

Oversized PCA/PCB Modulator Valve Kit

Part No.
56947J-49K



- Valve
- Plug
- Spring

Tool Kit

Part No.
F-56947J-TL49



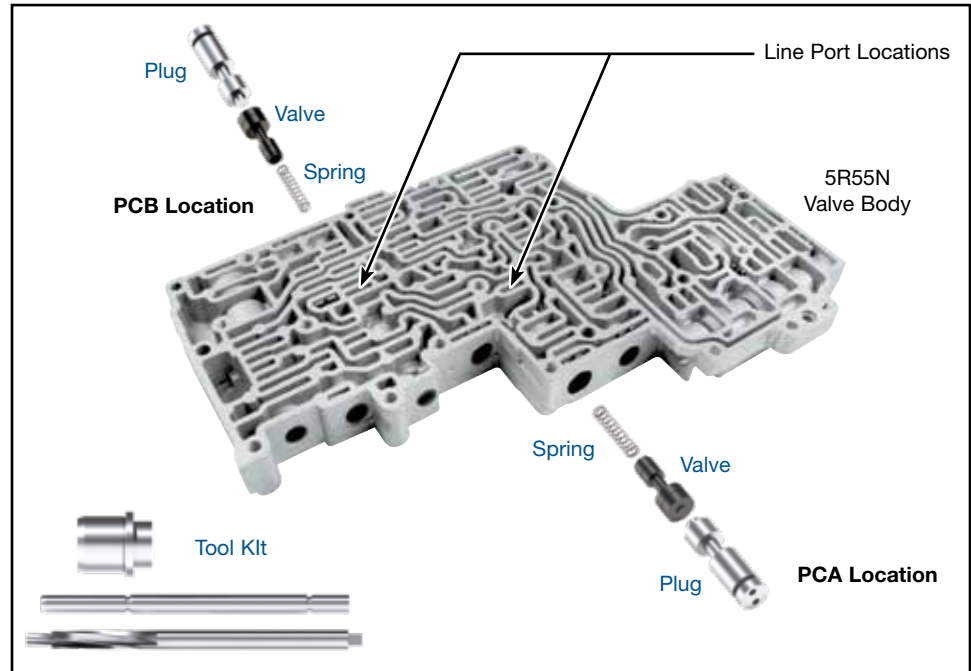
- Reamer
- Reamer Jig
- Guide Pin
- Dremel® Bit

Not Shown

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 **F-56947J-TL49** is no longer in production. Check with your distributor for availability.

Ford 5R55N

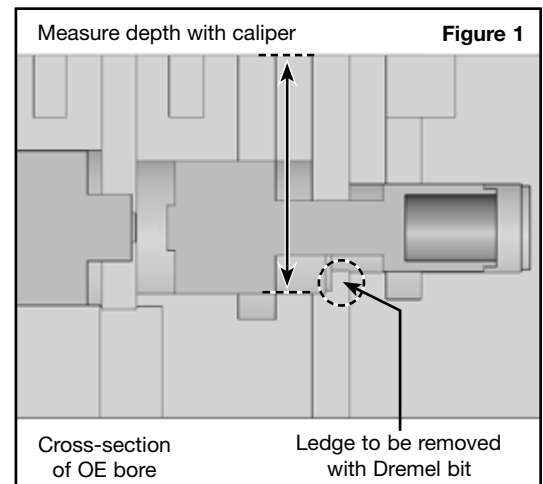


1. Disassembly

- Remove and discard OE valve and spring.
- If OE plug measures .472" dia. or is the same size as the large spool on the OE valve, discard the OE plug. The Sonnax replacement plug will be used instead.
 - If the OE plug measures .551" dia., keep the OE plug for reuse.
- Prior to reaming, a casting ledge must be removed from the line port. This ledge is non-critical, but removal is mandatory to allow the reamer to travel fully (**Figure 1**).

2. Dremel Ledge Removal

- With a caliper, measure the depth of the bore from the flat surface (**Figure 1**).
- Use this measurement to set the Dremel® bit cutting depth from the collet (**Figure 3**).
- Remove the ledge indicated (**Figures 1 & 2**), taking care not to cut through the valve body wall.
- To ensure ledge has been successfully removed, clean the valve body and invert the OE valve into the bore as shown (**Figure 4**).



3. Bore Preparation

- Clean the bore thoroughly in a solvent tank.
- Generously lubricate the bore and reamer with cutting fluid (i.e. Mobilmet S-122, Lubegard® Bio-Tap, Tap Mag-ic™, etc.). For best results, provide a continuous flow of water-soluble cutting fluid (i.e. Mobilmet S-122) during the reaming process.
- The reamers should be turned using a low RPM, high-torque air drill regulated to a maximum of 200 RPM.
- Examine the bore after cleaning for surface finish, debris and burrs. Flashing and burrs on the exit side of land and in bores must be carefully removed. A small piece of Scotch-Brite™ material attached to a wire and powered with a drill motor is ideal for the task. Scotch-Brite™ is a very abrasive material and all residual debris must be cleaned to ensure particles do not migrate or remain imbedded into the surface. Post cleaning involves several progressive steps with solvent on a lint-free rag.

4. Bore Reaming

Ream PCA and/or PCB modulator valve bore(s) (for reaming instructions/reamer care, please visit www.sonnax.com). Sonnax reaming tool kit F-56947J-TL49 and VB-FIX are required for this operation.

5. Installation & Assembly

- Be certain all debris has been removed from the valve bore and valve body.
- Place Sonnax spring into Sonnax valve's spring pocket and insert into bore spring end first.
- Install Sonnax plug and secure with OE retainer.

6. Final Testing

Vacuum testing at the port(s) indicated holds the recommended minimum 18 in-Hg (Figure 5).

