

Oversized E-Shift Valve Kit

Part No.

37000-15K

- Valve
- Spring
- End Plug

NOTE: Fits '00-'09 units only (Figure 1).

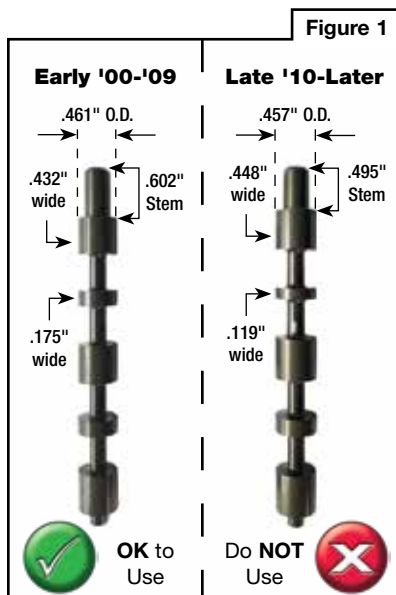
Tool Kit

Part No.

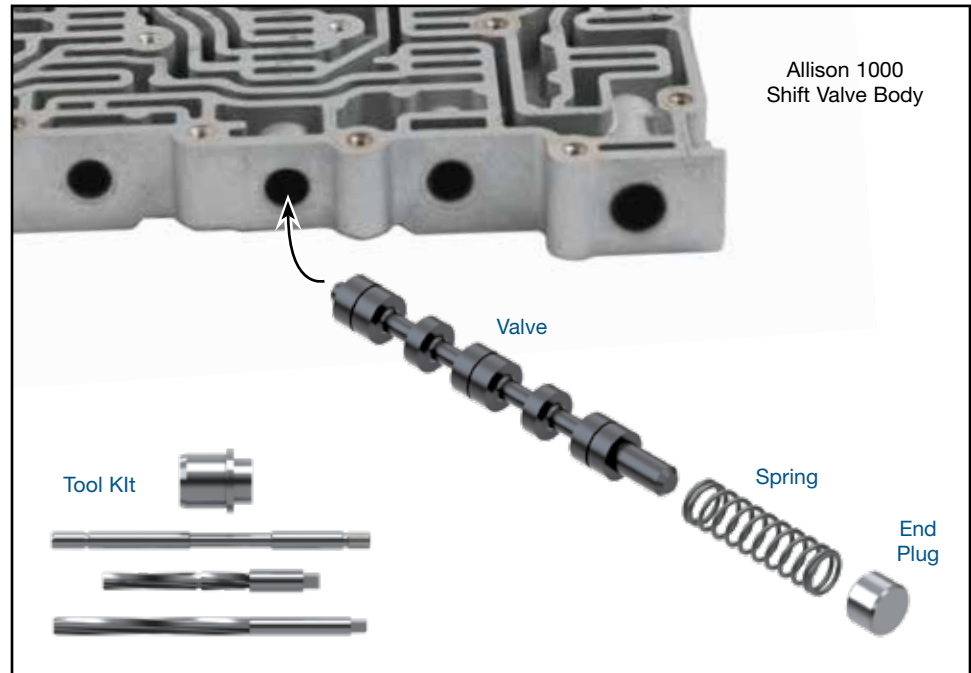
F-37000-TL15

- Reamer #1 • Reamer #2
- 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.



Allison® 1000/2000/2400



1. Disassembly

- Remove OE retainer and save for reuse.
- Remove and discard OE end plug, spring and valve.
- Thoroughly clean bore prior to reaming.



WARNING: Two-stage reaming operation is required. Failure to follow correct reaming order as described below will ruin casting.

2. Bore Reaming

- Securely clamp the casting to a flat bench or table. Use a single clamp positioned away from bore to be reamed.
- Ream E-shift bore with self-guided Reamer #1 from Sonnax reaming tool kit F-37000-TL15. Sonnax VB-FIX is NOT required for this operation.
- Thoroughly reclean bore.
- Ream E-shift bore with Reamer #2 from Sonnax reaming tool kit F-37000-TL15. Sonnax VB-FIX is required for this operation; for reaming instructions/reamer care, please visit www.sonnax.com.

3. Installation & Assembly

- Ensure all debris has been removed from valve bore and body.
- Insert Sonnax E-shift valve into bore with small nub inboard.
- Install Sonnax spring.
- Install Sonnax end plug and secure with OE retainer.

4. Final Testing

Vacuum testing at the port(s) indicated holds the recommended minimum 16 and 18 in-Hg (Figure 2).

