

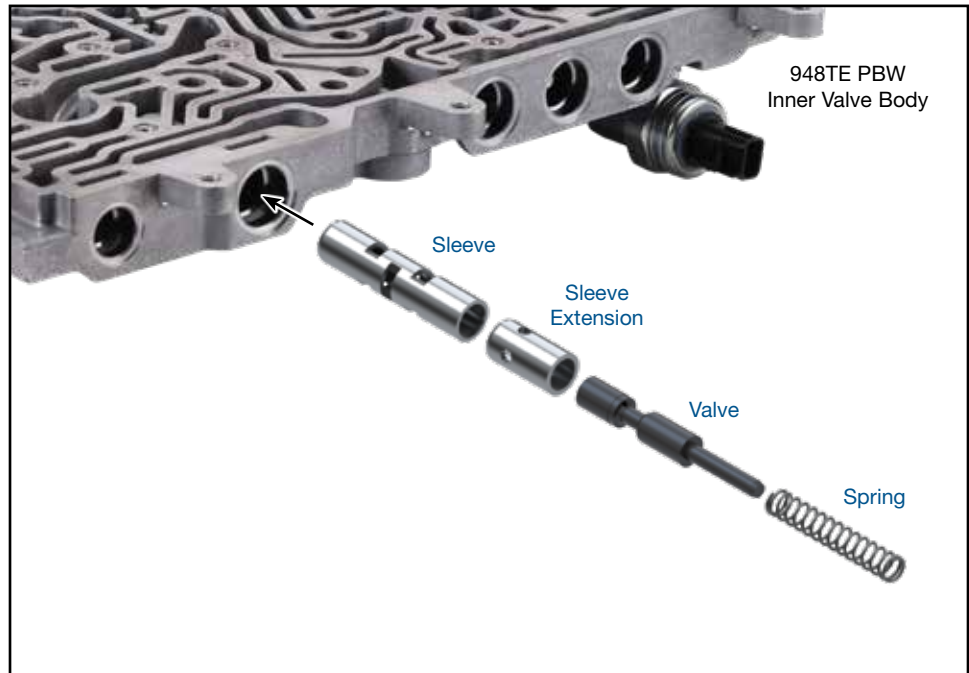
Solenoid Pressure Regulator Valve Kit

Part No.
85740-09K

- Sleeve
- Sleeve Extension
- Valve
- Spring
- Drill Bit
- Plug

Not Shown
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Chrysler 948TE; Honda/Acura, 9-Speed; ZF9HP48

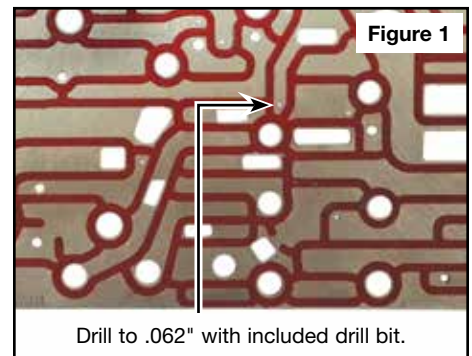


1. Disassembly

- a. Save OE retainer and end plug for reuse.
- b. Discard OE valve and spring.

2. Drill & Plug Separator Plate Balance Orifice at Solenoid Modulator Valve

- a. Using included drill bit, drill solenoid modulator balance orifice to .062" (**Figure 1**). Deburr both sides of drilled hole to ensure removal of burrs and to aid installation of aluminum plug.
- b. Insert included .062" aluminum plug into orifice, cut excess plug material using wire snippers just above flush of plate then peen material to seal orifice. Use care to ensure peened material does not interfere with gasket material and separator plate sits flush on valve body.



NOTE: The aluminum plug is extra long for handling purposes only and must be cut to length as noted above.

3. Installation & Assembly

- a. Insert Sonnax sleeve/valve assembly into bore. Sleeve should be installed with open end outboard. Valve should be installed with spring stem outboard.
- b. Insert Sonnax sleeve extension, O.D. chamfer and lube hole inward.

NOTE: In some instances it may be necessary to remove a small amount of material from the end of the sleeve extension to ensure proper fit when installing OE end plug and retainer.

3. Installation & Assembly (continued)

- c. Insert Sonnax spring over valve spring stem.
- d. Insert OE end plug and retainer.

4. Final Testing

Due to the design changes on the Sonnax sleeve and valve, vacuum testing at the inboard port is not a valid sealing test.