

Oversized Reverse Engagement Valve Kit



Part No.
56947J-59K

- Valve
- End Plugs (2)

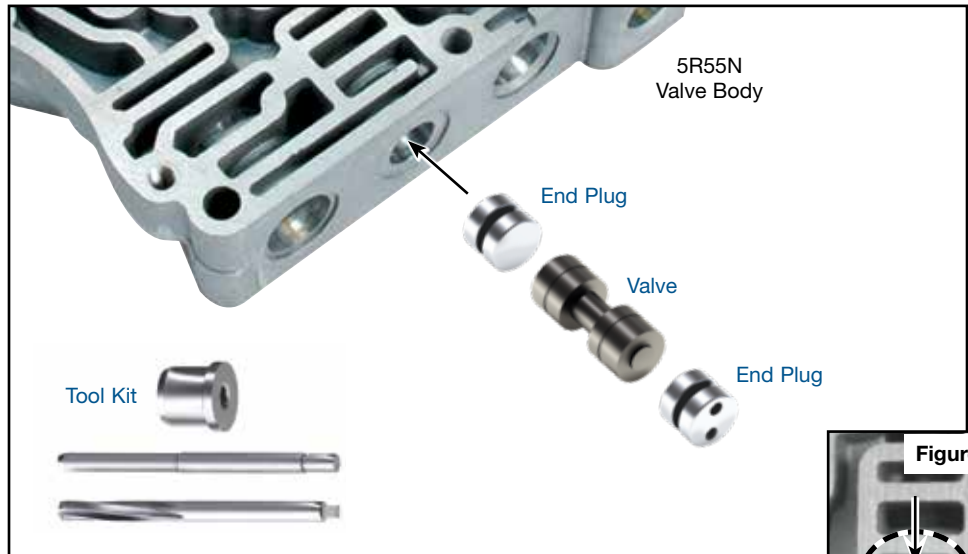
Tool Kit



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.



1. Disassembly

- Remove and discard two OE end plugs, reverse engagement valve and spring.
- Keep OE retainers, direct/reverse control valve and spring and reverse engagement valve spring for reuse.

2. Bore Reaming

Ream reverse engagement bore (for reaming instructions/reamer care, please visit www.sonnax.com). Sonnax reaming tool kit F-27741-TL13 and VB-FIX are required for this operation.



NOTE: Ream reverse engagement valve bore until tip of reamer disappears under the casting bore (Figure 1).

3. Installation & Assembly

- Be certain all debris has been removed from the valve bore and valve body.
- Return OE direct/reverse control valve and spring to inner bore.
- Install one of the Sonnax end plugs into bore (with two recessed bores facing inboard). Secure with OE L-shaped retaining pin.
- Install Sonnax valve and OE spring into bore, retain with Sonnax end plug (with the two recessed bores facing outward) and OE clip.

4. Final Testing

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

