

Ford C6

Oversized Modulator Valve Kit



Part No.

36833-01K

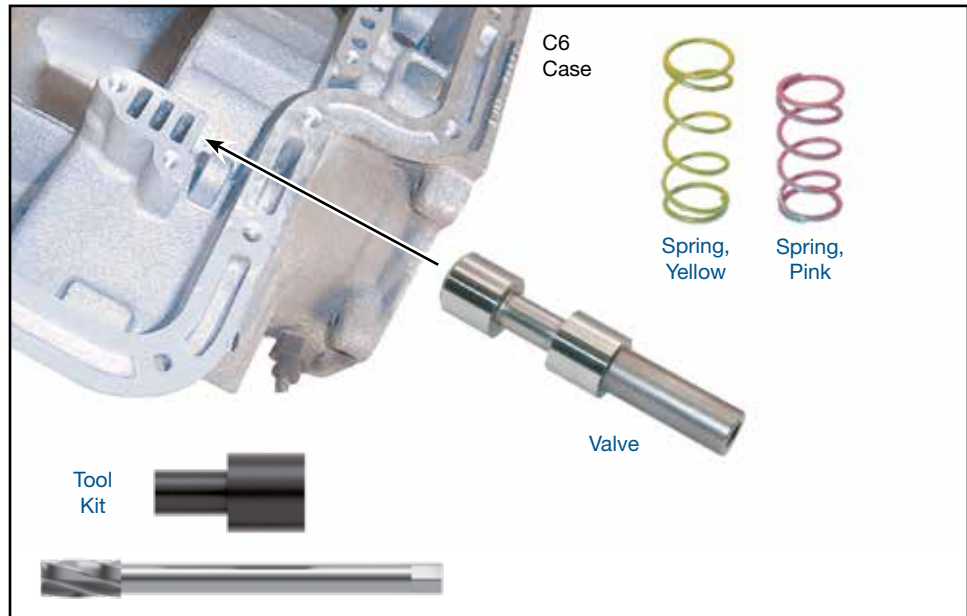
- Valve
- Spring, Yellow Standard Gas
- Spring, Pink Gas/Diesel Conversion

Tool Kit

Part No.

36833-TL

- Reamer
- Reamer Jig



1. Disassembly

- Remove modulator and set aside for reuse.
- Remove modulator valve train from case bore. Save OE retainer for reuse.
- Discard OE valve and spring.

2. Bore Preparation & Reaming

- Clean bore thoroughly with solvent.
- Insert reamer into jig.
- Saturate bore and reamer with cutting fluid (i.e. Mobilmet S-122, Lubegard® Bio-Tap, Tap Magic™, etc.). For best results, provide a continuous flow of water-soluble cutting fluid during the reaming process.
- Gently insert reamer/jig assembly into bore until cutting tip contacts first land to be reamed.
- Use a loose-fitting reamer socket and a wobble adapter to ream the bore. The reamer can be turned by using a speed handle or with a low-RPM, high-torque drill regulated to a maximum of 200 RPM. The reaming actions must be clockwise in smooth and continuous motion at 60-200 RPM. Continue reaming until reamer stop is reached.

CAUTIONS & SUGGESTIONS

- Turning the reamer backward will dull it prematurely.
- Pushing on the reamer will result in poor surface finish and inadequate and sporadic material removal.
- Never use a crescent wrench, ratchet or pliers to turn the reamer.
- A dull reamer will cut a smaller hole. Reamers can be sharpened, but should only be done by a professional tool sharpener. Actual life of a Sonnax reamer before resharpening or replacing averages 50-70 bores.

3. Finish & Clean-up

- a. Using low air pressure, blow the chips free before removing the reamer.
- b. To remove the reamer, turn clockwise while slowly pulling outward.
- c. Examine bore after cleaning for surface finish, debris and burrs. Flashing and burrs on the exit side of land and in bores must be carefully removed. A small piece of Scotch-Brite® material attached to a wire and powered with a drill motor is ideal for the task. However, Scotch-Brite is a very abrasive material and all residual Scotch-Brite debris must be removed afterward to ensure particles do not migrate or remain embedded in the surface. Cleaning this material out should involve several progressive steps using solvent on a lint free rag.
- d. Clean reamer after each use and store in protective tube.

4. Installation & Assembly

- a. Install appropriate Sonnax spring (see chart), followed by Sonnax valve. Ensure spring fits into spring pocket of valve.
- b. Reinstall OE retainer.
- c. Reinstall modulator.

APPLICATION	SONNAX SPRING
Standard Gas	Yellow Spring
Diesel	Pink Spring
Gas Governor or Valve Body in Diesel Application	Pink Spring

5. Final Testing

Vacuum testing at the port indicated holds the recommended minimum 18 in-Hg.

