

**GM 4L60-E, 4L65-E, 4L70-E**

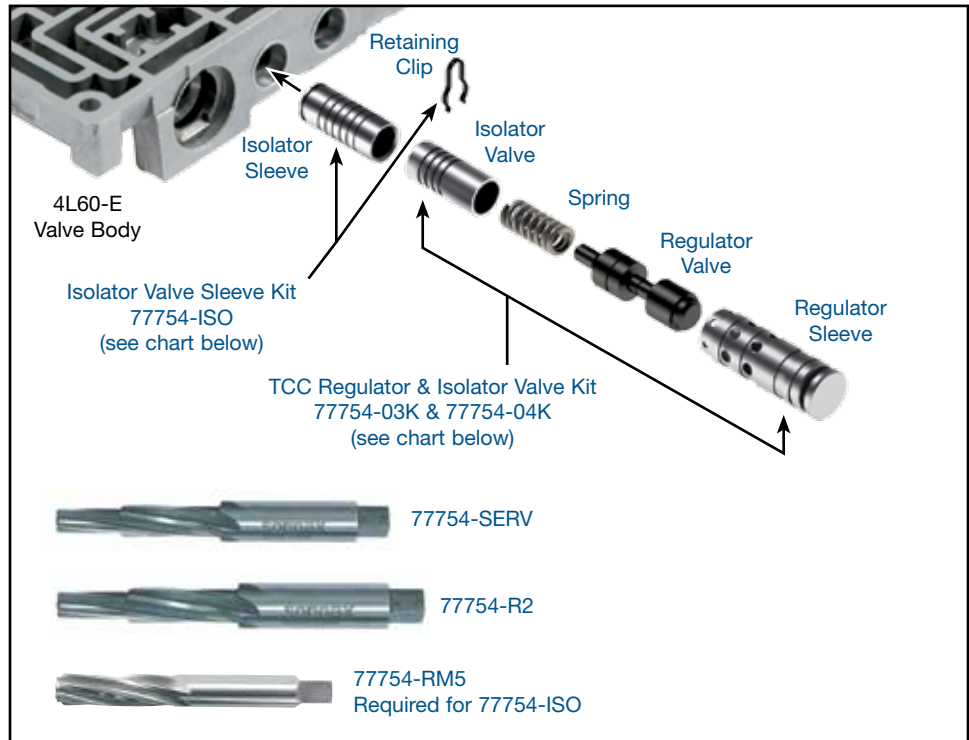
**Reamer**

**Part No.**

**77754-RM5**



**NOTE:** This reamer is required to install **77754-ISO**. See instruction included in **77754-ISO** for valve installation information.



**1. Part and Tool Use Options**

**Option A:**

If valve body has NOT been serviced (GM Remanufactured) and does NOT have a worn-out isolator bore.

- Use: **77754-R2**
- Install: **77754-03K** or **77754-04K**

**Option B:**

If valve body has NOT been serviced (GM Remanufactured) and DOES have a worn-out isolator bore.

- Use: **77754-R2** Reamer first (to cut regulator sleeve pocket)
- Then: **77754-RM5** Reamer next (to cut ISO sleeve pocket)
- Install: **77754-ISO** and either **77754-03K** or **77754-04K**

**Option C:**

If the valve body HAS been serviced (GM Remanufactured):

- Use: **77754-SERV** Reamer first (to cut regulator sleeve pocket)
- Then: **77754-RM5** Reamer next (to cut ISO sleeve pocket)
- Install: **77754-ISO** and either **77754-03K** or **77754-04K**

## 2. Reaming Instructions

### 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.

- Remove all components from bore and clean thoroughly in solvent tank.
- Generously lubricate 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.
- Gently insert proper reamer into bore until the cutting tip contacts the first land to be reamed. For Options A or B, use 77754-R2 for this step. For Option C, use 77754-SERV for this step.
- Use a loose-fitting reamer socket and a wobble adapter to ream the bore. The reamer can be turned using a speed handle or with a low-RPM, high-torque drill regulated to a maximum of 200 RPM. The reaming actions must be clockwise in smooth and continuous motion at 60-200 RPM. Continue reaming until the reamer stop is reached.
- Using low air pressure, blow chips free before removing reamer.
- To remove reamer, turn clockwise while slowly pulling outward.
- If performing reaming Option A, proceed to step 2, "Finish & Clean-Up". If performing reaming Option B or C, repeat steps "a" through "f" with reamer 77754-RM5.

## 3. Finish & Clean-Up

- Examine bore after cleaning for surface finish, debris and burrs. Flashing and burrs on 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. However, Scotch-Brite™ is a very abrasive material and all residual Scotch-Brite™ debris must be removed afterward to ensure particles do not migrate or remain embedded in the surface. Cleaning this material out should involve several progressive steps using solvent on a lint-free rag.
- Clean reamer after each use and store in its protective tube.