

Oversized Modulator Valve Kit

Part No.
56833-01K



- Valve
- Adjustment Screw

Tool Kit

Part No.
56833-TL



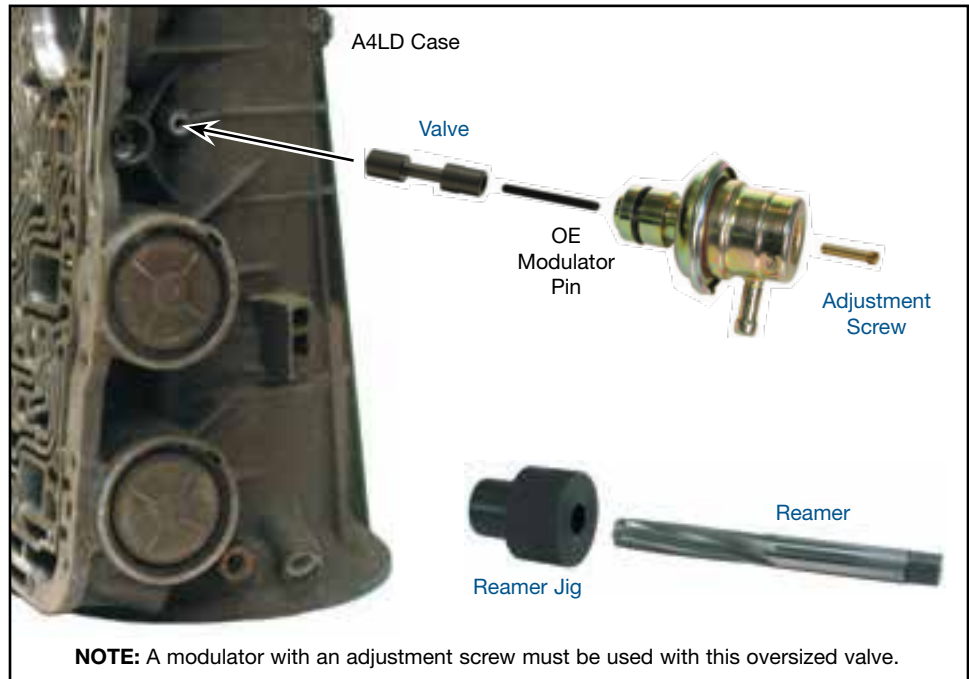
- Reamer
- Reamer Jig

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.

WARNING: Required tool kit 56833-TL is no longer in production. Check with your distributor for availability.



Ford A4LD, C3

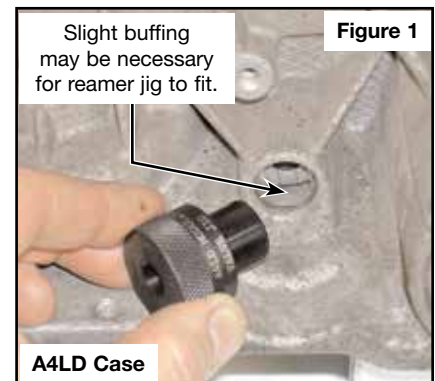


1. Disassembly

- Remove modulator and valve.
- Clean bore thoroughly.

2. Bore Reaming

- Clamp and position the case so it is secure and there is access to the modulator bore.
- Insert the reamer jig into bore (**Figure 1**). Due to some casting inconsistencies, some slight buffing or honing of the case bore may be necessary. Remove just enough material to fit the reamer jig.
- Ream modulator bore (for reaming instructions/reamer care, please visit www.sonnax.com). Sonnax reaming tool kit **56833-TL** are required for this operation.
- Fill bore and soak the reamer flutes with cutting fluid (kerosene, Tap Magic®, etc.).
- Insert reamer through the reamer jig and into the bore, just until the reamer guide nub contacts the bore to be cut (**Figure 2 & 3**). Using a speed handle, rotate the reamer clockwise at 1-2 revolutions per second. Continue reaming until the reamer bottoms in the bore. Spin the reamer 5-10 more times.



2. Bore Reaming (continued)

- f. Blow chips free with low air pressure BEFORE removing reamer. Rotate the reamer clockwise while removing it from the bore.
- g. Thoroughly clean bore.
- h. Lubricate the bore and Sonnax valve with ATF prior to installation. If snug, repeat the reaming process with an air drill at 500 rpm.

3. Installation & Assembly

- a. Be certain all debris has been removed from the valve bore.
- b. Prior to replacing or reinstalling the modulator, the pre-existing adjustment screw height must be measured. Reference distance "A" (Figure 4).
- c. Once the height has been noted, the adjustment screw in the modulator should be removed. Measure the length of the original adjustment screw, then add .109" to the measurement, and record this reading.
- d. The Sonnax pin needs to be shortened to the length calculated and recorded above. The intent is to have the Sonnax adjusting screw .109" longer than the original.
- e. Install the longer Sonnax adjusting screw such that the measured height "A" is re-established (Figure 5).
- f. Install the modulator and pin in accordance with manufacturer's specifications.

4. Final Testing

Vacuum testing at the port(s) indicated holds the recommended minimum 18 in-Hg (Figure 6).

