



**Part # 700219/ 750213**  
**GM 700 R-4 & 4L60-E**  
**Billet 4th Gear Powr-Servo**  
**Installation Instructions**

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The JET 4th Gear Powr-Servo can be installed with the transmission still in the vehicle provided that there is enough clearance to remove the servo assembly from the passenger side of the transmission. You may have to remove the aluminum heat shield from the transmission to gain access the servo assembly. Do not attempt to install this product without using transmission assembly lube to install the seals on the servo!

1. The servo is secured in the bore by a snap ring. Use a flat blade screwdriver to remove the snap ring from the servo bore.
2. Use pliers to work the servo cover outward until the rubber o-ring is visible. Use a scribe or small screwdriver to pull the o-ring out of the bore far enough that it can be cut and removed. After removing the o-ring, remove the servo cover from the bore.
3. Remove the first piston (4th gear apply) from the bore and set aside.
4. The servo assembly can now be removed by using a screwdriver to gently pry it from the bore. Use the edge of the bore for leverage-see photo.
5. **If you are installing this servo in addition to the JET Billet Powr-Servo omit this step!** Remove the e-clip shown in the photo with a small screwdriver. Remove the washer and small spring and replace the spring with the blue spring in the kit. Then reinstall the stock washer and e-clip. Make sure the e-clip seats firmly in the slot on the pin.
6. Make sure the o-ring and Teflon seal are well lubricated with transmission assembly lube and seated properly in their grooves, then carefully install the servo assembly back into the transmission bore. Make sure the Teflon seal remains seated as it installs in the bore.
7. Install the black lip seal in kit in the groove on the new 4th gear piston. The part of the seal that sticks out of the groove needs to face the side of the piston with the snout on it.
8. Apply assembly lube to the lip seal and install the piston into the new cover with the snout facing down. Use a screwdriver to slip the seal into the cover as shown in photo.
9. Install the blue o ring in the groove on the servo cover using assembly lube. Carefully push the servo cover back into the bore and secure the assembly with the stock snap ring.
10. Check the transmission fluid level before test driving vehicle.

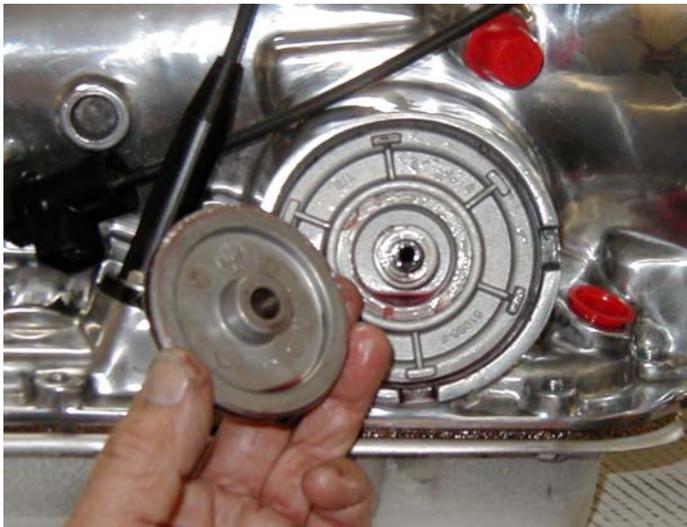
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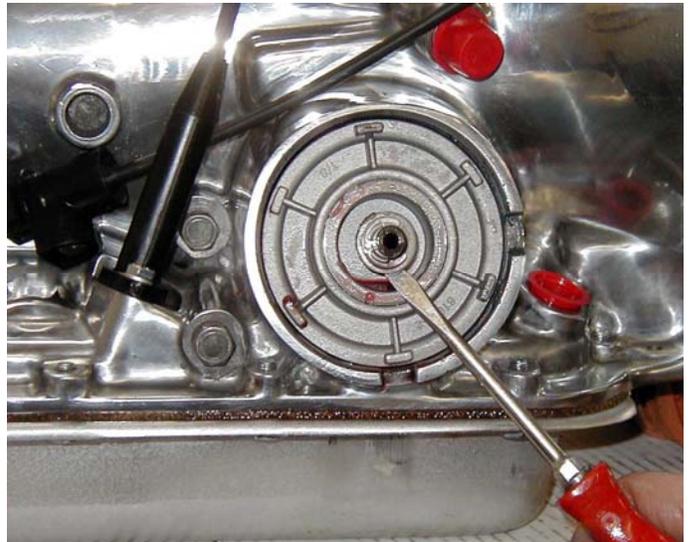
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