

E-Shift Valve Spring

Part No.

37000-02

NOTE: Fits '00-'09 units only.

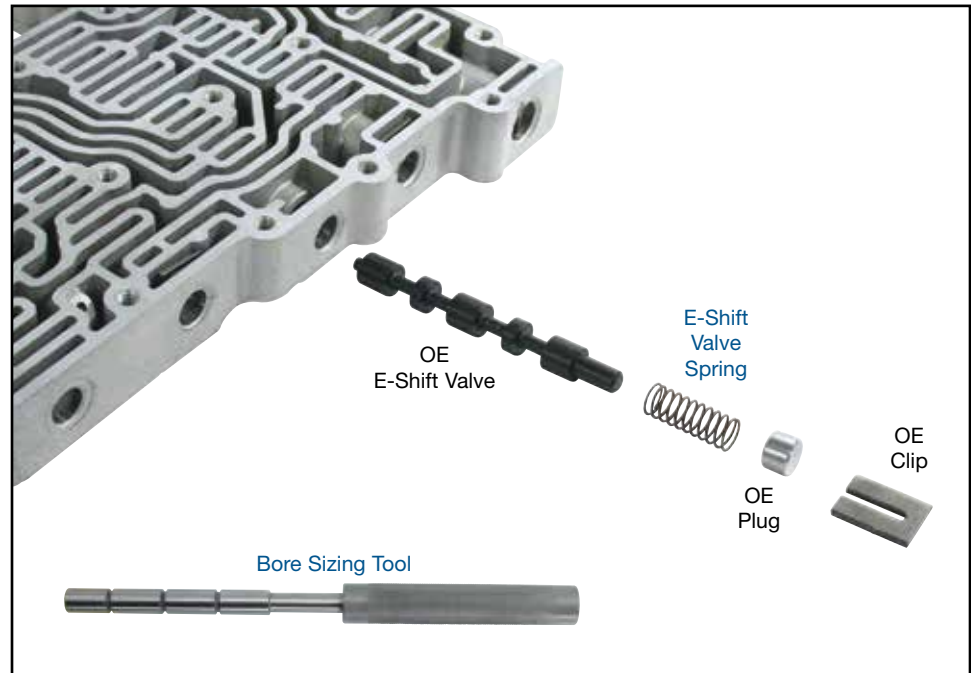
Recommended

Bore Sizing Tool

Part No.

37000-02BST

Allison® 1000/2000/2400

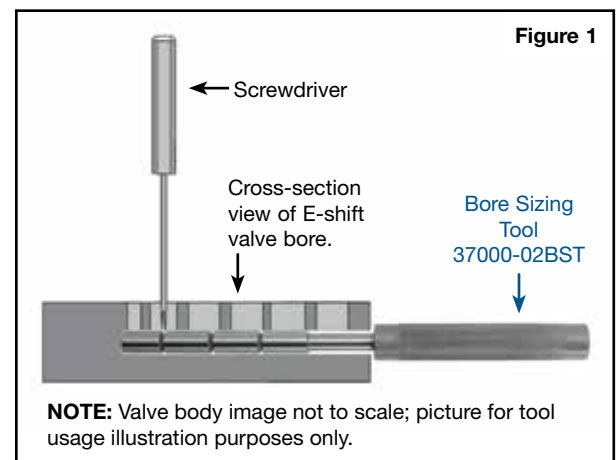


1. Disassembly

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

2. Installation & Assembly

- Lubricate Sonnax bore sizing tool **37000-02BST** with ATF.
- Insert sizing tool into bore. Press into bore until tool bottoms out.
- 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.
- Clean the bore of any debris.
- Lubricate OE valve and bore with ATF. Reinstall OE valve, followed by Sonnax E-shift spring, OE plug and clip.
- 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.