

Oversized Bypass Clutch Control Valve Kit

Part No.

96206-05K

- Bypass Clutch Control Valve
- Plunger Valve
- Plunger Sleeve

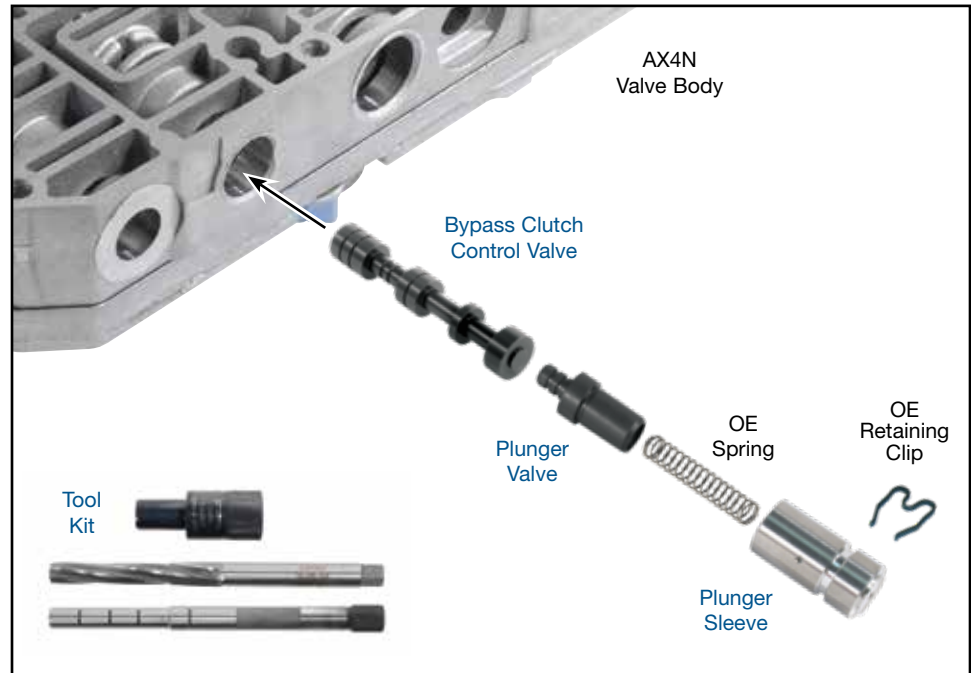
Tool Kit

Part No.

96206-TL

- Reamer
- Reamer Jig
- Bore Sizing Tool

Ford 4F50N, AX4N



1. Disassembly

- Remove OE retaining clip.
- Remove OE bypass clutch control valve and plunger valve, spring and sleeve from valve bore.
- Discard both valves and the sleeve, while saving spring and retaining clip for reuse.

2. Bore Reaming & Sizing

- Ream bypass clutch control bore (for reaming instructions/reamer care, please visit www.sonnax.com). Sonnax reaming tool kit **96206-TL** is required for this operation.
- After reaming the bore, use the bore sizing tool with a slide hammer to ensure proper valve fit and bore integrity.
- Lubricate the bore sizing tool with ATF and insert the reamer jig into the valve bore, then insert the sizing tool. Pushing carefully until it bottoms in the bore, then reciprocated in the bore, mimicking the stroking of the valve.
- With the tool bottomed in the bore, a screwdriver tip may be placed through a valve body port and into a tool groove, then tapped with a hammer.

3. Installation & Assembly

- Lubricate Sonnax bypass clutch control valve and insert into reamed bore, largest diameter spool outboard.
- Place OE compression spring into the pocket of Sonnax plunger valve.
- Insert the spring and valve assembly into Sonnax sleeve, spring end first.
- Install this assembly into the valve bore, with nubbed end of the valve inward.
- Press into the bore just far enough to insert OE retaining clip.