

Reverse Engagement Valve Kit

56947J-59K

- Valve
- End Plugs (2)



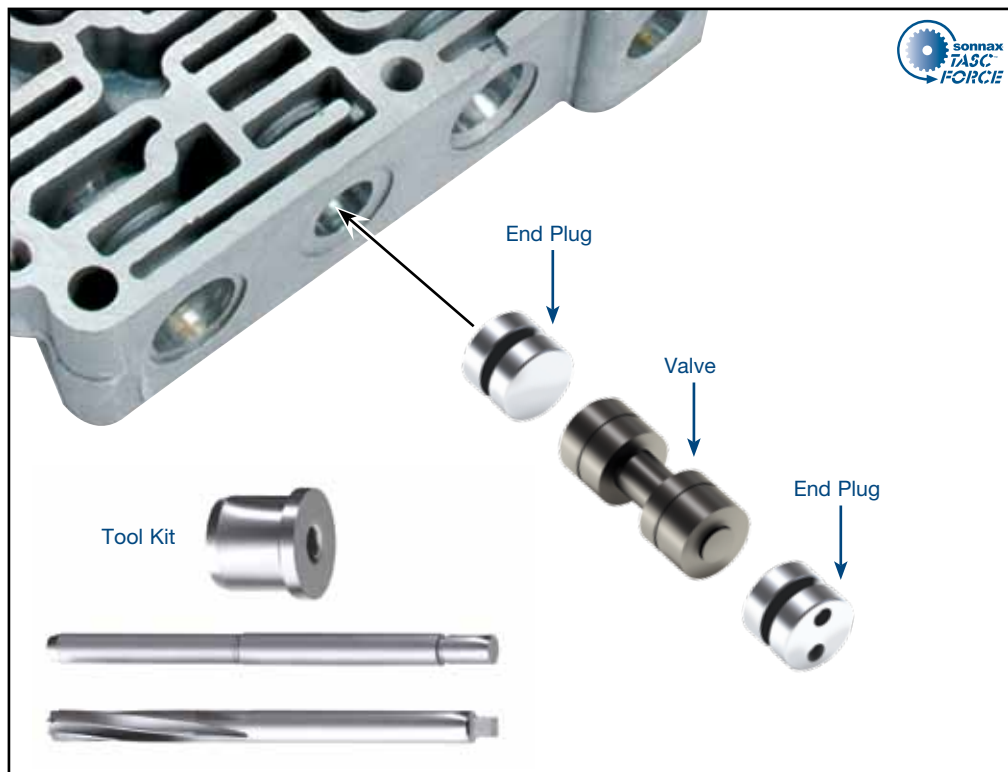
Tool Kit

F-27741-TL13

- Reamer
- Reamer Jig
- Guide Pin



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.w



NOTES OR CAUTIONS:

Wet air test the B checkball to insure it seats properly.

Air test both servo assemblies. Reverse pressure pushes both servos toward the cover. Pin bore wear creates a delay reverse.

Other valves which affect reverse:

- Rear servo control.
- Main pressure regulator and boost sleeve.
- Reverse modulator
- PCB modulator
- 4-3 pre-stroke/intermediate band control

1. Disassembly

- Remove and discard the two OE plugs, reverse engagement valve and spring.
- Keep the OE retainers, direct/reverse control valve and spring and reverse engagement valve spring for reuse.

2. Bore Preparation

- Clean the bore thoroughly in a solvent tank.
- Generously lubricate the bore and reamer with cutting fluid (i.e. 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.

c. The reamers should be turned using a low RPM, high-torque air drill regulated to a maximum of 200 RPM.

d. Examine the bore after cleaning for surface finish, debris and burrs. Flashing and burrs on the exit side of land and in bores must be carefully removed. A small piece of Scotch-Brite™ material attached to a wire and powered with a drill motor is ideal for the task. Scotch-Brite™ is a very abrasive material and all residual debris must be cleaned to ensure particles do not migrate or remain imbedded into the surface. Post cleaning involves several progressive steps with solvent on a lint-free rag.

CAUTIONS AND SUGGESTIONS:

- Turning the reamer backward will dull it prematurely.
- Pushing on the reamer will result in poor surface finish and inadequate and sporadic material removal.
- Never use a crescent wrench, ratchet or pliers to turn the reamer.
- 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 Sonnax reamer before resharpening or replacing averages 50-70 bores.

5R55N

PART NUMBERS 56947J-59K, F-27741-TL13

INSTRUCTION DATA SHEET

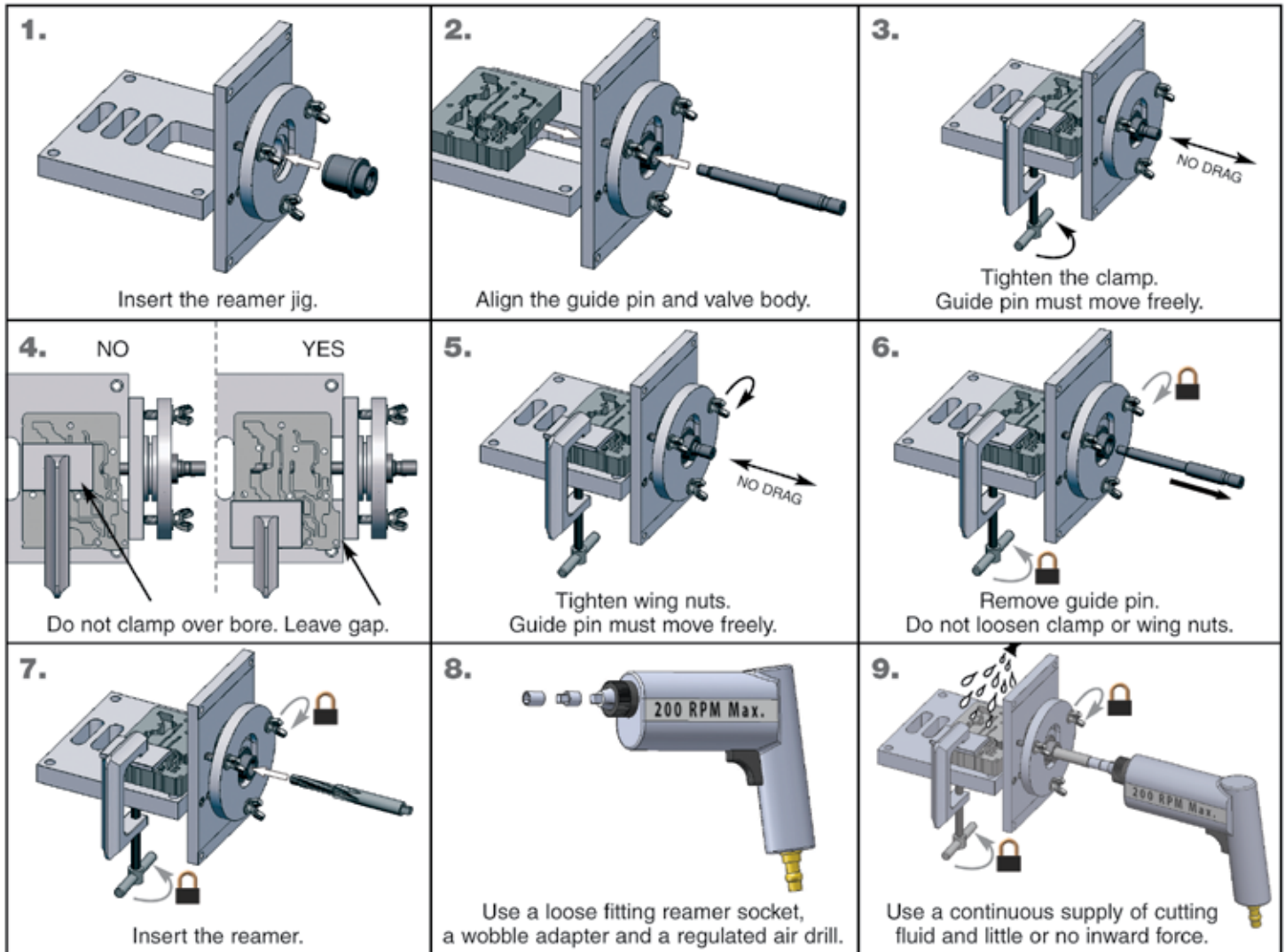
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3. Bore Reaming

Use the associated "F-Tool" kit F-27741-TL13 and VB-FIX reaming fixture as illustrated below to ream the bore.

SPECIAL NOTE:

Ream reverse engagement valve bore until tip of reamer disappears under the casting bore (Figure 1).



4. Installation & Assembly

- Return OE direct/reverse control valve and spring to inner bore.
- Install one of the Sonnax end plugs into bore (with two recessed bores facing inboard). Secure with OE L-shaped retaining pin.
- Install the oversized Sonnax reverse engagement control valve and OE spring into bore, and retain with other end plug (two recessed bores facing outward) and OE clip.

5. Final Testing

A WAT and/or vacuum test at ports indicated.

