sonnax®

TRANSMISSION PARTS

Instructions

Chrysler 45RFE, 545RFE, 65RFE, 66RFE, 68RFE

Oversized TCC Regulator & Accumulator Valve Kit

Part No. 44912-12K

- TCC Regulator Valve
- Accumulator Valve
- Accumulator Spring Retainer

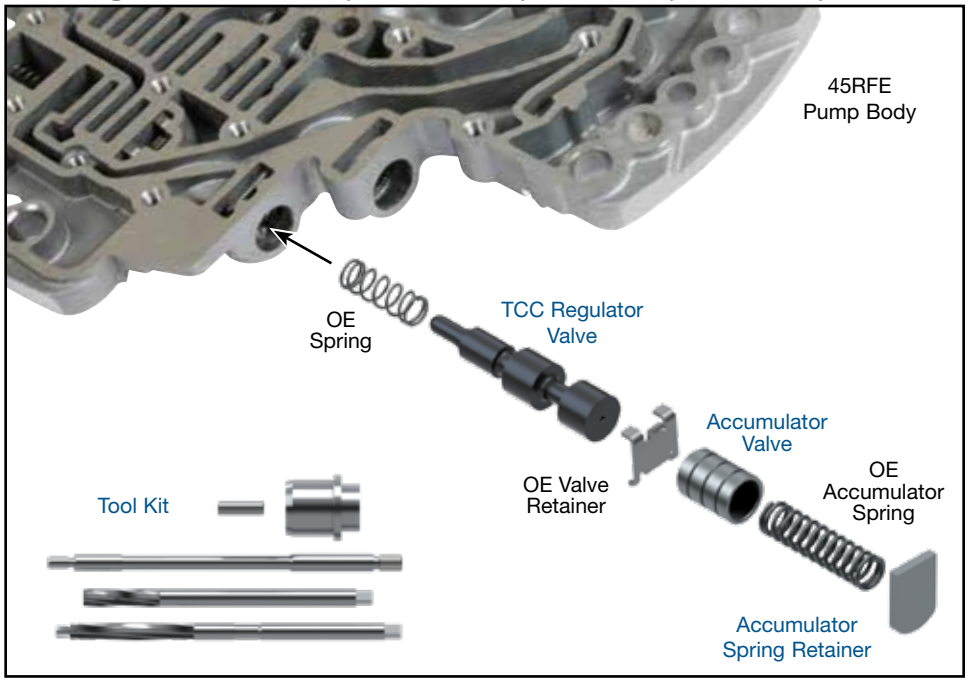
Tool Kit

VALVE BODY FIXTURE REQUIRED

Part No. F-44912-TL12

- Reamer 1
- Reamer 2
- Reamer Jig
- Reamer Stop
- 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.



1. Disassembly

a. Remove and discard OE accumulator spring retainer and accumulator valve.

b. Set aside the OE accumulator spring for reuse.

c. Remove and discard the OE TCC Regulator valve.

d. Set aside OE TCC Regulator valve spring and retainer for reuse.

2. Bore Reaming

Ream TCC regulator/accumulator bore (for reaming instructions/reamer care, please visit www.sonnax.com). Sonnax reaming tool kit **F-44912-TL12** and **VB-FIX** are required for this operation.

NOTE: This repair requires two reamers and a reamer stop. The reamer stop is used for reamer #1 ONLY, failure to use the reamer stop could/will damage the pump core beyond repair.

a. Insert the reamer stop into bore, ensure the reamer stop contacts bottom of bore.

b. Ream the TCC Regulator/Accumulator bore using reamer marked #1, ream until reamer contacts reamer stop. Remove reamer #1 and reamer stop, be certain all debris has been removed from the pump while maintaining initial setup/alignment.

c. Using Reamer #2, ream until reamer contacts bottom of bore.

3. Installation & Assembly

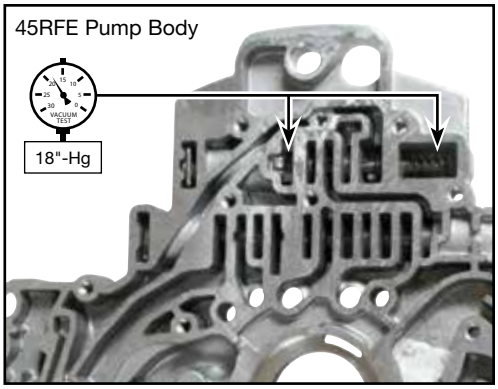
a. Be certain all debris has been removed from the valve bore and pump.

b. Reinstall OE TCC regulator spring, followed by Sonnax TCC regulator valve and the OE retainer.

c. Install Sonnax TCC accumulator valve.

d. Reinstall OE accumulator spring.

e. Secure with Sonnax accumulator spring retainer.



3. Final Testing

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