

FORD C-6 ALUMINUM SERVO KIT**“R” Code - Mid ‘68 and Later**

Part # 605411

PARTS LIST

- | | |
|--|---|
| <input type="checkbox"/> Servo Cover | <input type="checkbox"/> Cover Gasket |
| <input type="checkbox"/> Servo Assembly | <input type="checkbox"/> (2) Selective Return Springs |
| <input type="checkbox"/> Servo Pin O-Ring | <input type="checkbox"/> (4) 5/16-18 x 1 1/2" Studs (#951131) |
| <input type="checkbox"/> Servo Pin Teflon® Seal O-Ring | <input type="checkbox"/> (4) 5/16-18 Flange Nuts (#952100) |
| <input type="checkbox"/> Medium O-Ring | |
| <input type="checkbox"/> (2) Large O-Rings | Packed by: _____ |

**Disassembly**

Remove the old servo assembly and clean bore and gasket area.

Bore, Preparation and Spring Selection**NOTE!**

Some servo modifications involve blocking feed or exhaust passages in the case. These modifications must be removed. For proper operation of this servo, ensure that the exhaust passage and both oil feed passages are unrestricted.

- a. This servo kit is a drop-in item for mid 1968 or later models. Models previous to this will need to be bored out to 3.493" / 3.495" diameter with a surface finish of less than RA16.
- b. When choosing a return spring, the size of the servo along with the return spring affect not only the 1-2 shift, but also the 2-3 shift. To assist in tuning the 2-3 shift, this kit includes two different springs:
 - The spring with smaller diameter wire ensures more apply force in 2nd but will have a slower servo release on the 2-3 shift.
 - The spring with the larger diameter wire will have slightly less apply force in 2nd, but will have a faster servo release on the 2-3 shift.

General Guidelines For Which Return Spring To Use:

With the various possible combinations of servo apply levers and valve body calibrations, it's not possible to predict which spring would work best in your application. For maximum servo apply, start with the lightest spring. If the 2-3 shift has excessive overlap, switch to the return spring with larger diameter. If using the return spring with larger wire diameter and the 2-3 shift has a flare, then switch to the spring with smaller diameter wire.

Assembly & Installation

- a. Generously apply Transgel™ to the servo bore in the case.
Note! The Teflon® seal ring is for the servo lever end of the servo pin!
- b. Insert the servo assembly into the case. Insert bolts and tighten.
- c. Adjust band according to manufacturer specifications.