

TCC Regulator Valve Kit



Part No.

72854-03K

- Sleeve
- Valve
- Spring 1.000", Plain
- Spring 1.670", Plain
- Spring 1.875", White
- Washer
- End Plug
- O-Ring

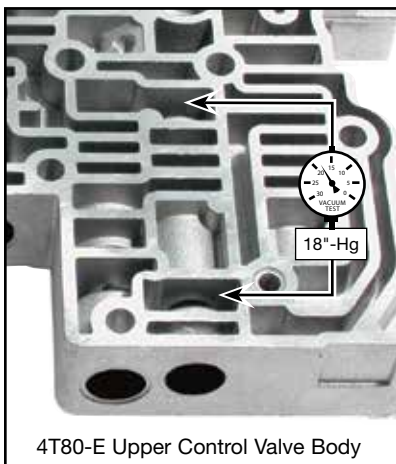
Tool Kit

Part No.

72854-TL2

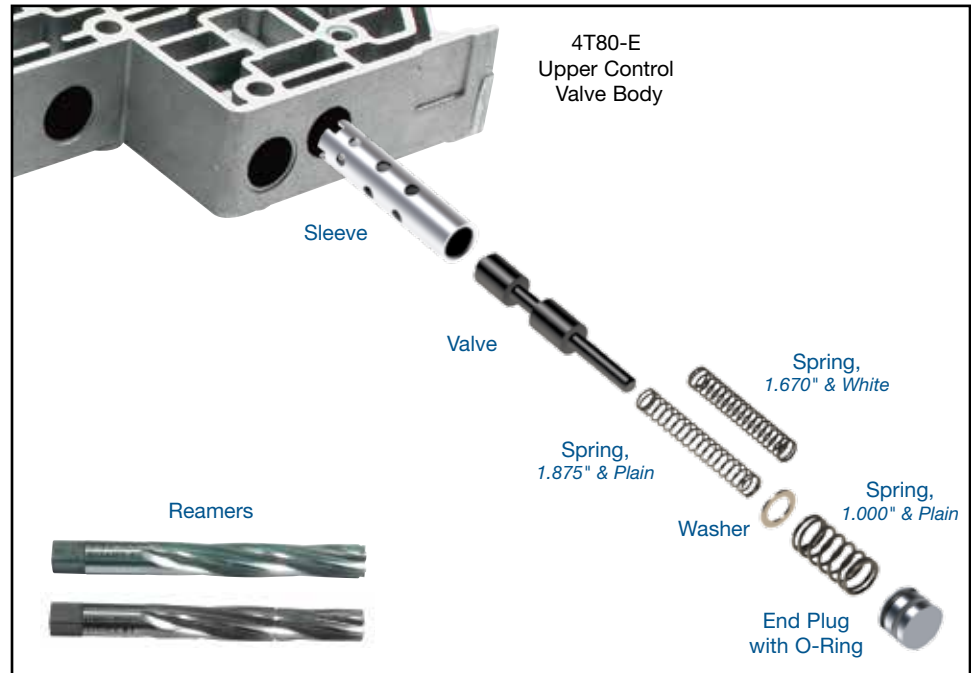
- Reamers (2)

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.



4T80-E Upper Control Valve Body

GM 4T80-E



1. Disassembly

- a. Remove all OE components from the bore.
- b. Save OE retainer for reuse and discard all other components.

2. Bore Reaming

Ream TCC regulator bore (for reaming instructions/reamer care, please visit www.sonnax.com). Sonnax reaming tool kit **72854-TL2** is required for this operation.

- a. Securely clamp the valve body horizontally to the bench, making sure not to clamp directly over the bore to be reamed.
- b. Soak the bore and reamer with cutting fluid.
- c. Place self-piloting Reamer #1 into the bore and ease forward until the cutting tip contacts the first bore to be reamed.
- d. Turn the reamer in a smooth and continuous clockwise motion, at 60-200 RPM. Continue reaming until the reamer bottoms in the bore.
- e. Using low air pressure, blow the chips free prior to removing the reamer.
- f. To remove the reamer, turn clockwise while slowly pulling outward on the reamer.
- g. Remove any remaining debris from the bore with air pressure and clean in a solvent tank.
- h. Repeat steps (b) through (g) using self-piloting Reamer #2.

3. Installation & Assembly

- a. Be certain all debris has been removed from the valve bore and valve body.
- b. Push Sonnax sleeve into the bore, notched end first, until it bottoms in the bore.
- c. Push Sonnax valve into the installed sleeve, stem end facing out.

3. Installation & Assembly (continued)

d. Choose one of two Sonnax selective springs based on following application needs:

OE TCC Apply, 25 psi Cracking	Firm TCC Apply, 18 psi Cracking & Less Slipping
Use 1.875" Plain Spring	Use 1.670" White Spring

e. Install Sonnax washer so it sits flush with the outer face of the installed Sonnax sleeve.

f. Install Sonnax 1.000" plain spring into the bore, over the valve stem and inner spring, flush with the washer.

g. Lubricate Sonnax O-ring with Sonnax Slippery Stick **O-Lube** and install into the small groove on the end plug. Gently push the O-ringed end plug into the bore, recessed pocket facing inward, until the OE retaining clip can be installed into the end play.

4. Final Testing

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