

## Ford E40D, 4R100

### Performance Rated Accumulator Spring Kit

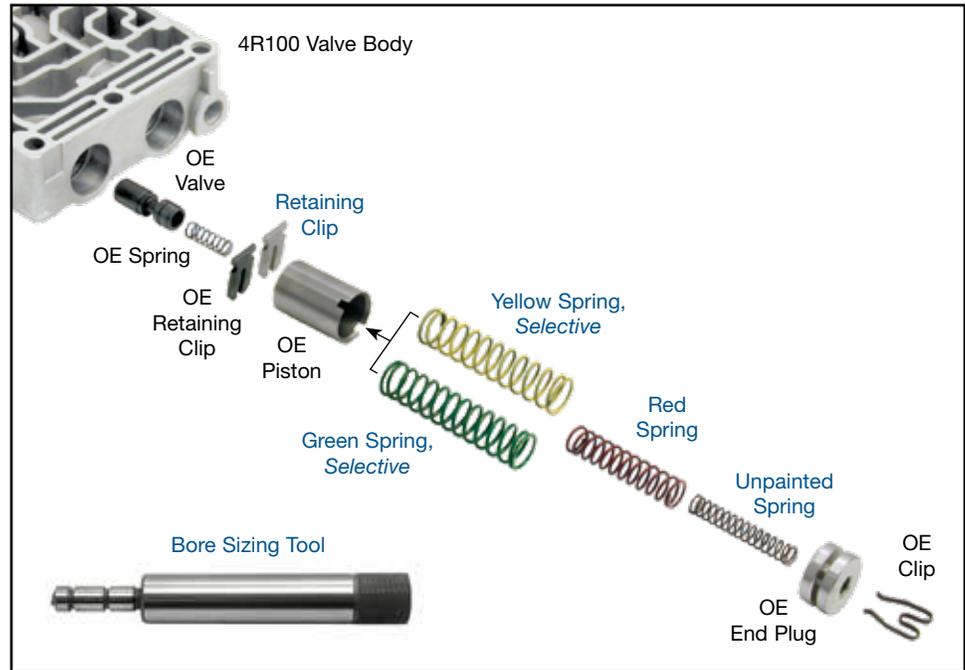
**Part No.**  
**36948-18K**

- Retaining Clips (3)
- Yellow Spring, *Selective* Large
- Green Springs (2), *Selective* Large
- Red Springs (3) Medium
- Unpainted Springs (3) Small

### Bore Sizing Tool

**Part No.**  
**36948-12**

**NOTE:** Recommended Tool.



**NOTE:** Accumulator regulator valves located in the bottom of the bore are known to stick in the bore, causing harsh or soft shifts and clutch failure. For proper operation these valves must move freely without binding. Sonnax bore sizing tool **36948-12** will clean up and restore the valve bore to OE dimensions and prevent these critical valves from hanging up.

#### Also Available

**1-2 & 2-3 Accumulator Control  
Valve Kit**  
**36948-13K**

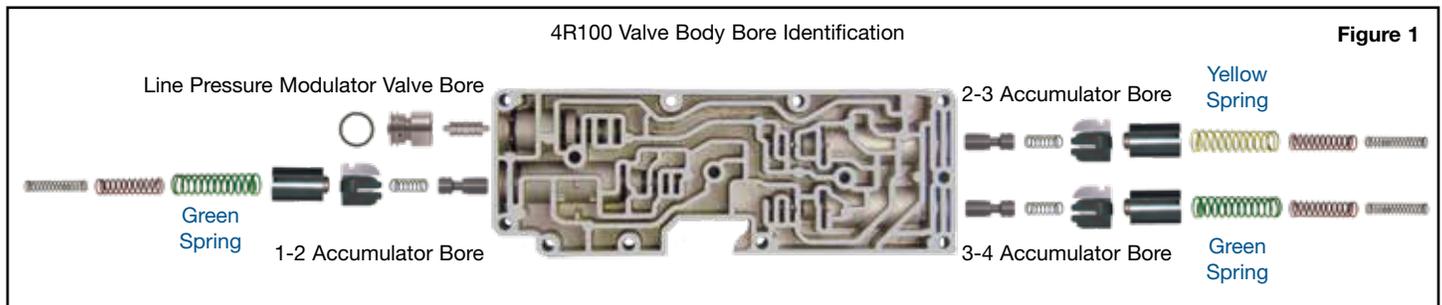
**3-4 Accumulator Control  
Valve Kit**  
**36948-09K**

#### 1. Disassembly

- Remove all components from the various accumulator bores, keeping OE valve, small spring, retaining clip, piston, end plug and clip from each bore for reuse.
- Discard remaining OE parts.

#### 2. Assembly

- Clean bore(s) thoroughly.
- Reference **Figure 1** for the proper positioning of OE and Sonnax parts.



### 2. Assembly (continued)

- c. Sonnax retaining clip works in conjunction with the OE retaining clip. Place Sonnax clip under the bent metal hook of the OE clip (**Figure 2**). This will help retain both clips in the valve body.
- d. Install the assembled OE and Sonnax clip (**Figure 2**). Sonnax bore sizing tool **36948-12** can be used to compress the spring while installing the retainer set.
- e. Reassemble OE pistons, Sonnax selective springs (**Figure 1**), OE end plugs and retaining clip.

