1. Disassembly
   Remove OE clip, plug, shift spring and valve. Discard OE shift spring and save all other parts for reuse.

2. Installation & Assembly
   a. Lubricate Sonnax bore sizing tool 37000-02BST with ATF.
   b. Insert sizing tool into bore. Press into bore until tool bottoms out.
   c. Remove sizing tool. The end of bore sizing tool is tapped to allow use of a slide hammer with a 5/16-18 UNC threaded adapter.
   d. Clean the bore of any debris.
   e. Lubricate OE valve and bore with ATF. Reinstall OE valve, followed by Sonnax E-shift spring, OE plug and clip.
   f. Ensure valve strokes smoothly and does not stick. If valve does not move freely, remove valve train and reinsert sizing tool. Tap tool back and forth in bore using a dead-blow hammer and screwdriver inserted through the ports and into the tool grooves (Figure 1). This will smooth out remaining ridges in bore. Repeat process until valve strokes freely.

CAUTION: Screwdriver must only contact bore sizing tool at groove (Figure 1). Do not contact machined tool face.