

TC Limit Valve Kit

Part No.

44912-03K



- Valve
- Sleeve
- Spring
- Retainer Plate

NOTE: Kit also serves late model steel valve.



Late Model Steel Valve

Tool Kit

Part No.

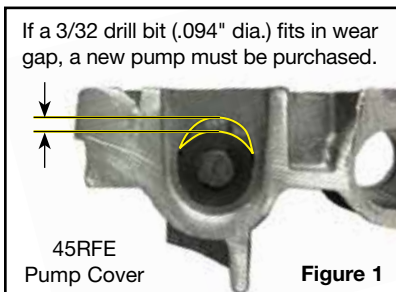
F-44912-TL



- Roughing Reamer
- Reamer Jig (2)
- Finishing Reamer
- 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.

WARNING! Extreme wear of the OE cast pump bore is possible and beyond the ability of reaming to fix. If wear gap exceeds .094" dia., pump replacement is required (Figure 1).

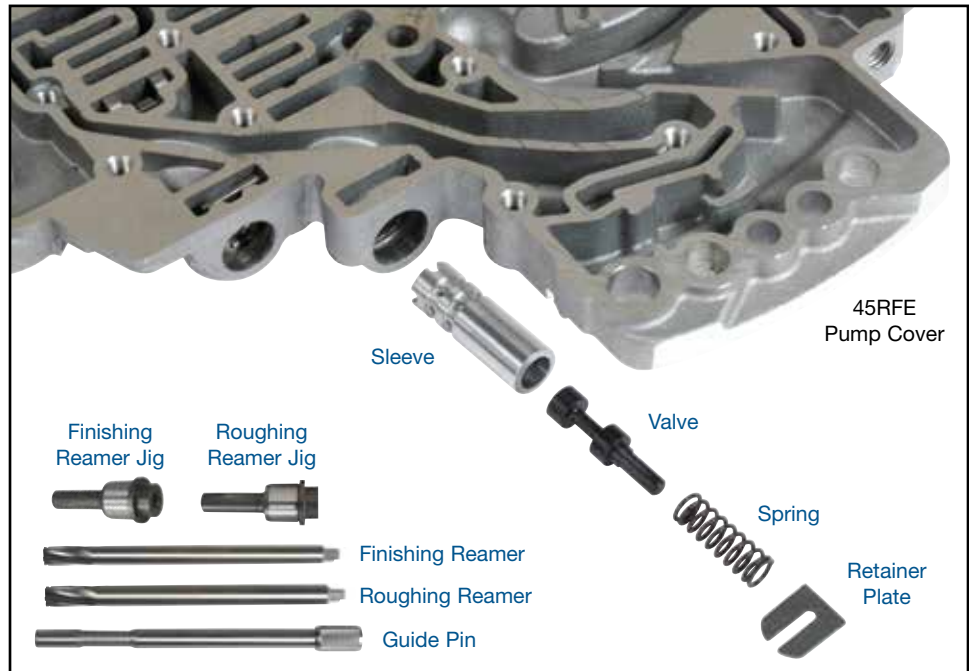


If a 3/32 drill bit (.094" dia.) fits in wear gap, a new pump must be purchased.

45RFE Pump Cover

Figure 1

Chrysler 45RFE, 545RFE, 65RFE, 66RFE, 68RFE



1. Disassembly

Remove and discard OE retainer, spring and valve.

2. Bore Preparation

Ream TC limit valve bore (for reaming instructions/reamer care, please visit www.sonnax.com). Sonnax reaming tool kit **F-44912-TL** and **VB-FIX** are required for this operation.

- From tool kit **F-44912-TL**, first select jig **F-44912-RJ**, and align with guide pin **F-44912-GP** per **VB-FIX** instructions.
- Remove pin and ream with roughing reamer **F-44912-RM**. Do not remove pump cover from the **VB-FIX**.
- Use low pressure air to remove all debris from the reamed bore. Repeat reaming process with jig **F-44912-RJ2** and reamer **F-44912-RM2**.

3. Installation & Assembly

- Ensure all debris has been removed from bore and pump body.
- Insert Sonnax sleeve, slotted end first. Ensure sleeve seats at bottom of bore.
- Check retaining plate fitment and modify if necessary:
 - With some castings the sleeve may interfere with Sonnax retainer plate. In these cases, trim the non-slotted end of the sleeve just enough to clear the plate.
 - Ensure the retainer plate sits below flush of the machined flat surface of pump body. Run straight edge over the area to see if it catches on retainer plate. If necessary, grind a few thousandths of an inch off retainer so it sits just below flush.

3. Installation & Assembly (continued)

- d. Insert Sonnax valve and spring into installed sleeve.
- e. Compress spring, secure assembly with Sonnax retainer plate.

4. Final Testing

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

