

## Oversized Solenoid Regulator Valve Kit

Part No.  
**37947-48K**



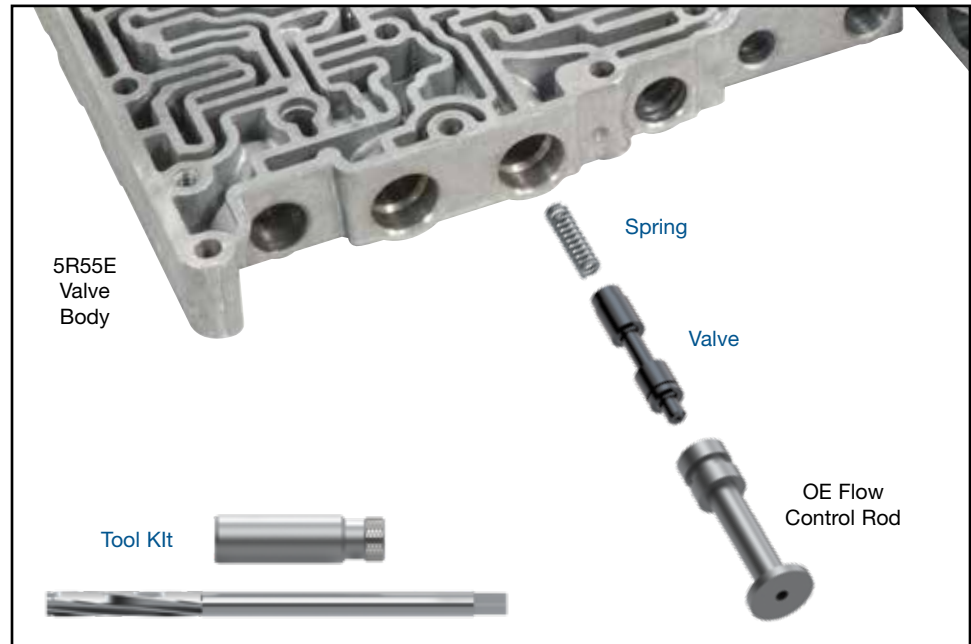
- Valve
- Spring

## Tool Kit

Part No.  
**37947-TL48**

- Reamer
- Reamer Jig

## Ford 4R44E, 4R55E, 5R44E, 5R55E



### 1. Disassembly

- Remove OE retaining bracket and set aside for reuse.
- Remove OE solenoid, L-clip and flow control rod. Save for reuse.
- Remove and discard OE valve and spring.

### 2. Bore Reaming

Ream solenoid regulator valve bore (for reaming instructions/reamer care, please visit [www.sonnax.com](http://www.sonnax.com)). Sonnax bench-style reaming tool kit **37947-TL48** is required for this operation.

### 3. Installation & Assembly

- Ensure all debris has been cleaned from valve bore and valve body.
- Install Sonnax spring into bore.
- Install Sonnax valve, ensuring spring seats in valve pocket.
- Reinstall OE flow control rod and secure with OE L-clip.
- Reinstall or replace OE solenoid. Secure with OE bracket.

### 4. Final Testing

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

