

Ford 4R70E, 4R70W, 4R75E, 4R75W, AODE

1-2 Accumulator Sleeve Kit

Part No.

76890-01K

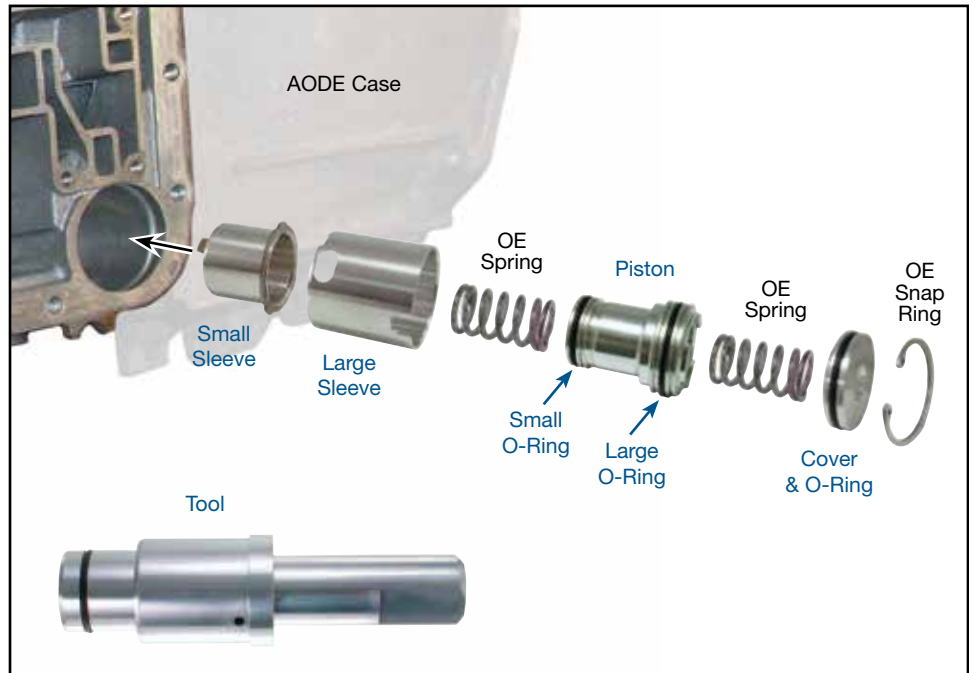
- Sleeve Small
- Sleeve Large
- Piston
- Piston O-Ring Small
- Piston O-Ring Large
- Cover
- Cover O-Ring

Tool

Part No.

76890-TL

NOTE: This installation tool is not required but is recommended to simplify installation and ensure proper sleeve orientation.

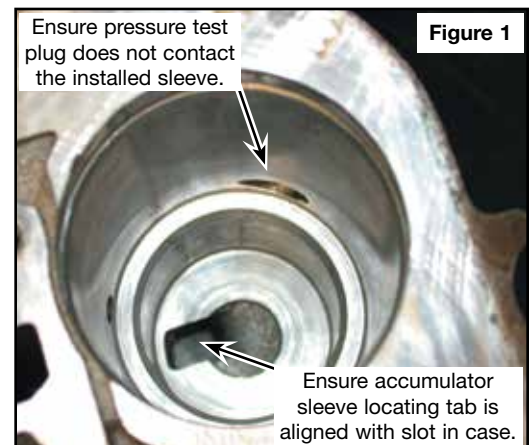


1. Case Preparation

- a. Remove pressure test plug. If it is a long style pipe plug, grind the end of it so it will not contact the sleeve when reinstalled (**Figure 1**).
- b. Remove any high spots or burrs from the accumulator bores and thoroughly clean the bores with a Loctite® compatible solvent.
- c. Apply an even coat of Loctite 609 or equivalent to the small case bore and the outer diameter of the Sonnax small sleeve as per Loctite instructions.
- d. Use a swab to apply the Loctite to the bottom of the smaller bore.

2. Installation & Assembly

- a. Place Sonnax small sleeve in the case bore, align the sleeve locating tab with the slot in the bottom of the case bore (**Figure 1**), and, if needed, use the old cover to push the sleeve all the way in until bottomed.
- b. Repeat Loctite application process for the large bore diameter and large Sonnax sleeve.
- c. Place Sonnax large sleeve in accumulator bore, align tabs and slots, and if needed use the old cover to push Sonnax large sleeve in all the way in until bottomed.
- d. Remove any residual Loctite.



2. Installation & Assembly (continued)

- e. Verify that the oil feed holes are not covered by the Sonnax sleeves.
- f. Reinstall OE pressure tap pipe plug (shortened if needed) and verify that the plug does not hit the installed Sonnax sleeve (**Figure 1**).
- g. Install two Sonnax O-rings onto the Sonnax accumulator piston. Apply ATF to the rings and insert Sonnax accumulator piston assembly into the newly re-sleeved bore.
- h. Reinstall OE spring.
- i. Install Sonnax cover O-ring onto Sonnax cover. Apply ATF to the O-ring, and insert Sonnax cover assembly into the case. Secure the assembly with OE snap ring.

NOTE: Allow Loctite® to thoroughly cure before operating the transmission.