



**SF-99 Servo Bore Repair System
Master Kit, Ford C3, A4LD, 4R44E, 4R55E, and 5R55E type transmissions**

Apply oil for both the overdrive and intermediate servos in Ford's A4LD and it's electronic four and five speed successors, the 4R44E, 4R55E, and 5R55E, is routed through the hollow servo pins. This requires the pin to seal in the case. From the factory, this system works fine, but as the transmission ages and the servos go through many apply and release cycles, the case wears, creating a leak. This wear is compounded on the 5R55E, as it uses the overdrive servo for Second gear as well as Fifth. Not only does this wear leak apply, but it also allows release oil to escape, causing delayed engagements and dragging bands.

The A4LD kit contains tooling necessary to repair both the Overdrive and Intermediate servo pin bores.

Part No. TOOL.112



**SF-99 Servo Bore Repair System
Sub Kit, Ford C3, A4LD, 4R44E, 4R55E, and 5R55E type transmissions**

This Sub Kit can be used with any SF-99 Servo Bore Repair System Master kit, enabling it to be used to repair the above transmissions

Part No. TOOL.113



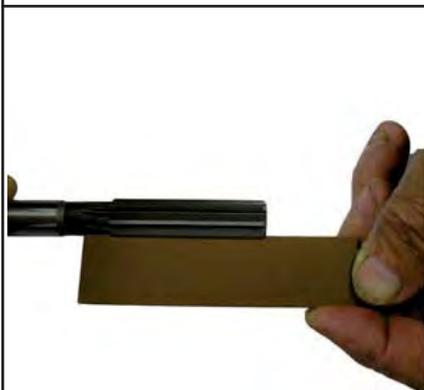
**SF-99 Servo Bore Repair System
Gauge Pins For accurately re sizing bushings after installation**

In order to get the best possible seal from the bushings we use, we machine them as close to the size of the pins as possible. However, in order for the bushing to seal and stay in place, it is necessary for the bushing to crush during installation. This "crush" effectively shrinks the bushing's inner diameter. These pins allow you to quickly and easily re-size the bushing to it's correct (something old servo pins don't always do) inner dimension.

The Gauge Pin kit contains tooling necessary to re-size every bushing in every kit we make. The pins are precision machined hardened steel, and they come in a plastic utility box.

Note: The Gauge Pin kit is only necessary if you purchased your tooling before 2005. In 2005, we started including each pin with it's respective kit.

Part No. TOOL.118



**SF-99 Servo Bore Repair System
Reamer Cleaning Stone**

Aluminum does not dull tool steel. Period. What happens instead is that the reamer collects aluminum on it's cutting edges. This phenomenon is not limited to our products. Check any cutting tool in your shop. These "build ups" of aluminum effectively become the new cutting edges. These build ups obviously do not cut as well as the tool steel and are also larger than the original diameter of the reamer. Translation- a larger bore that was a lot harder to cut. To combat these build ups, we offer a stone which fits between the flutes of the reamer and cleans the cutting edges up quite nicely.

Note: While aluminum will not dull tool steel, bear in mind that cases typically cast from recycled aluminum, which can contain steel.

Part No. TOOL.119