

## Oversized Accumulator Control Valve Kit



Part No.

**34994-22K**

- Valve
- Spring
- End Plug

## Tool Kit



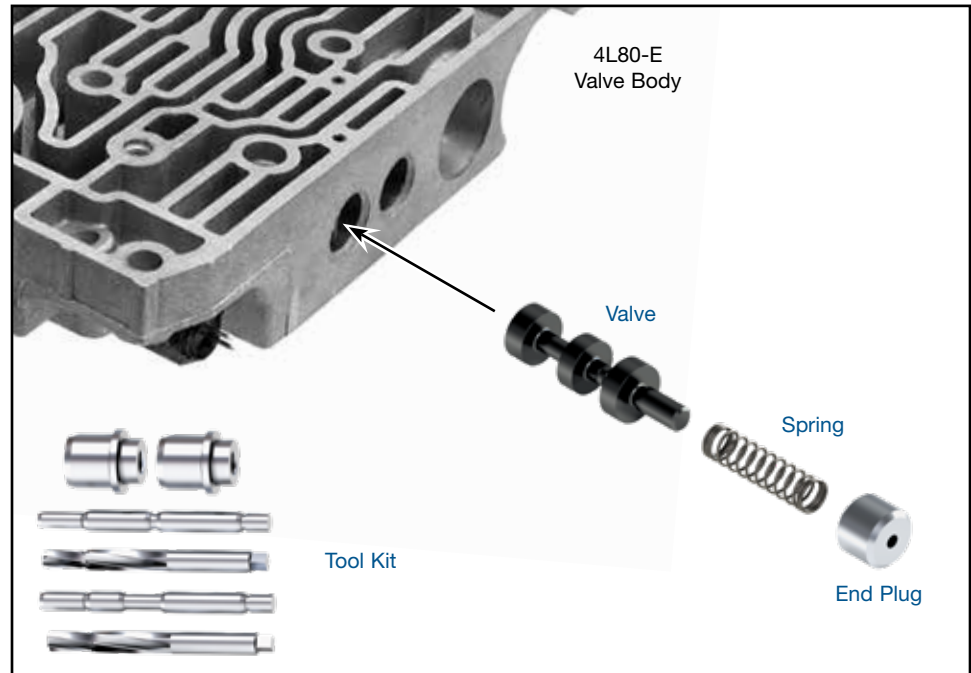
Part No.

**F-34994-TL22**

- Reamers (2)
- Reamer Jigs (2)
- Guide Pins (2)

**NOTE:** Sonnax “F-Tool” kits designed to service a specific bore require the VB-FIX, a self-aligning valve body reaming fixture. More information and instructions can be found online at [www.sonnax.com](http://www.sonnax.com).

## GM 4L80-E, 4L85-E



### 1. Disassembly

- Remove OE retaining pin and set aside for reuse.
- Remove OE end plug, spring and valve from valve body and discard.

### 2. Bore Reaming

Ream accumulator control bore (for reaming instructions/reamer care, please visit [www.sonnax.com](http://www.sonnax.com)). Sonnax reaming tool kit **F-34994-TL22** and **VB-FIX** are required for this operation.

- Use reamer jig **F-34994-RJ22** and align appropriate guide pin for the valve body model year. For '91-'96, use guide pin **F-34994-GP22**. For '97-later, use guide pin **F-34994-GP23**.



**CAUTION:** Do not loosen valve body clamp or VB-FIX wing nuts until both reaming steps below have been completed.

- ALL model years require a two-step reaming process using both the reamers and reamer jigs in the order shown below:
  - Use reamer jig **F-34994-RJ22** and ream with reamer **F-34994-RM22**.
  - Switch to reamer jig **F-34994-RJ23** and ream with reamer **F-34994-RM23**.
- Ensure both reaming steps have been completed before installation.

### 3. Installation & Assembly

- Be certain all debris has been removed from the valve bore and valve body.
- Install Sonnax valve, spring and end plug.
- Reinstall OE retaining pin.

### 4. Final Testing

Vacuum testing at the port(s) indicated holds the recommended minimum 14 and 18 in-Hg.

