

Oversized Accumulator Pressure Control Valve

36948-19

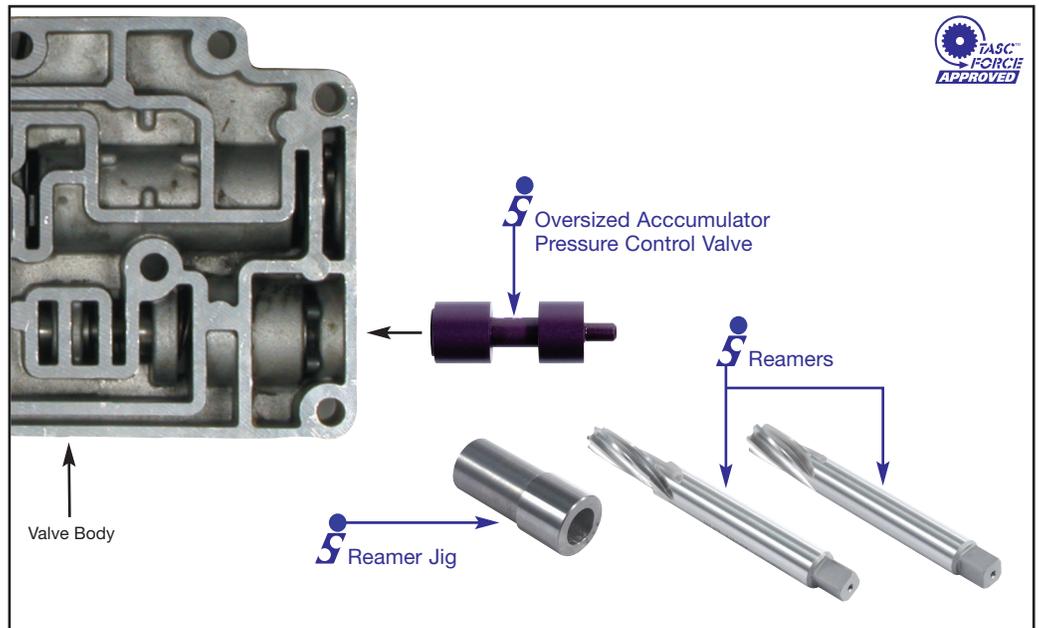
1 Oversized Accumulator
Pressure Control Valve



36948-TL

2 Reamers
1 Reamer Jig

Note: Tool kit also works in AX4N applications.



Reaming Instructions

Note: The E4OD, 4R100 applications use the reamer jig and reamer **36948-RM**. The tool kit also contains reamer **36948-RM2** for the '95-'97 AX4N. Each reamer should have the part number and application etched into the shank for identification purposes.

Prep and Set-up

1. Remove all components from the bore.
2. Clean the bore thoroughly in a solvent tank.
3. Securely clamp the housing to the bench, making sure not to clamp directly over the bore to be reamed.
4. Insert the reamer jig into the bore.
5. Soak the bore and reamer with cutting fluid (Mobilmet S-122, Lubegard Bio-Tap, Tap Magic™, etc). For best results, provide a continuous flow of water-soluble cutting fluid (i.e. Mobilmet S-122) during the reaming process.
6. Gently insert the reamer through the jig and into the bore until the cutting tip contacts the first bore to be reamed.
7. Select the correct size socket to fit the square shank of the reamer, and attach it to a wobble/swivel socket drive.

Reaming

1. The reamer should be turned either by hand using a speed handle or by a low rpm, high torque air drill regulated to a maximum of 200 rpm.
2. The reaming action should be clockwise in a smooth and continuous motion, at 60-200 rpm. The reamer should actually pull itself through the bore, so little or no forward force should be applied.
3. Continue reaming until the reamer stop is reached. The approximate reaming time is 2 minutes.

Finish and Clean-up

1. Using low air pressure, blow the chips free before removing the reamer.
2. To remove the reamer, turn clockwise while slowly pulling outward on the reamer.
3. Remove any remaining debris from the bore with low air pressure and clean in a solvent tank.
4. Examine the bore after cleaning for surface finish, debris, and burrs. Flashing and burrs on the exit side of casting bores can be carefully removed with a small piece of Scotchbrite™ on the end of a long wire.
5. Clean the reamer after each use and store in its protective tube.

Cautions and Suggestions

1. Turning the reamer backward will dull it prematurely.
2. Pushing on the reamer will result in poor surface finish and inadequate and sporadic material removal.
3. Never use a crescent wrench, ratchet or pliers to turn the reamer.
4. A dull reamer will cut a smaller hole. Reamers can be sharpened, but should only be done by a professional tool sharpener. Actual life of a reamer before resharpening averages 50-70 bores.

Installation/Assembly Steps:

1. Remove all components from the bore. Retain the valve body clip, inner spring and spring seat assembly, and the outer spring.
2. Discard the OEM accumulator pressure control valve valve.
3. For desired shift feel, use either the .372" diameter or .427" diameter plunger valve. Inspect the plunger sleeve for wear and replace with the Sonnax replacement assembly if necessary.
4. Ream the bore according to instructions.
5. Return all components to the bore in the indicated orientation (as shown below).
6. If after vehicle testing the shifts at wide-open throttle seem slightly soft, the outer line pressure modulator valve spring can be removed. This will result in slightly firmer light throttle shifts and OEM style medium and WOT throttle shifts.

