

## Oversized Solenoid Switch Valve Plug Kit



Part No.

**92835-22K**

- Inner Plug
- Outer Plug
- End Plug
- O-Ring

Patent No. 7,001,300

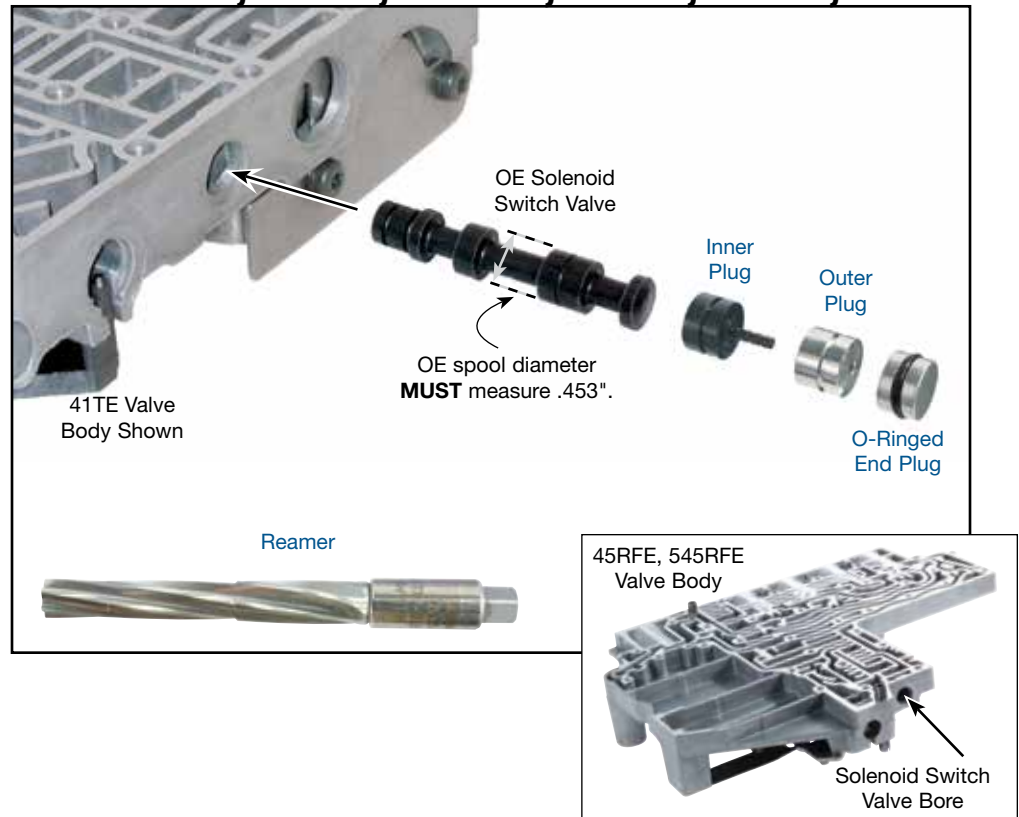
**NOTE:** Fits bores containing OE switch valve with .453" dia. large spool only (see main illustration).

## Reamer

Part No.

**92835-RM22**

## Chrysler 40TE, 40TES, 41AE, 41TE, 41TES, 42LE, 42RLE, 45RFE, 545RFE, 65RFE, 66RFE, 68RFE



**NOTE:** Large spool of OE switch valve must be .453" dia. (main photo). If spool measures .453", continue installation. If spool measures .420", **STOP!** This Sonnax kit cannot be used. Instead, install Sonnax oversized solenoid switch valve plug kit **92835-18K** after reaming bore with Sonnax tool **92835-RM** or **F-92835-TL18**.

### 1. Disassembly

- Remove OE retainer, end plug and switch valve plugs and set aside.
- Remove OE switch valve and measure large spool. If large spool is .453" dia., proceed to step "c". If spool measures .420", **STOP** and see note above.
- If OE switch valve spool measures .453" dia., discard OE end plug and switch valve plugs. Keep OE switch valve and retainer for reuse.

### 2. Reaming

Ream switch valve plug bore (for reaming instructions/reamer care, please visit [www.sonnax.com](http://www.sonnax.com)). Sonnax reamer **92835-RM22** is required for this operation.



**TECH TIP:** These valve bodies commonly warp and allow pressure to escape the switch valve circuit. Recommend flat-sanding the casting to ensure pressure is properly contained.

### 3. Installation & Assembly

- Thoroughly clean valve bore and body
- Reinstall OE solenoid switch valve.
- Install Sonnax switch valve plugs. Outer plug has a slight chamfered edge on one side; this side must face outboard (**Figure 1**).
- Install Sonnax O-ring onto Sonnax end plug and lubricate. Roll on clean bench to size O-ring into groove.
- Insert O-ringed end plug into bore, nub facing inboard towards switch valve plugs (**Figure 2**).
- Reinstall OE retainer.

### 4. Final Testing

Vacuum testing at the port(s) indicated holds the recommended minimum 16 in-Hg (**Figures 3 & 4**).

