

## 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

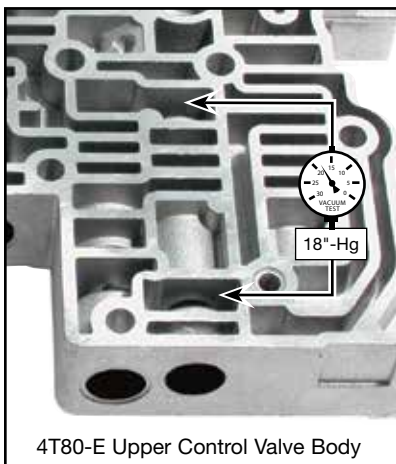
## Tool Kit

### Part No.

**72854-TL2**

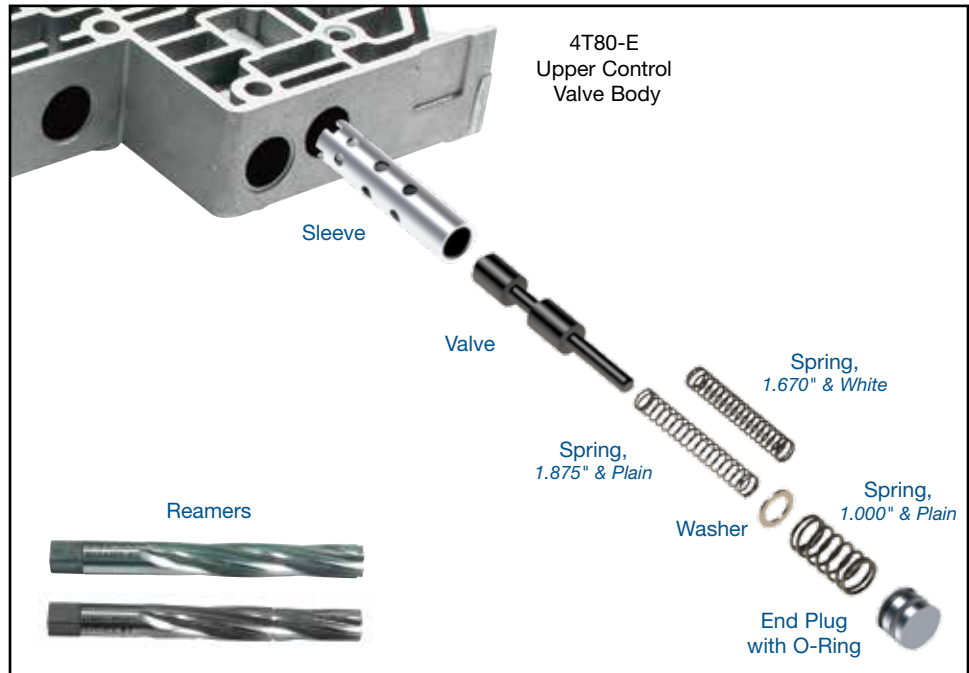
- Reamers (2)

**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](http://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](http://www.sonnax.com)). Sonnax reaming tool kit **72854-TL2** is required for this operation.

### 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.
- 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 plug.

### 4. Final Testing

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