

## Oversized Signal Accumulator Piston Kit

Part No.  
**154740-01K**

- Accumulator Pistons (7)

## Tool Kit

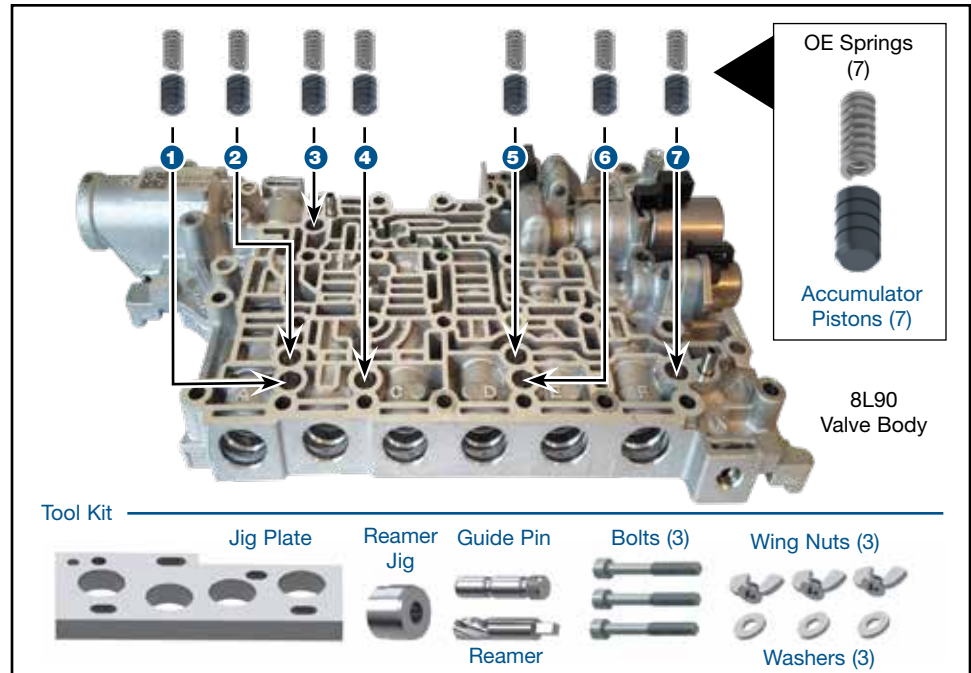
Part No.  
**154740-TL**

- Jig Plate
- Reamer Jig
- Guide Pin
- Reamer
- Bolts (3)
- Wing Nuts (3)
- Washers (3)

**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).



## GM 8L45, 8L90



### 1. Disassembly

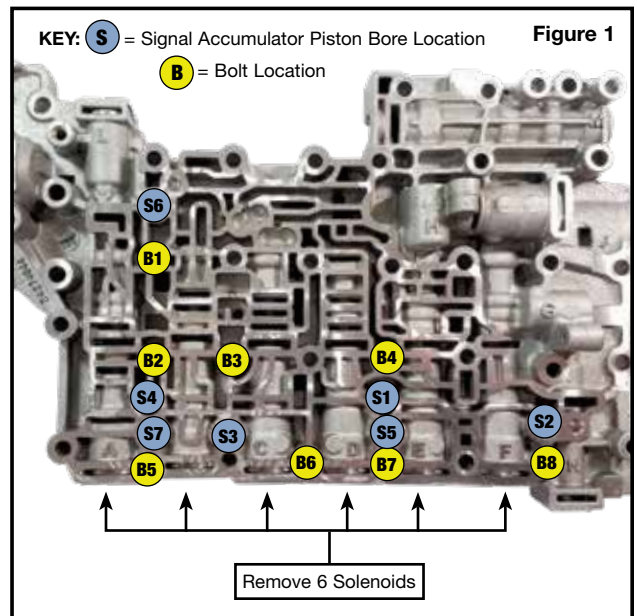
- Remove and discard OE accumulator pistons.
- Retain OE accumulator springs for reuse.
- Remove and retain 2 OE alignment pins for reuse.
- Remove solenoids (Figure 1).



**CAUTION:** It is critical to note exact location of each solenoid before removal. Each solenoid must be replaced in the original bore after reaming, or shift quality will be affected.

### 2. Bore Reaming

- Place OE control solenoid valve body casting on bench with OE accumulator bores facing upwards (Figure 1).
- Position Sonnax jig plate and use the wing nuts, bolts and washers to hold it in place where indicated (Figures 2–6).
- Recommend using small plate and clamp to secure casting to bench, ensuring not to damage machined surfaces of the casting.



### 2. Bore Reaming (continued)

- d. Install Sonnax reamer jig into specified hole (**Figures 2-6**).
- e. Slide Sonnax guide pin through reamer jig and into casting accumulator bore until bottomed.
- f. Once guide pin, reamer jig and jig plate are aligned with bore to be reamed, securely tighten wing nuts. Ensure jig plate is tightly held in place while allowing guide pin to stroke freely in reamer jig and casting bore.
- g. Remove guide pin and insert Sonnax reamer into reamer jig.
- h. Ream bore with steady, clockwise rotation. Once reaming is complete, spin the reamer a few more times to burnish and improve surface finish (for full reaming instructions/reamer care, please visit [www.sonnax.com](http://www.sonnax.com)).
- i. Repeat steps 2b-2h for remaining accumulator bores in casting.
- j. If necessary, deburr bore entrances slightly to facilitate assembly of the oversized accumulators.
- k. Thoroughly clean the casting after reaming.

### 3. Installation & Assembly

- a. Install OE spring into Sonnax accumulator piston.
- b. Install spring/piston assembly into bore, spring side upward.

### 4. Final Testing

Vacuum testing at the port(s) indicated holds the recommended minimum 18 in-Hg (**Figure 7**).

