

Oversized F-Trim Valve Kit



Part No.

37000-30K

- Spring
- Valve
- Sleeve
- O-Ring

NOTE: Fits '00-'05 units only.

Tool Kit



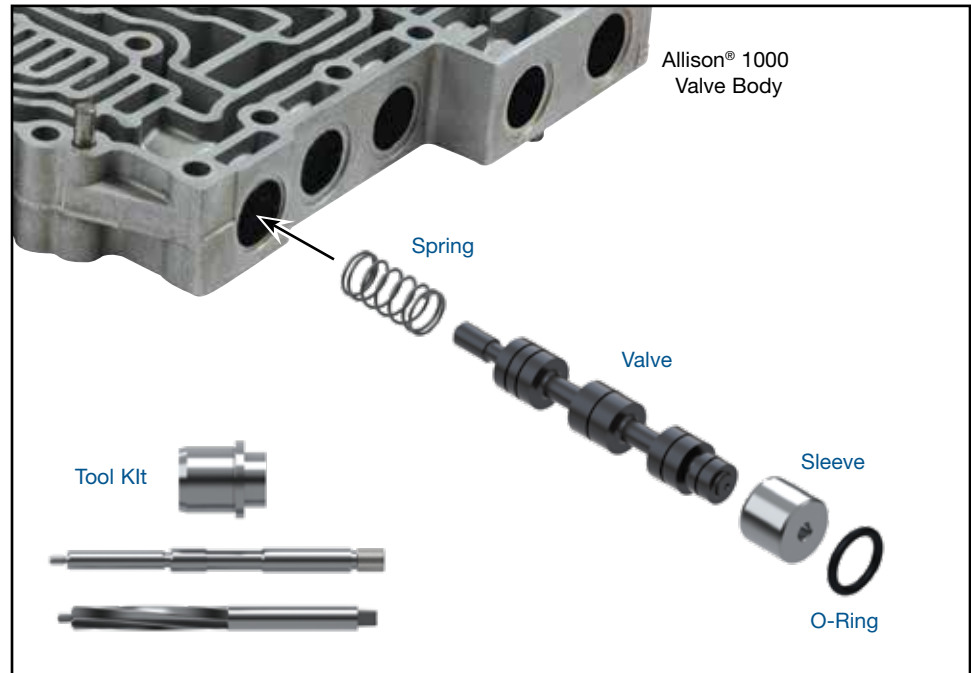
Part No.

F-37000-TL30

- 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.

Allison® 1000/2000/2400



1. Disassembly

- Remove OE solenoid retainer and solenoid. Set both aside for reuse.
- Remove and discard the OE sleeve, valve and spring.
- Thoroughly clean and dry the F-trim bore.

2. Bore Reaming

Ream F-trim bore (for reaming instructions/reamer care, please visit www.sonnax.com). Sonnax reaming tool kit **F-37000-TL30** and **VB-FIX** are required for this operation.

3. Installation & Assembly

- Be certain all debris has been removed from the valve bore and valve body.
- Insert Sonnax spring, F-trim valve and sleeve.



WARNING! Failure to replace the small O-ring on the TCC PCS solenoid with the O-ring included in the Sonnax kit will cause high TCC signal pressure when unregulated control main pressure escapes around the solenoid OE small O-ring and strokes the F-trim valve.

- Remove the smaller OE O-ring from the TCC PCS solenoid and replace it with the Sonnax O-ring.
- Reinstall TCC PCS solenoid and OE solenoid retainer.

4. Final Testing

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

