

TCC Regulated Apply Valve Sleeve

Part No.
33000-02



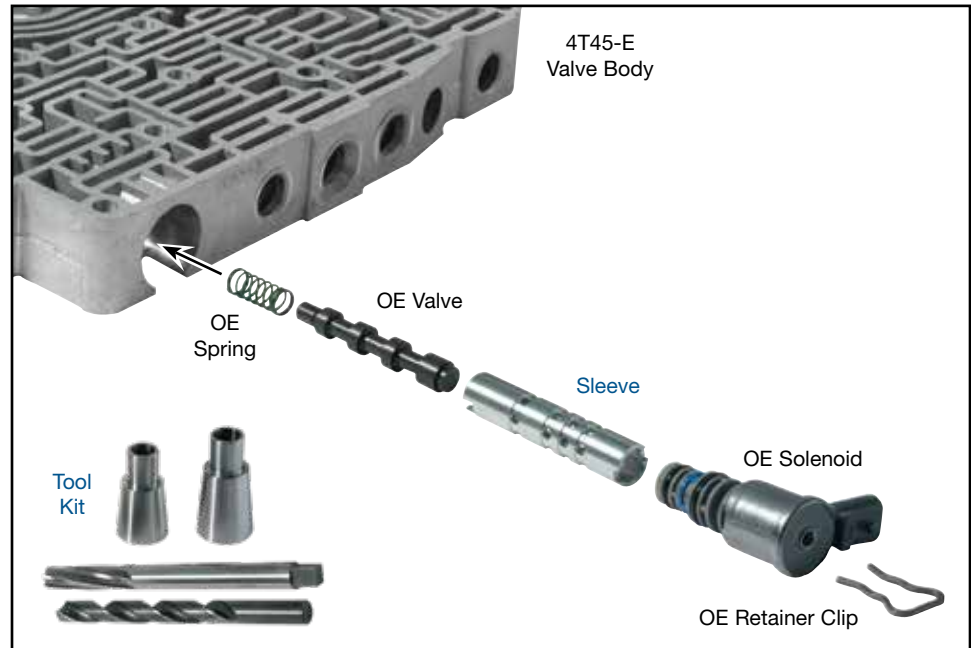
Tool Kit

Part No.
33000-TL

- Core Drill 10000-38
- Drill Jig 33000-DJ
- Reamer 33000-RM2
- Reamer Guide 33000-DJ2

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.

GM 4T40-E, 4T45-E



1. Disassembly

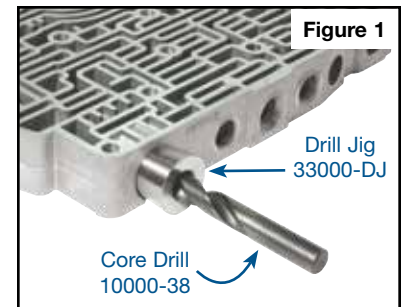
- a. Remove OE retainer clip, solenoid, valve and spring. Save for reuse.

2. Bore Reaming

Ream regulated apply bore (for reaming instructions/reamer care, please visit www.sonnax.com). Sonnax reaming tool kit **33000-TL** is required for this operation.

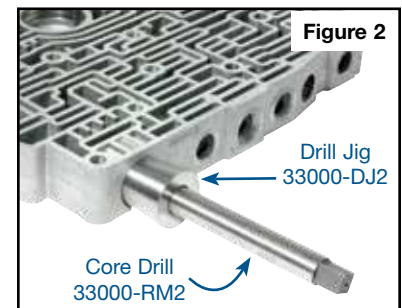
To Drill Valve Bore:

- a. Install Sonnax drill jig **33000-DJ** into bore, then insert Sonnax core drill **10000-38** into drill jig (**Figure 1**).
- b. Drill the valve bore using plenty of cutting fluid and take care not to drill through the valve bore end wall.
- c. Clean out or blow free any chips before and after removing the drill.



To Ream Valve Bore:

- a. Install Sonnax reamer guide **33000-DJ2** into bore then insert Sonnax reamer **33000-RM2** into reamer guide (**Figure 2**).
- b. Ream the valve bore by rotating the reamer in a clockwise direction with a speed handle to rotate the reamer. Use plenty of cutting fluid.



NOTE: Never rotate the reamer backward. Clean out or blow free any chips before removing the reamer. Remove any remaining debris from the valve bore.

3. Installation & Assembly

- Be certain all debris has been removed from the valve bore and valve body.
- Install Sonnax sleeve (stepped end first), pushing sleeve in until it bottoms on the valve bore end wall (**Figure 3**).
- Reinstall OE spring, valve, solenoid with o-rings and retainer clip (**Figure 3**).

4. Final Testing

Vacuum testing at the port(s) indicated holds the recommended minimum 18 in-Hg (**Figure 4**).

