

## Oversized Forward & Reverse Engagement Latch Valve Kit

**Part No.**  
**33740-07K**

- Valve
- Spring
- End Plug
- O-Ring (2)



1 Extra

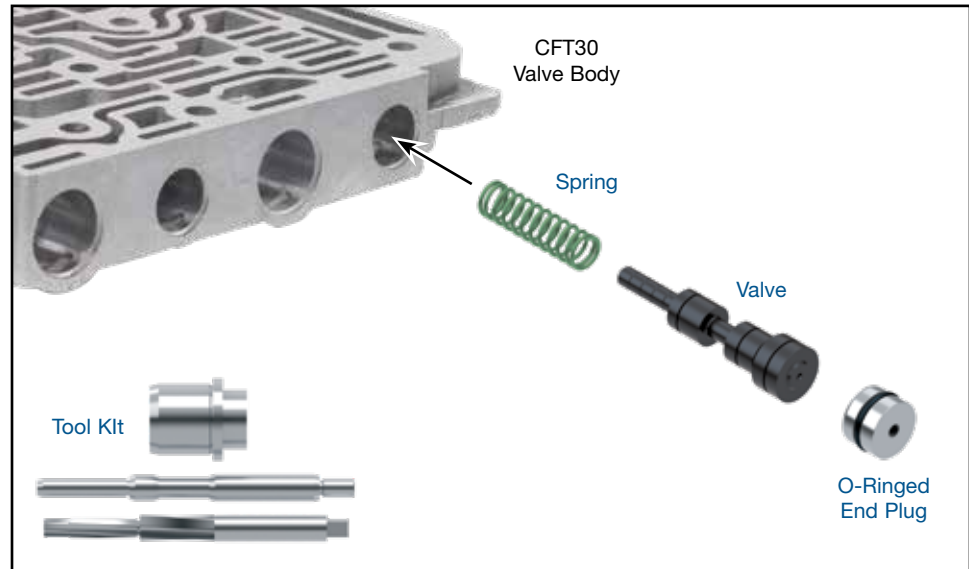
## Tool Kit

**Part No.**  
**F-33740-TL7**

- 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](http://www.sonnax.com).



## Ford CFT30

### 1. Disassembly

- Remove OE end plug retainer. Set aside for reuse.
- Remove and discard OE end plug, forward and reverse engagement latch valve and spring.

### 2. Bore Reaming

Ream forward and reverse engagement latch valve bore (for reaming instructions/reamer care, please visit [www.sonnax.com](http://www.sonnax.com)). Sonnax reaming tool kit **F-33740-TL7** and **VB-FIX** are required for this operation.

### 3. Preparation

Install O-ring into shallow groove on end plug spool.



**NOTE:** Chamfer any sharp edges at bore entrance that may cut O-ring during end plug installation.

### 4. Installation & Assembly

- Ensure all debris has been removed from valve bore and valve body.
- Install Sonnax spring.
- Install Sonnax valve with spring stem oriented inboard. Ensure spring seats over valve stem.
- Use Sonnax Slippery Stick **O-LUBE** or equivalent to lubricate O-ring, end plug and bore.
- Roll end plug on clean, hard surface work bench to size O-ring into groove.
- Position end plug into bore with tapped hole oriented outboard as illustrated.
- Press end plug into bore in small incremental steps. Rotate plug while pressing into bore. Apply light pressure when pushing on end plug, then ease off pressure while preventing plug from moving backward. These actions allow O-ring to squeeze into place as it enters bore.
- Secure with OE retainer.

### 5. Final Testing

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

