

Installation Instructions

High Performance 2-4 Servo

Part No. 70225

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The B&M High Performance 2-4 Servo is designed for greater torque capacity with a significantly firmer shift in most General Motors TH700 transmissions.

Before beginning, check the parts list to make sure you have all the necessary parts. Also check the tool list. A minimum of tools are required.

This Servo can be installed in a few hours by carefully following directions. Read all instructions first to familiarize yourself with the parts and procedures. Work slowly and do not force any parts.

Automatic transmissions operate at temperatures between 150°F and 250°F. It is suggested that the vehicle be allowed to cool for a few hours to avoid burns from hot oil and parts. The vehicle should be off the ground for ease of installation. Jack stands, wheel ramps or a hoist will work fine. **Make sure vehicle is firmly supported!!** Try to raise it 1 - 2 feet so you have plenty of room to work easily. Also have a small box or pan handy to put

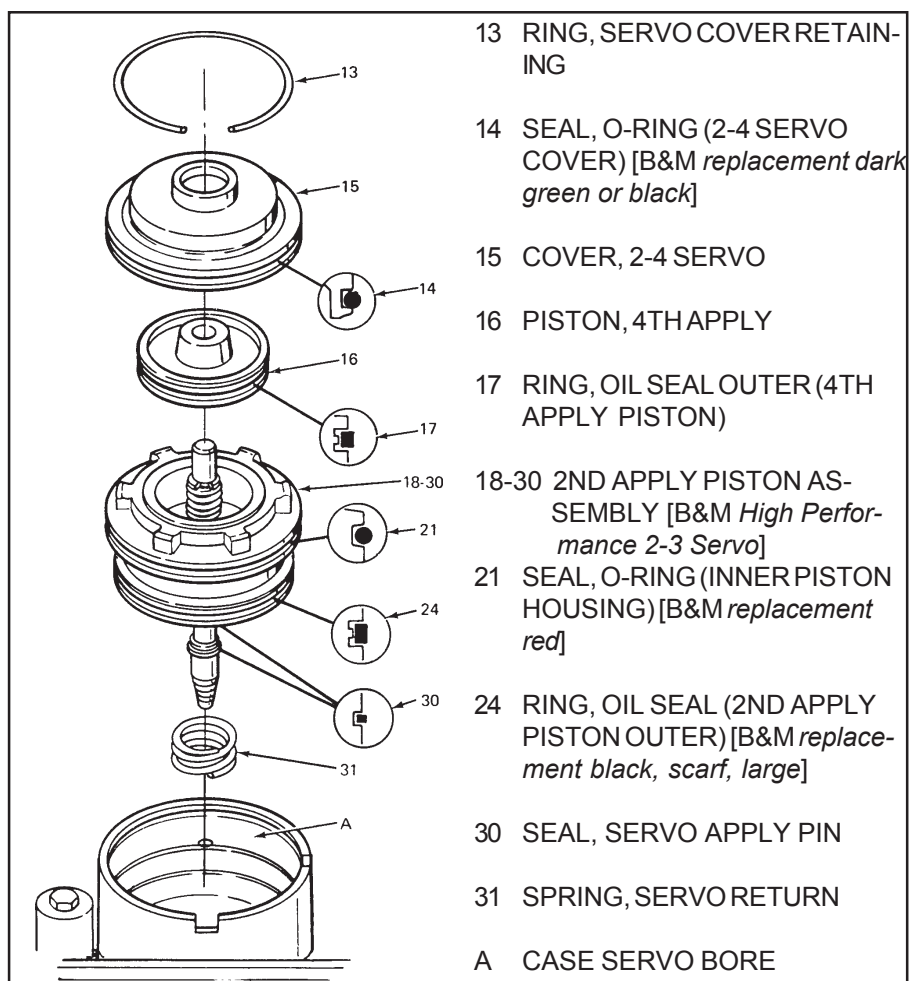


FIGURE 1. Servo Removal / Installation

parts in so they won't be lost.

NOTE: It may be necessary in some instances for transmission removal. Refer to your vehicles

service manual.

DISSASSEMBLY

STEP 1. (Refer to figs 1 and 2) Remove the servo cover retain-

ing ring (13).

STEP 2. Remove Servo Cover and O-ring seal (14). The only way to remove the servo cover easily is to first work the cover out until the o-ring is visible through the two slots in the case. Hook the o-ring with a small screwdriver, then remove the o-ring by breaking it and pulling it from the cover. The cover can then be removed.

STEP 3. Remove the servo pin retaining ring (18), washer (19), and apply pin spring (20).

STEP 4. Remove the 2nd apply piston pin (29).

STEP 5. Remove the retaining ring (28).

STEP 6. Remove the cushion spring retainer (27) and cushion spring (26).

INSPECT

STEP 7. Inspect springs for distortion and replace as necessary.

IMPORTANT: Check servo bores (A) in the case for any wear or sharp edges which may cut the servo seals (see fig. 1).

ASSEMBLY

STEP 8. (Refer to figs 1 and 2 for assembly) Install cushion spring (26) into the B&M High Performance 2-4 Servo Piston (25), cushion spring retainer (27) on top of the cushion spring.

STEP 9. Compress spring retainer just past the retaining ring groove in the B&M High Performance 2-4 Servo Piston (25) and install the retaining ring (28).

STEP 10. Install the B&M High Performance 2-4 Servo Piston (25) on the 2-4 servo apply pin (29) with spring (20), washer (19) and retaining E-ring (18) on the 2-4 servo apply pin (29).

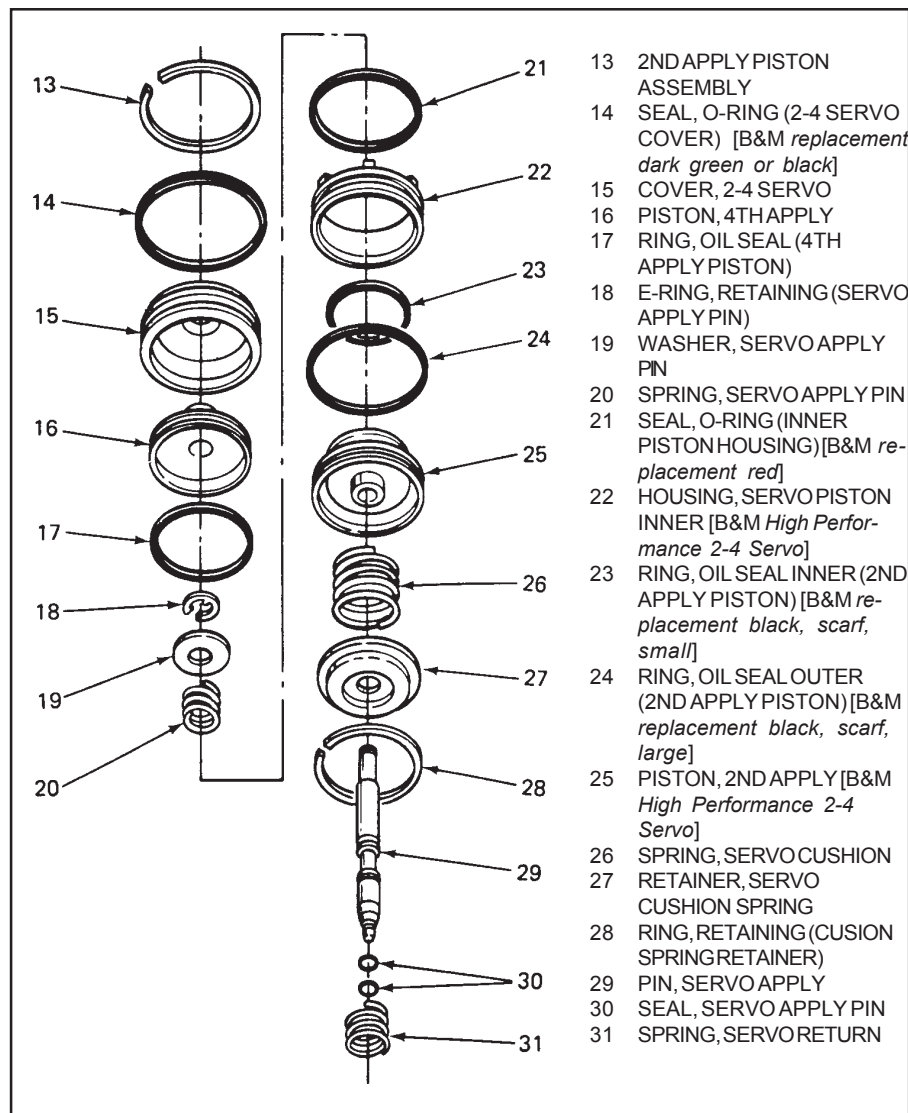


FIGURE 2. Servo Disassembly / Assembly

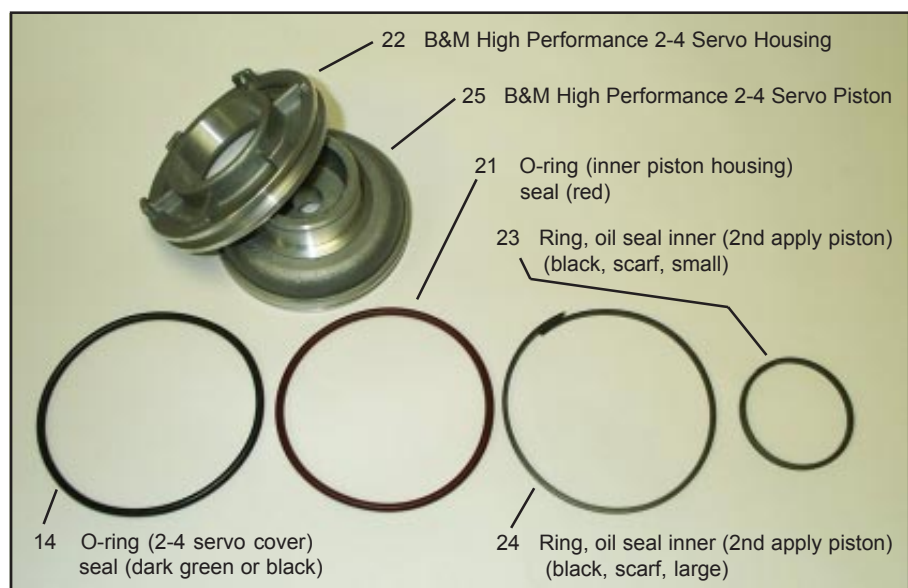


FIGURE 3. B&M High Performance 2-4 Servo (Parts)

STEP 11. Assemble the supplied replacement inner (23) and outer (24) oil seal rings on the B&M High Performance 2-4 Servo Piston (25). Lubricate seals with multi-purpose grease to hold in place.

STEP 12. Place supplied red o-ring seal (21) onto the B&M High Performance 2-4 Servo Housing (22). Lubricate the seal with multi-purpose grease.

STEP 13. Install the B&M High Performance 2-4 Servo Piston (25) into the B&M High Performance 2-4 Servo Housing (22).

STEP 14. Place the B&M High Performance 2nd apply servo assembly into the servo bore. Lubricate the servo bore with multi-purpose grease.

STEP 15. Install the 4th apply piston (16) into the servo bore (15).

STEP 16. Assemble the supplied dark green or black o-ring seal (14) onto the servo cover (15). Lubricate seal with multi-purpose grease.

STEP 17. Push the servo cover (15) into the servo bore (A), depress the servo cover and install the retaining ring (13).

PARTS LIST

1	B&M High Performance 2-4 Servo Housing [22]
1	B&M High Performance 2-4 Servo Piston [25]
1	O-ring (2-4 Servo Cover) seal (dark green or black) [14]
1	O-ring (Inner piston housing) seal (red) [21]
1	Ring, oil seal inner (2nd apply piston) (black, scarf, small) [23]
1	Ring, oil seal outer (2nd apply piston) (black, scarf, large) [24]

TOOL LIST

1	Jack and Jack Stands, Wheel Ramps, or Hoist
1	Small Flat Blade Screwdriver
1	Medium Flat Blade Screwdriver
1	Multi-Purpose Grease