

TCC Regulator Valve Kit

72854-03K

- Sleeve
- Valve
- Springs (3)
- Washer
- O-Ringed End Plug



Tool Kit

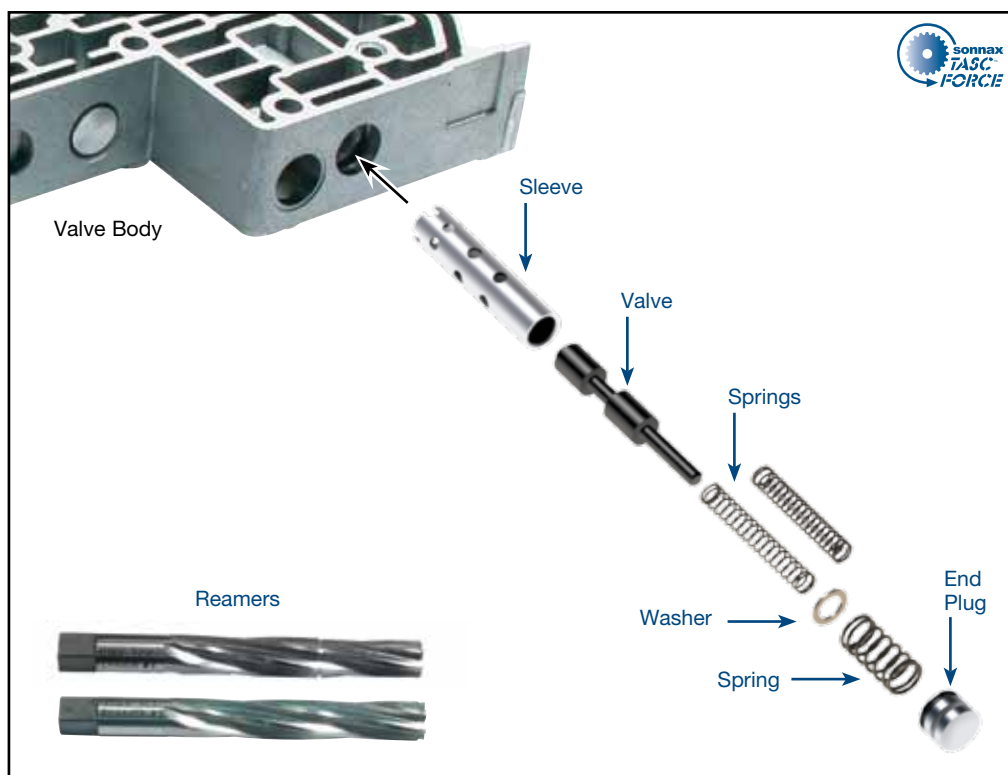
72854-TL2

Reamers (2)

Also Available

Boost Valve Assembly

72754-01K



1. Disassembly

- Remove all OE components from the bore.
- Keep OE retainer 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.
- The reamers should be turned using a low RPM, high-torque air drill regulated to a maximum of 200 RPM.
- Examine the bore after cleaning for surface finish, debris and burrs. Flashing and burrs on the exit side of land and 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 must be cleaned to insure 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.

4T80-E

TCC Regulator
Valve Kit

PART NUMBERS 72854-03K, 72854-TL2

INSTRUCTION DATA SHEET

3. Bore Reaming

- Securely clamp the valve body horizontally to the bench, making sure not to clamp directly over the bore to be reamed.
- Soak the bore and reamer with cutting fluid.
- Place self-piloting reamer #1 into the bore and ease forward until the cutting tip contacts the first bore to be reamed.
- Turn the reamer in a smooth and continuous clockwise motion, at 60-200 RPM. Continue reaming until the reamer bottoms in the bore.
- Using low air pressure, blow the chips free prior to removing the reamer.
- To remove the reamer, turn clockwise while slowly pulling outward on the reamer.
- Remove any remaining debris from the bore with air pressure and clean in a solvent tank.
- Repeat steps (b) through (g) using self-piloting reamer #2.

4. Installation & Assembly

- Push the sleeve into the bore, notched end first, until it bottoms in the bore.
- Push the valve into the installed sleeve, stem end facing out.
- Select one of the two longer and narrower springs per the following application, and place over the installed valve stem:
 - For "OE TCC apply" (25psi cracking) use the **unpainted** spring.
 - For "Firm TCC apply" (18psi cracking) and less slippage, use the **white** spring.
- Install the washer so that it sits flush with the outer face of the installed sleeve.
- Install the shorter and wider spring into the bore, over the valve stem and inner spring, flush with the washer.
- Lubricate the O-ring with Sonnax Slippery Stick™ (**O-Lube**), and install into the small groove on the end plug. Gently push the O-ringed end plug into the bore, recessed pocket facing inward, until the OE retaining clip can be installed into the end plug.

5. Final Testing

A vacuum test at either port indicated fails to hold 18" of vacuum or higher, or if visual wear is detected.

