

### Instructions

# Ford 6R140

# Oversized TCC Apply Regulator & Boost Valve Kit

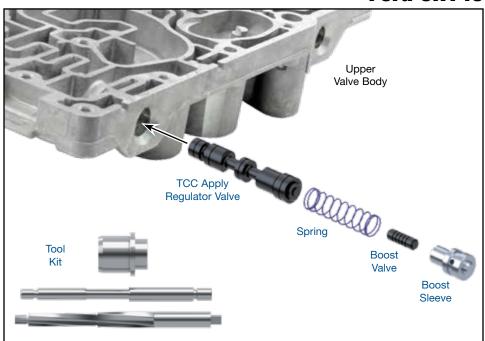


- TCC Apply Regulator Valve
- Spring
- Boost Valve
- Boost Sleeve



- 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.



#### 1. Disassembly

- a. Remove OE retaining clip, set aside for reuse.
- b. Remove and discard OE boost valve and sleeve, spring and TCC apply regulator valve.

#### 2. Bore Reaming

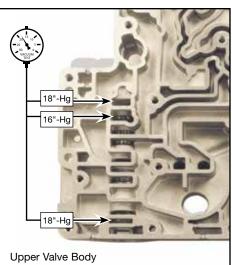
Ream TCC apply regulator bore (for reaming instructions/reamer care, please visit www.sonnax.com). Sonnax reaming tool kit **F-126740-TL15** and **VB-FIX** are required for this operation.

#### **3. Installation & Assembly**

- a. Ensure all debris has been removed from valve bore and body.
- b. Install Sonnax TCC apply regulator valve, followed by Sonnax spring.
- c. Install Sonnax boost assembly, ensuring the undercut is seated inside spring.
- d. Reinstall OE retaining clip.

#### 4. Final Testing

Vacuum testing at the port(s) indicated holds the recommended minimum 16 in-Hg and 18 in-Hg.



©2015 Sonnax Industries, Inc.

126740-15K-IN 07-21-15