

## Accumulator Valve Kit



**Part No.**  
**63940-02K**

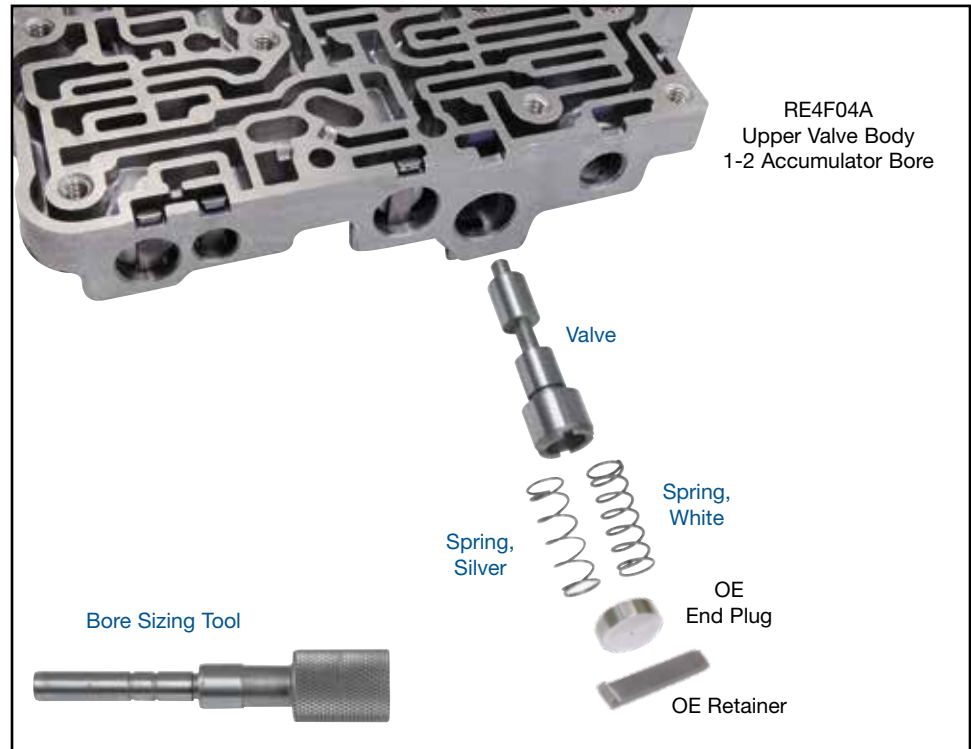
- Valve
- Springs (2) Selective
- O-Ringed End Plug

**NOTE:** Maxima '99-earlier, all other '01-earlier.

## Bore Sizing Tool

**Part No.**  
**63940-BST**

## Ford 4F20E; Jatco/Nissan RE4F04A



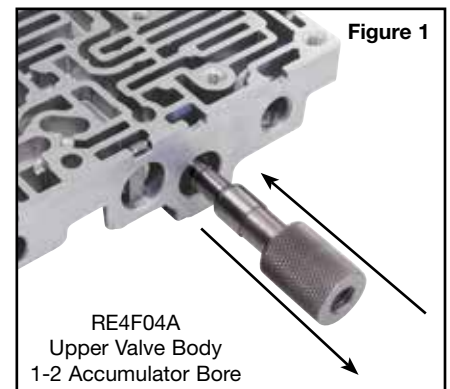
### Upper Valve Body: 1-2 Accumulator Bore

#### 1. Disassembly

- Remove all components from the valve bore and 1-2 accumulator lineup on the opposite side of the valve body.
- Discard OE 1-2 accumulator valve and spring.

#### 2. Bore Preparation

- Be certain all debris has been removed from the valve bore and valve body.
- Insert the stepped end of the bore sizing tool **63940-BST** into the bore (**Figure 1**). It is designed to have an interference fit with the bore. A 3/8-16 UNC internal thread is provided at the knurled end of the tool to adapt to a puller or slide hammer for ease of use.
- Stroke the bore sizing tool within the bore to mimic valve oscillation.
- Remove the bore sizing tool and install the oversized 1-2 accumulator valve.
- If the valve does not move freely, reinstall the bore sizing tool and tap the sizing tool up and down using a hammer and screwdriver through the ports and into the tool slots. This will smooth out any ridges in the bore. Repeat this process until the valve strokes freely.



### Upper Valve Body: 1-2 Accumulator Bore (continued)

#### 3. Installation & Assembly

- Install Sonnax 1-2 accumulator valve with small end inboard.
- Select the desired Sonnax selective spring (**Figure 2**).
- Reinstall OE end plug and retainer.
- Reinstall OE 1-2 accumulator washer, spring, piston and retainer in the opposite side of the valve body.

Selective Spring		Figure 2
Spring Color	Wire Diameter	Desired Results
Silver/Plain	.022"	Slightly increased pressure
White	.026"	Noticeably increased pressure for firmer shifts

### Lower Valve Body: Accumulator Control Bore

#### 1. Disassembly

- Remove all components from the bore.
- Discard OE spring.

#### 2. Installation & Assembly

- Reinstall OE valve without a spring.
- Install Sonnax O-ring into shallow groove of Sonnax end plug. Lubricate with Sonnax Slippery Stick **O-LUBE** and roll on bench to size O-ring into the groove.
- Carefully insert Sonnax O-ringed end plug into the bore until it contacts the valve.
- Reinstall OE end plug and retainer.

