

Oversized Solenoid Switch Valve Plug Kit

Part No.

92835-18K



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

Patent No. 7,001,300

NOTE: Fits bores containing OE switch valve with .420" dia. large spool only (see main illustration).

Two reaming options available: Use either **F-92835-TL18** and **VB-FIX**, or **92835-RM**.

WARNING: Reamer **92835-RM** does NOT work on 62TE units. **F-92835-TL18** MUST be used.

Additionally, bore sizing tool **92835-BST2** can be used after reaming for improved bore sizing and superior surface finish.

Tool Kit

Part No.

F-92835-TL18

- Reamer • Reamer Jig • Guide Pin

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.



Reamer

Part No.

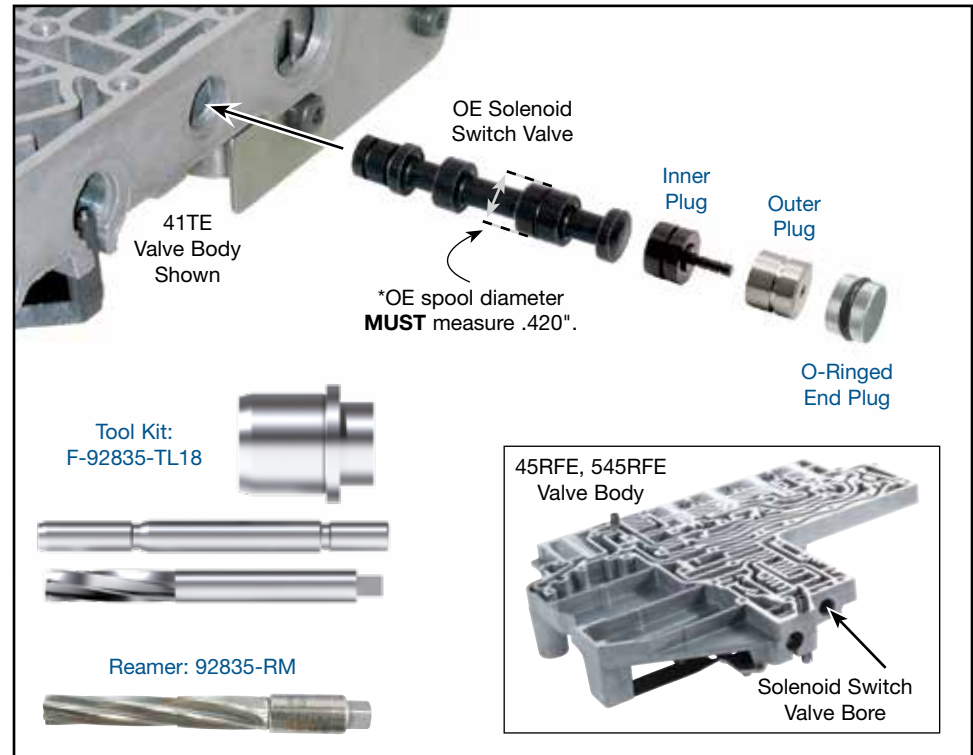
92835-RM

Bore Sizing Tool

Part No.

92835-BST2

Chrysler 41TE, 42LE, 42RLE, 45RFE, 545RFE, 62TE, 68RFE



NOTE: Large spool of OE switch valve must be .420" dia. (main photo). If spool measures .420", continue installation. If spool measures .453", **STOP!** This Sonnax kit cannot be used. Visit www.sonnax.com and select the unit you are trying to service for information on alternative Sonnax part numbers used in this bore.

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

2. Reaming

Ream switch valve plug bore (for reaming instructions/reamer care, please visit www.sonnax.com). Sonnax reaming tool kit **F-92835-TL18** and **VB-FIX** are required for this operation. Alternatively, Sonnax self-guided reamer **92835-RM** can be used to prepare the bore.

WARNING: When installing Sonnax oversized switch valve in conjunction with this kit, the bore for the switch valve plugs **MUST** be reamed prior to reaming switch valve portion of the bore. Failure to follow this reaming order will damage valve body irreparably! To avoid this extra reaming step, please visit Sonnax website to search for part number for a tool kit that reams both sections of bore concurrently.



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 outward (**Figure 1**).
- Verify Sonnax plugs move smoothly in bore. If plugs hang up or do not move properly, Sonnax bore sizing tool **92835-BST2** can be used to smooth and condition bore.
- Install Sonnax O-ring onto Sonnax end plug and lubricate. Roll on clean bench to size O-ring into groove.
- Insert Sonnax end plug into bore, nub facing inward (**Figure 2**).
- Reinstall OE retainer.

4. Final Testing

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

