

## 3-4, 4-5 & Safety Mode Valve Kit



Part No.

**55211-14K**

- Shift Valve
- Control Valve
- Spring

**NOTE:** This kit can be used in any of three locations. If using in the safety mode valve location, the control (small) valve is not used.

## Tool Kit



Part No.

**F-55211-TL14**

- Reamer
- Reamer Jig
- Guide Pin

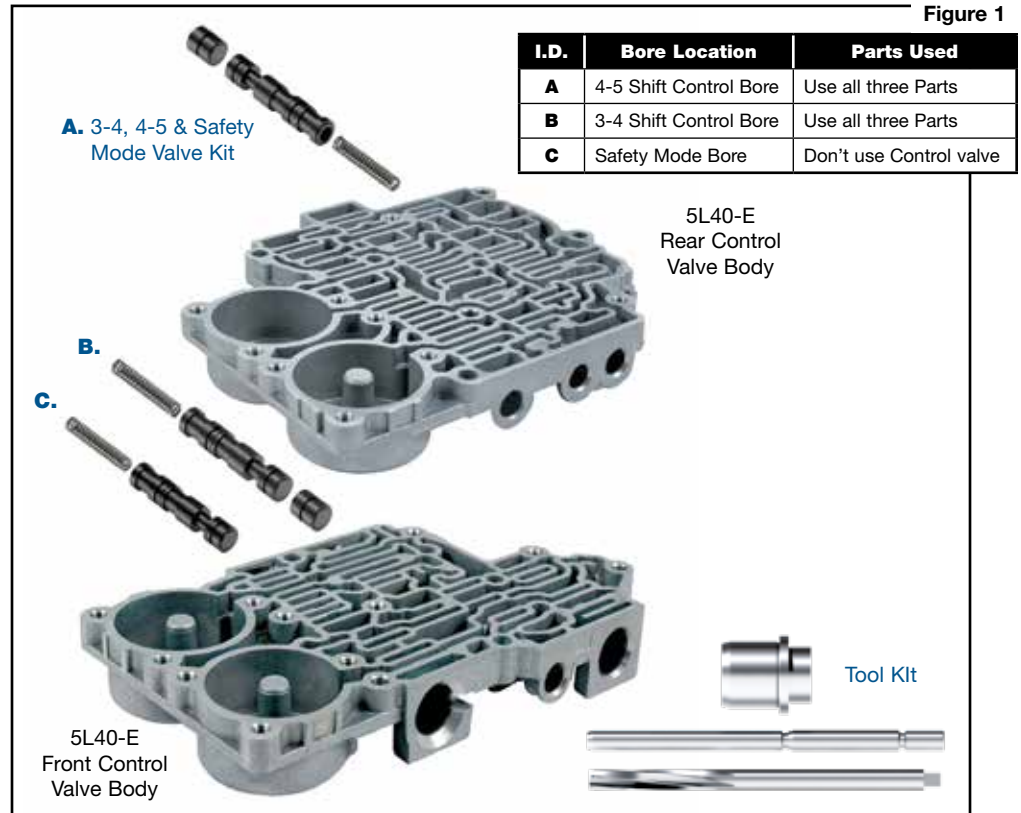
**NOTE:** Sonnax "F-Tool" kits designed to service a specific bore require the VB-FIX, a self-aligning valve body reaming fixture. More information and instructions can be found online at [www.sonnax.com](http://www.sonnax.com).



**WARNING:** Required tool kit F-55211-TL14 is no longer in production. Check with your distributor for availability.

## GM 5L40-E, 5L50-E

Figure 1



### 1. Disassembly

Remove OE components from bore and discard all except the retainer.

### 2. Bore Reaming

Ream shift control and/or safety control bores (for reaming instructions/reamer care, please visit [www.sonnax.com](http://www.sonnax.com)). Sonnax reaming tool kit F-55211-TL14 and VB-FIX are required for this operation.

### 3. Installation & Assembly

- Be certain all debris has been removed from the valve bore and valve body.
- Install Sonnax components as oriented above, this will vary depending on which bore location you are replacing (Figure 1).

**NOTE:** The control (small) valve is not used in the safety mode valve location.

### 4. Final Testing

Vacuum testing at the port(s) indicated holds the recommended minimum 18" in-Hg (Figure 2).

