

## Forward Engagement Valve Kit

Part No.  
**56947J-56K**

- Valve
- Spring
- End Plug



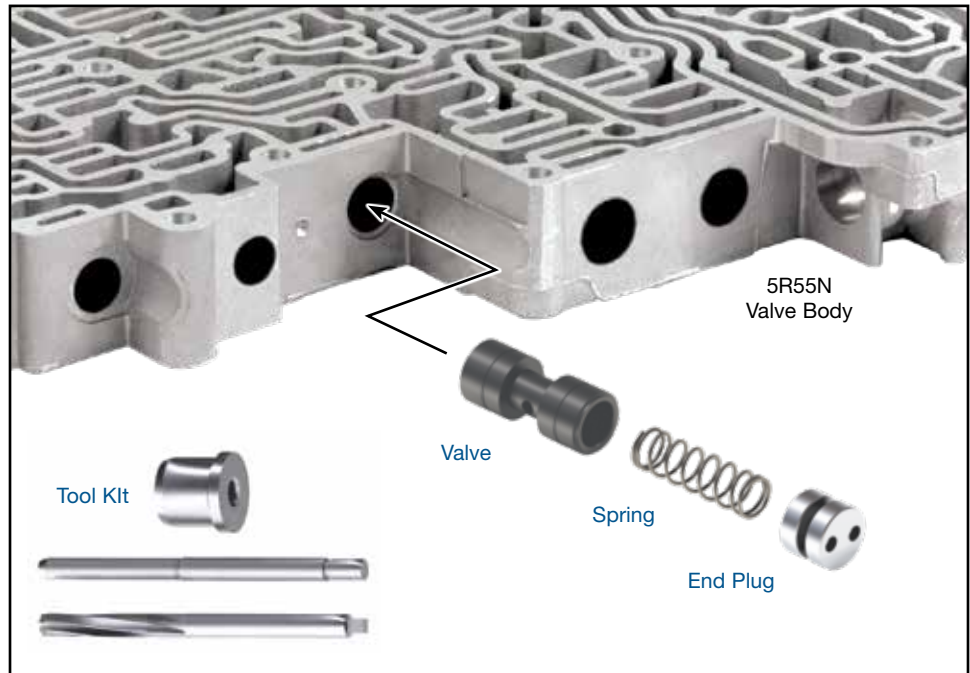
## Tool Kit

Part No.  
**F-27741-TL13**

- 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).



## Ford 5R55N

### 1. Disassembly

- Remove and discard OE plug, valve and spring.
- Keep OE retainer for reuse.

### 2. Bore Reaming

Ream forward engagement bore (for reaming instructions/reamer care, please visit [www.sonnax.com](http://www.sonnax.com)). Sonnax reaming tool kit F-27741-TL13 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.
- Place Sonnax spring into Sonnax valve spring pocket and insert into bore with the spring facing out.
- Install Sonnax end plug.
- Secure with OE retainer.

### 4. Final Testing

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

