

g. Once guide pin, reamer jig and jig plate are aligned with bore to be reamed, securely tighten wing nuts. Ensure jig plate is tightly held in place while allowing guide pin to stroke freely in reamer jig and casting bore (**Figure 9**).

h. Remove guide pin and insert Sonnax reamer into reamer jig (**Figure 10**).

i. Ream bore with steady, clockwise rotation using either speed handle or regulated air drill. Once reaming is complete, spin the reamer a few more times to burnish and improve surface finish (for full reaming instructions/reamer care, please visit www.sonnax.com).

j. Repeat steps 2c–2i for remaining accumulator bores in channel plate.

k. If necessary, deburr bore entrances slightly to facilitate assembly of the oversized accumulators.

l. Thoroughly clean the channel plate after reaming.

3. Installation & Assembly

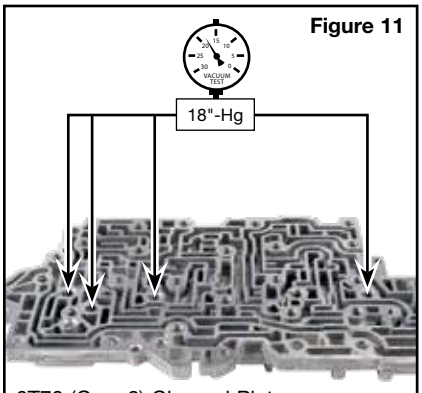
a. Install Sonnax accumulator pistons, pocket side up.

b. Install Sonnax springs into pistons (**main image**).

4. Final Testing

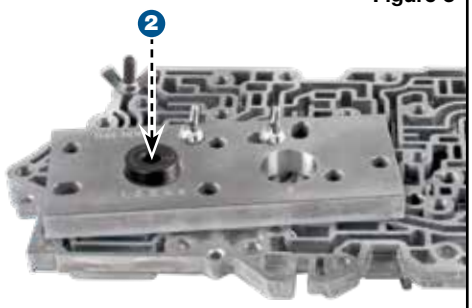
Vacuum testing at the port(s) indicated holds the recommended minimum 18 in-Hg (**Figure 11**).

Figure 11



6T70 (Gen. 2) Channel Plate

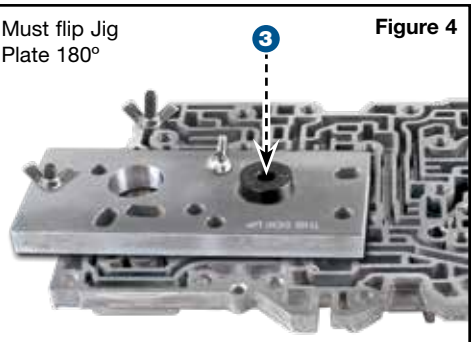
Figure 3



Setup: Position #2 Jig Plate & Reamer Jig

Figure 4

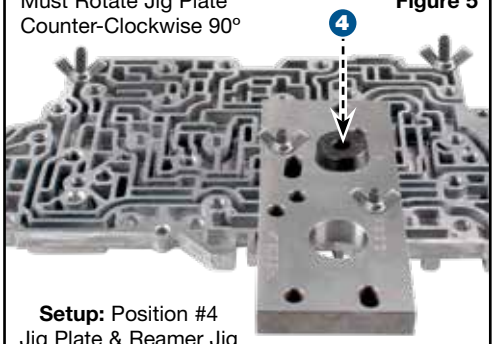
Must flip Jig Plate 180°



Setup: Position #3 Jig Plate & Reamer Jig

Figure 5

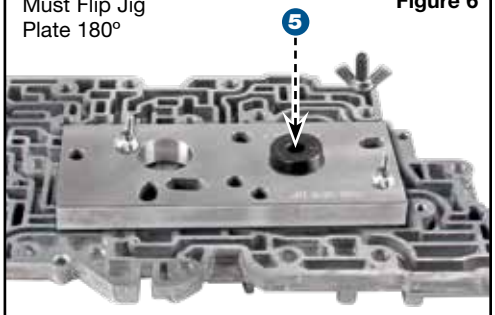
Must Rotate Jig Plate Counter-Clockwise 90°



Setup: Position #4 Jig Plate & Reamer Jig

Figure 6

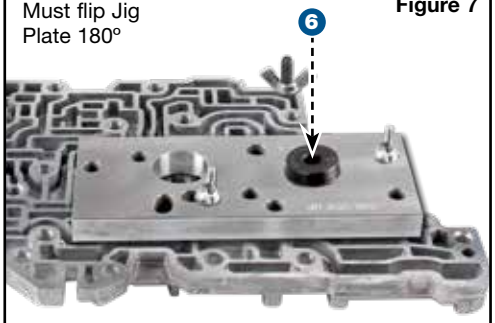
Must Flip Jig Plate 180°



Setup: Position #5 Jig Plate & Reamer Jig

Figure 7

Must flip Jig Plate 180°



Setup: Position #6 Jig Plate & Reamer Jig

Figure 8

Reamer Jig

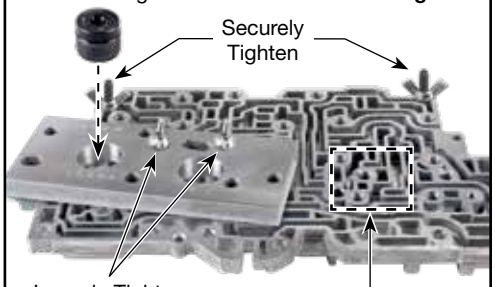
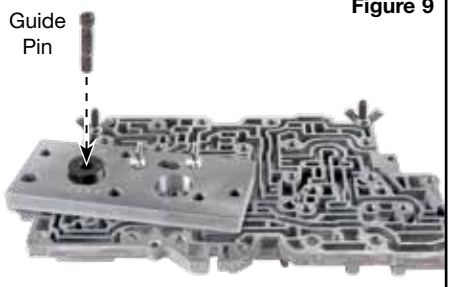
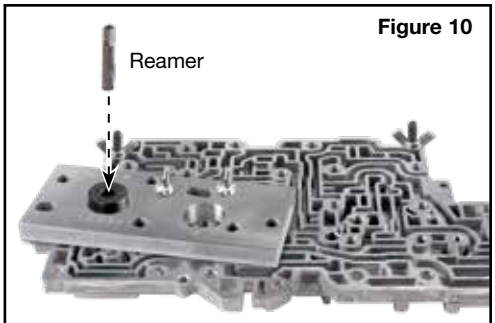


Figure 9



Securely tighten wing nuts on jig plate, holding all components together, while letting Sonnax guide pin move freely in OE accumulator bore.

Figure 10



Insert Sonnax reamer into reamer jig and ream bore.