

Oversized Torque Signal Valve



Part No.

84754-44

Tool Kit

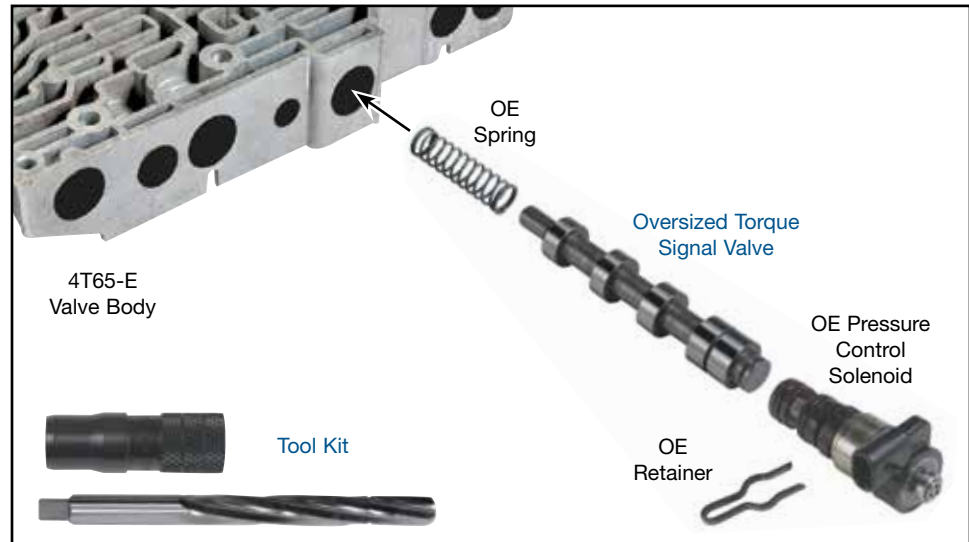
Part No.

84754-TL44

- Reamer
- Reamer Jig

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.

GM 4T65-E



NOTE: To eliminate codes 1811 and 741 and TCC-related issues, be sure to also inspect the actuator feed limit valve, boost valve assembly, TCC regulated apply valve and TCC apply valve. The PCM must be reset/relearned after any valve body repairs. Aftermarket scanner relearn procedure or battery disconnect for 12 hours may not restore drivability and line pressure control. Performing a dealer reflash or a web reflash is frequently the only method to properly restore control.

1. Disassembly

- Disassemble valve body and discard OE torque signal valve.
- Save OE spring for reuse.

2. Bore Reaming

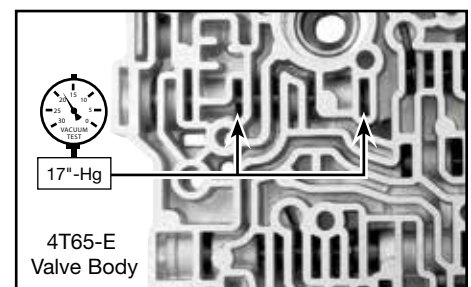
- Lubricate the reamer jig, valve body bore and reamer with cutting fluid.
- Insert the reamer jig in the solenoid bore. Begin the reaming process with the reamer.
- Using a speed handle, ream the bore clockwise at 1 to 1 ½ turns per second. This reaming operation should take approximately two minutes.
- Use low air pressure (35 psi, with the reamer remaining in the bore, blow chips out of the bore.
- While continuing to turn the reamer clockwise, remove it from the bore. Clean the remaining chips from the bore.

3. Installation & Assembly

- Ensure all debris has been removed from the valve bore and valve body.
- Reinstall OE spring into the bore.
- Install Sonnax valve into the bore.
- Reinstall OE solenoid and retaining clip.



NOTE: When repairing a '03-later valve body, the Sonnax oversized valve may be slightly longer than the OE valve it's replacing. Despite this difference, the Sonnax oversized valve will perform identically to the OE version.



4. Final Testing

Vacuum testing at the port(s) indicated holds the recommended minimum 17 in.-Hg.