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TRANSMISSION PARTS

Instructions

Ford 5R55N/W/S

Overdrive & Intermediate Servo Pin Bore Sleeve Kit

Part No.
56361J-01K

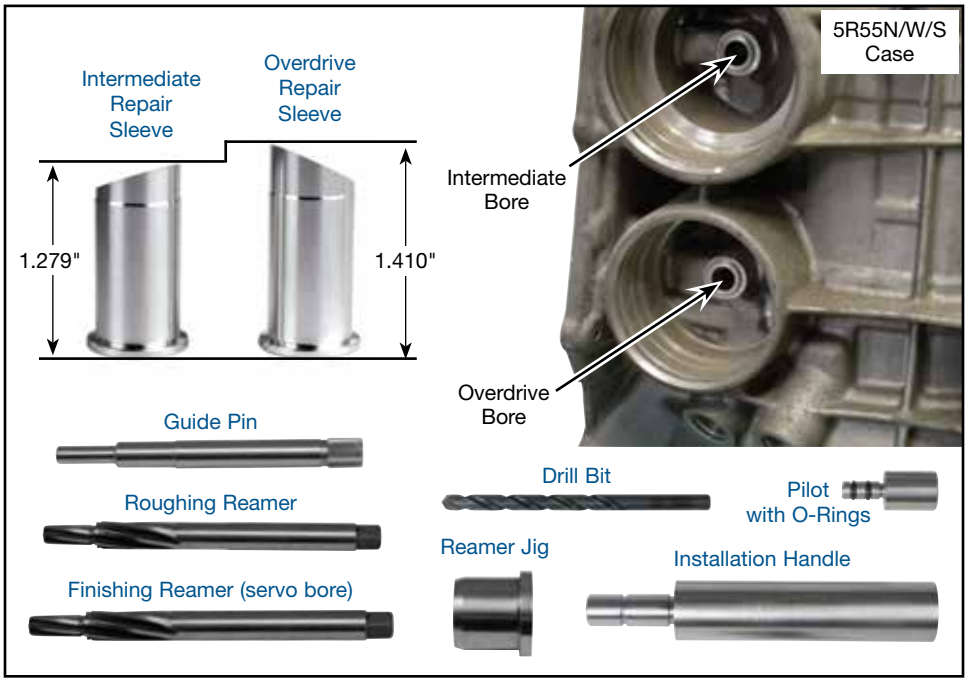
- Overdrive Repair Sleeve
- Intermediate Repair Sleeve

Tool Kit

SERVO FIXTURE REQUIRED

Part No.
S-56361J-TL

- Drill Bit
- Roughing Reamer
- Finishing Reamer
- Guide Pin
- Reamer Jig
- Installation Handle
- Pilot
- O-Rings (2)
- Flex Hone, *not shown*



1. Preparation & Set-Up

a. Remove servo assembly from case and thoroughly clean servo pin bore.

b. Test fit Sonnax guide pin in the pin bore to be reamed. If guide pin installs easily, proceed to next step. If guide pin sticks in bore, deburr the bore with Sonnax flex hone (included in tool kit **S-56361J-TL**) until guide pin can be smoothly inserted.

c. Install Sonnax **SERVO-FIX** onto case. For **SERVO-FIX** set-up instructions, please visit www.sonnax.com or refer to instructions included in **SERVO-FIX** kit.

2. Reaming

a. Install reamer jig from tool kit **S-56361J-TL** into **SERVO-FIX**.

b. Use guide pin from tool kit to align reamer jig properly with bore.

NOTE

NOTE: Once servo pin bore is aligned with the **SERVO-FIX**, do not disturb or loosen the fixture or guide setting in any way until both reamers have been used and the reaming process is complete. Be sure to use plenty of continuously-supplied cutting fluid during reaming.

c. Gently insert roughing reamer through jig until cutting tip contacts bore opening.

d. Use a speed handle or a low-speed, high-torque drill fitted with a wobble adapter to turn the reamer in the bore. Never use a ratchet or pliers. Reaming action must be clockwise in a smooth and continuous motion, at 60-120 rpm.

CAUTION

CAUTION: Never turn reamer counterclockwise, not even when removing from bore. Turning counterclockwise will dull or damage reamer.

e. Continue reaming until the reamer cuts completely though the bore. Remove roughing reamer and use low air pressure to blow away chips.

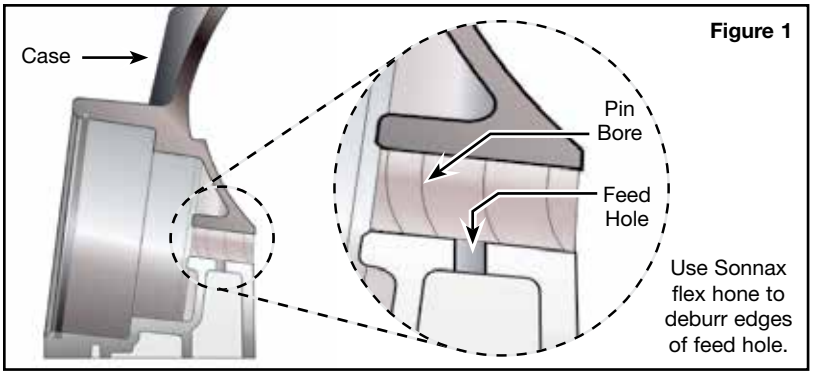


Figure 1

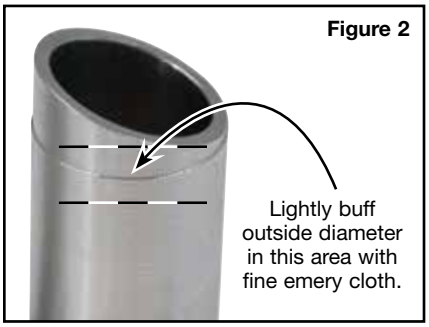


Figure 2


Figure 3

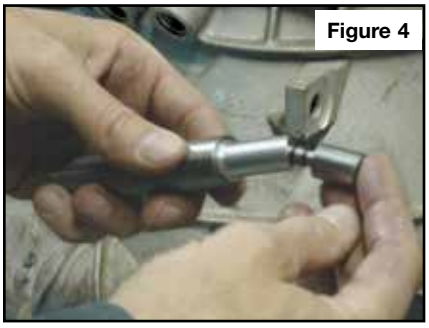


Figure 4

2. Reaming (continued)

f. Gently insert finishing reamer (reamer marked "Servo Bore") through jig and repeat steps "c" through "e".

g. Remove **SERVO-FIX**. Clean reamers and servo bore with low air pressure and solvent.

3. Tech Tips

To help ease sleeve installation:

a. Thoroughly deburr feed hole in reamed pin bore with Sonnax flex hone (**Figure 1**).

b. Use fine emery cloth to lightly buff outer diameter of sleeve at stepped location (**Figure 2**).

4. Installation & Assembly

NOTE: Select the correct Sonnax sleeve for the bore being serviced. The Overdrive bore sleeve is the longer of the two (Main image). Although the sleeves are designed as press-fit, use of sleeve retainer (such as Loctite 640) is highly recommended to aid in proper sleeve retention.

a. Remove the pilot from Sonnax installation tool by pulling gently.

b. Slide Sonnax sleeve over small end of installation tool handle, flanged end first (**Figure 3**).

c. Lubricate O-rings on Sonnax pilot.

d. Gently push the pilot back into the end of the installation tool, securing sleeve on the tool. (**Figure 4**).

e. Carefully apply a thin coat of sleeve retainer to the upper half outside diameter of Sonnax sleeve.

f. Press sleeve into bore by sliding the installation tool pilot into the case bore and then gently pushing/tapping the handle of the installation tool. Press just far enough to seat the sleeve flange against the case bore boss/face (**Figures 5 & 6**).

g. From the inside of the case, gently pull the pilot off the installation tool and set aside.

h. Using 15/64" drill bit from Sonnax tool kit, drill the apply hole into the wall of the sleeve, using the existing case apply hole as a guide (**Figures 7 & 8**).

CAUTION: Ensure drill bit does not contact the opposite wall of the sleeve.

i. Remove burrs from the inner diameter of the installed sleeve by inserting the installation tool WITHOUT the pilot attached.

j. Reassemble servo per OE specifications.


Figure 5

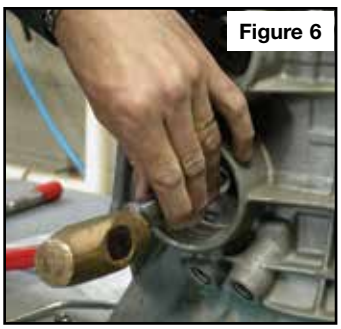
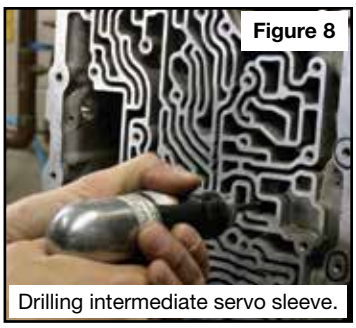


Figure 6


Drilling overdrive servo sleeve.
Figure 7


Drilling intermediate servo sleeve.
Figure 8