

Oversized Actuator Feed Accumulator Piston Kit

Part No.
124740-40K

- Accumulator Pistons (3)
- Springs (3)



Tool Kit

Part No.
124740-TL40

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



NOTE: Original release 124740-TL40 with shown jig plate works in Gen. 1 only. To update to work in Gen. 2 applications requires purchase of jig plate 124740-JP40 below.

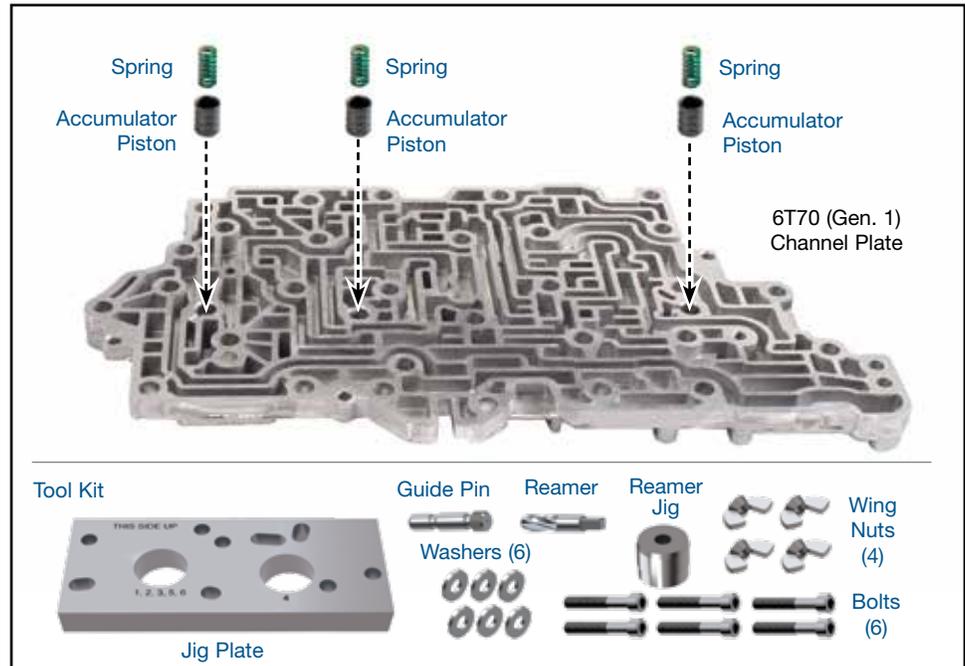
All new release 124740-TL40 tool kits include the updated jig plate 124740-JP40, so will work in Gen. 1 & Gen. 2 applications.

Jig Plate

Part No. Works with Gen. 1 & 2
124740-JP40



GM 6T70/75 (Gen. 1)

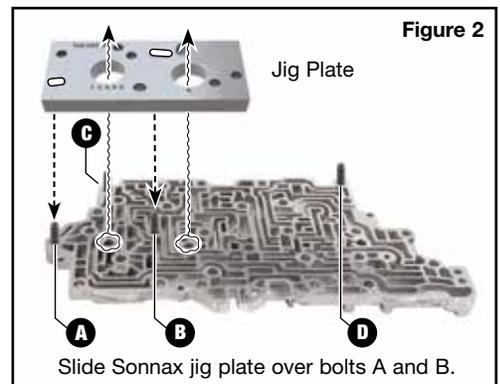
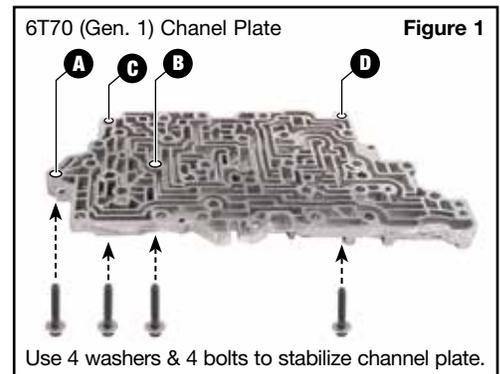


1. Disassembly

Remove and discard all three OE accumulator pistons and springs.

2. Bore Reaming

- Place OE channel plate on bench with OE accumulator bores facing upwards.
- Fit four washers, over four bolts and slide them up, through channel plate holes A-D to stabilize casting (**Figure 1**).
- Place Sonnax jig plate over bolts A and B, aligning two large plate holes over two casting accumulator bores (**Figure 2**).
- Place and securely tighten wing nuts on bolts C and D. Place and loosely tighten wing nuts on bolts A and B (**Figure 3**).
- Recommend using small plate and clamp to secure casting to bench (**Figure 3**).
- Install Sonnax reamer jig into left plate hole (**Figure 3**).
- Slide Sonnax guide pin through reamer jig and into casting accumulator bore until bottomed (**Figure 4**).



2. Bore Reaming (continued)

- h. 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 4).
- i. Remove guide pin and insert Sonnax reamer into reamer jig (Figure 5).
- j. 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).
- k. Leaving setup intact, repeat steps 2f-2j for second accumulator bore in channel plate (Figure 6).
- l. Reposition jig plate, clamp and plate, and add washers and bolts E and F as shown (Figures 7-8). Repeat steps 2f-2j to ream third accumulator bore (Figures 8-10).
- m. If necessary, deburr bore entrances slightly to facilitate assembly of the oversized accumulators.
- n. 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).

