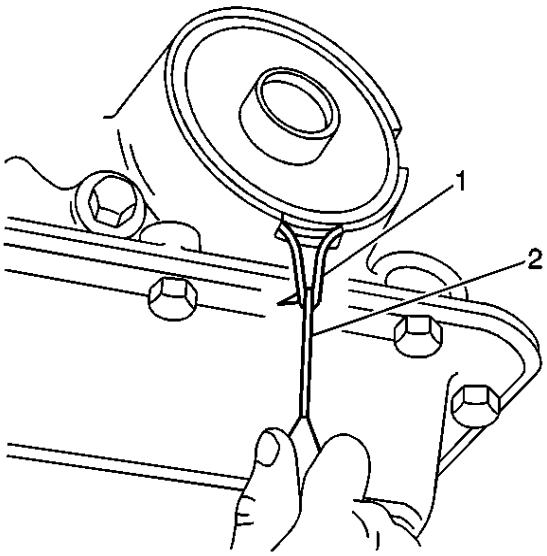
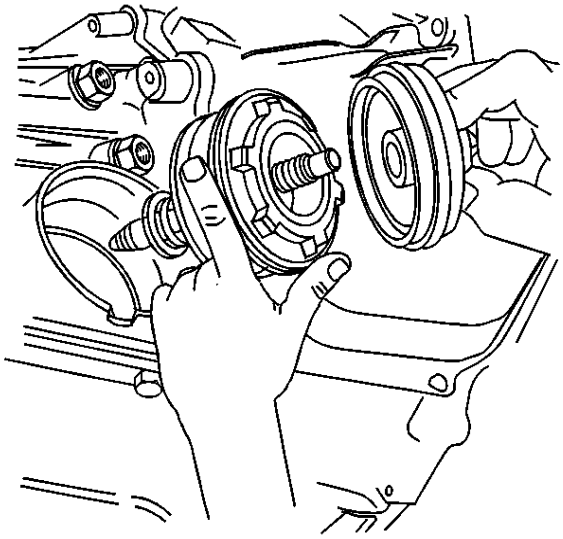
- **AT ALL TIMES: AVOID FOREIGN CONTAMINANTS FROM ENTERING TRANSMISSION**
- **THROUGHLY LUBRICATE ALL COMPONENTS PRIOR TO ASSEMBLY**
- **PROPERLY LIFT AND SUPPORT VEHICLE (IF NEEDED) PRIOR TO ATTEMPTING REPLACEMENT PROCEDURE**
- **ALLOW VEHICLE TO SUFFICIENTLY COOL PRIOR TO ATTEMPTING PROCEDURE; UNDER CAR COMPONENTS AND TRANSMISSION OIL CAN BE VERY HOT CAUSING SEVERE BURNS**

2-3 Servo Removal & Install Instructions

1. Compress the servo cover.
2. Remove the servo cover retaining ring (4L60E shown, 200 & 2004R similar).

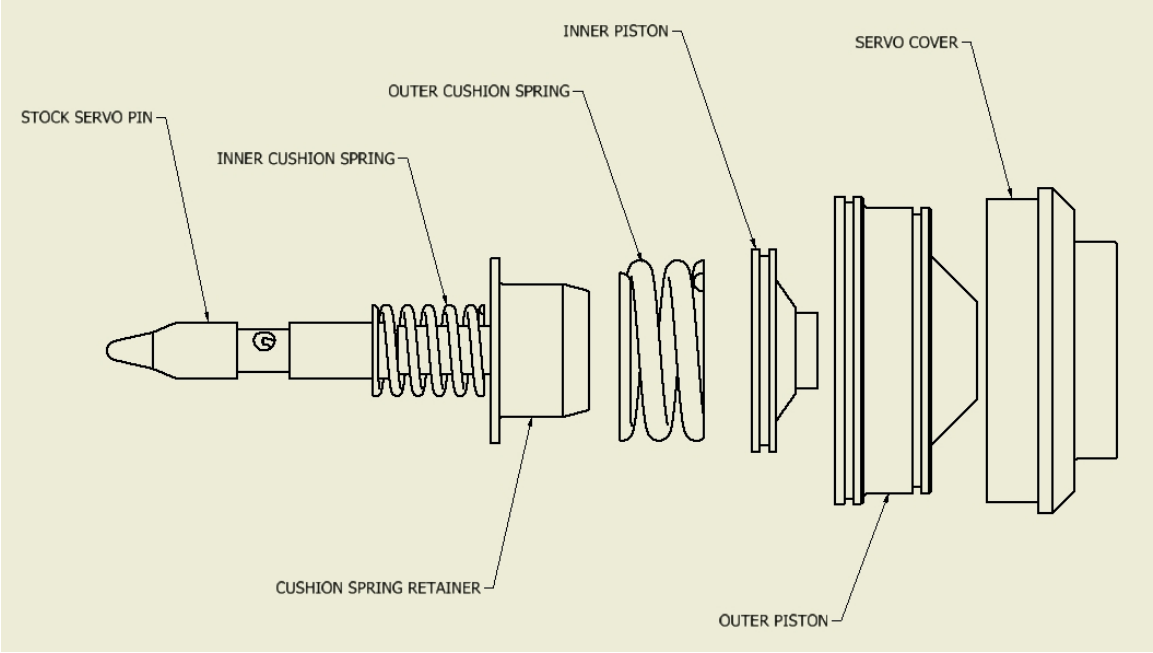


3. Remove the servo cover and O-ring seal. If the cover gets hung up on the seal, use a pick or a small screwdriver (2) to pull and stretch the seal (1) out of the groove. Cut the o-ring and slide out the O-ring seal before removing the cover.



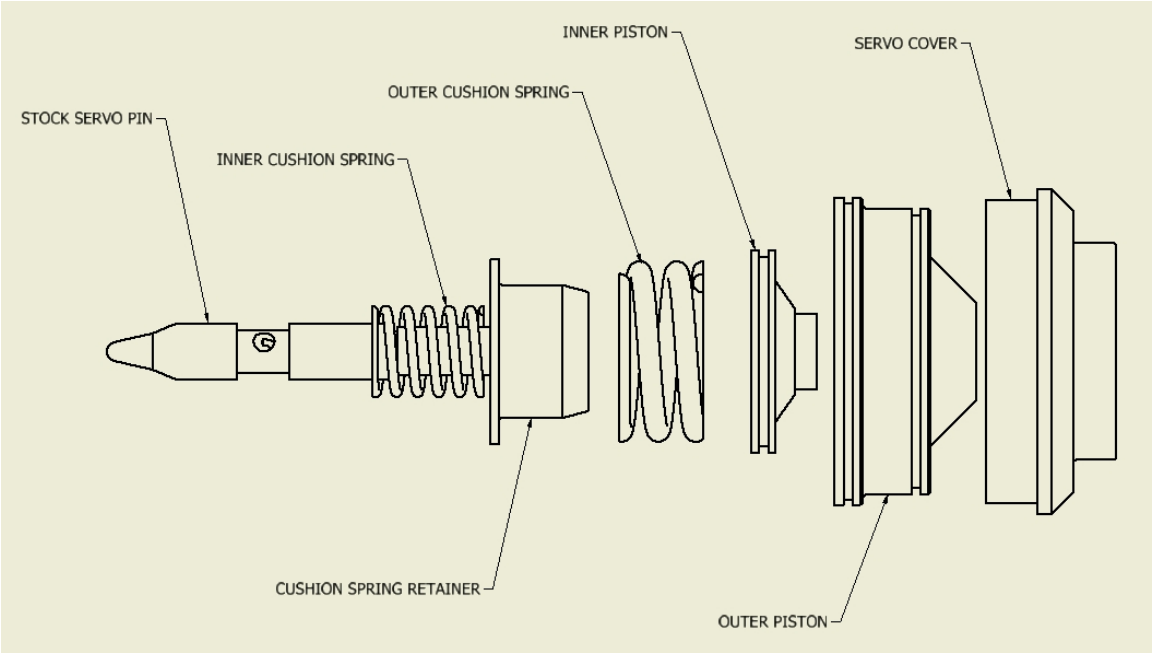
4. Remove the 2-3 servo assembly from the transmission (4L60E shown, 200 & 2004R similar). NOTE: on some vehicles, you may have to remove the servo assembly in pieces in order to avoid dropping the rear of the transmission.

2-3 Servo Disassemble



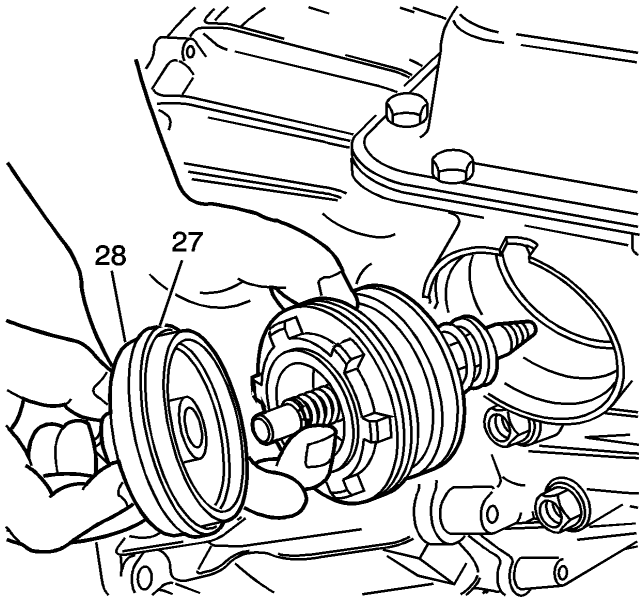
1. Disassemble the 2-3 servo assembly.

2. Remove the seal from the inner piston and discard. You will re-use this component without the stock seal inside the new outer piston we supplied with your kit.
3. Remove the stock outer piston and cover assembly and discard.



Assemble the 2-3 servo components in the order shown.

1. Reposition the servo apply pin through the cushion spring retainer, the outer cushion spring, the inner piston and the outer piston.
2. Reinstall inner cushion spring on the servo apply pin.
3. Take care to lubricate the servo bore.



1. Install the 2-3 servo assembly into the 2-3 servo bore (4L60E shown, 200 & 2004R similar).
2. Compress the servo cover.
3. Install the servo cover retaining ring, making sure the snap ring is fully and completely seated in the transmission case snap ring groove.