

## Oversized Manual Valve Kit



**Part No.**  
**37000-28K**

- Valve
- Selector Pin

## Tool Kit

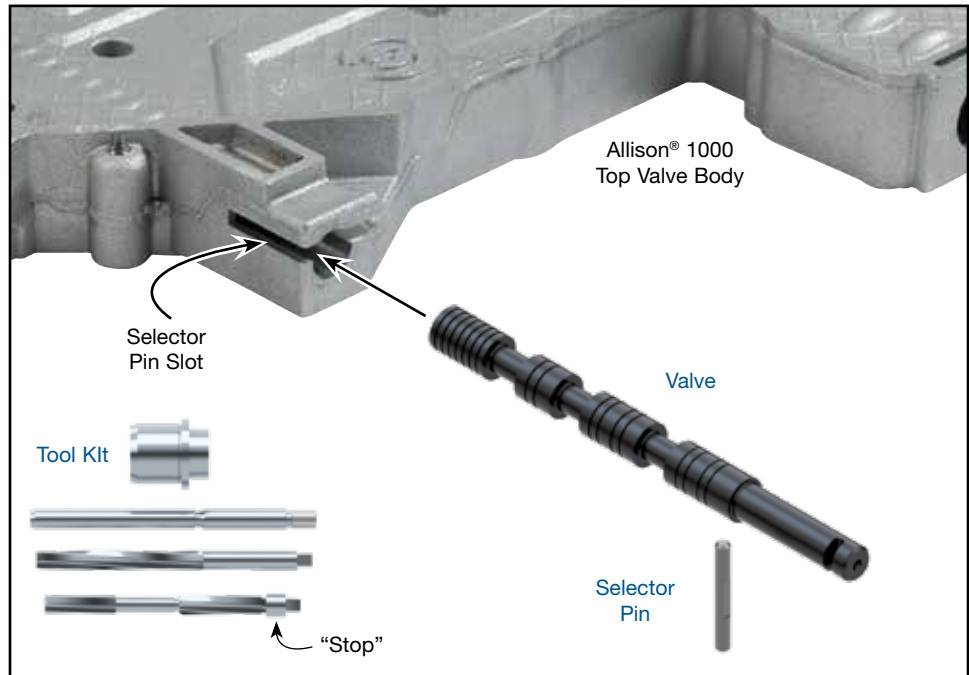


**Part No.**  
**F-37000-TL28**

- Reamer Self-Guiding
- Reamer Use with VB-FIX
- 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).

## Allison® 1000/2000/2400



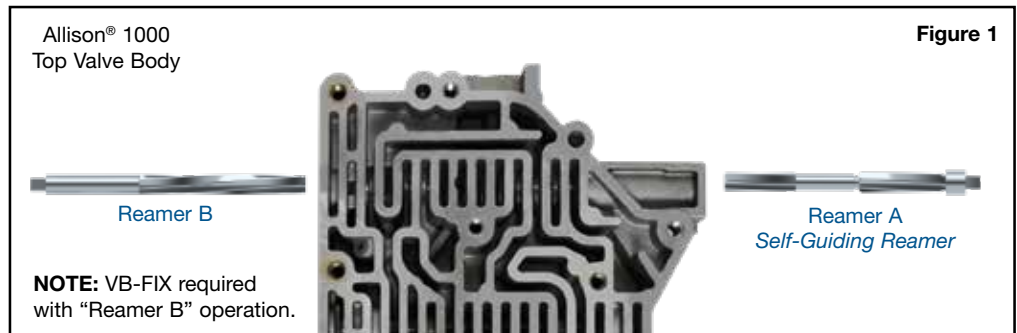
### 1. Disassembly

Remove and discard OE manual valve and its selector pin.

### 2. Bore Reaming

Ream manual valve bore in two operations (for reaming instructions/reamer care, please visit [www.sonnax.com](http://www.sonnax.com)). Sonnax reaming tool kit **F-37000-TL28** is required to complete both operations. Sonnax **VB-FIX** is required for the second reaming operation only.

- Thoroughly clean the entire manual valve bore.
- Clamp the valve body a flat bench top or other firm and flat surface. Maximize clamp distance from manual valve bore.
- Insert self-guiding reamer marked “**Reamer A**” into bore end with valve retaining pin slots so that extended guide nub is fully into bore and reamer cutting tip contacts bore entry (**Figure 1**).



### 2. Bore Reaming, *continued*

- d. Ream until the large diameter “stop” at back of reamer contacts casting outboard of valve retaining pin slots.
- e. Unclamp and thoroughly clean entire manual valve bore again.
- f. Mount valve body onto **VB-FIX** with unreamed section of bore closest to reamer jig. Align bore with reamer jig and guide pin provided.
- g. Insert reamer marked “**Reamer B**” through jig into bore. Ream until front of reamer just enters the long section of bore reamed in the first operation and stop (**Figure 2**).

### 3. Installation & Assembly

- a. Ensure all debris has been removed from valve bore and body.
- b. Install selector pin into slot on valve.
- c. Insert valve into casting engaging selector pin into slots in casting.

### 4. Final Testing

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

