

Oversized Lockup Control Valve Kit

Part No.
47740-30K



- Control Valve
- Plunger Valve
- Plunger Sleeve

Tool Kit

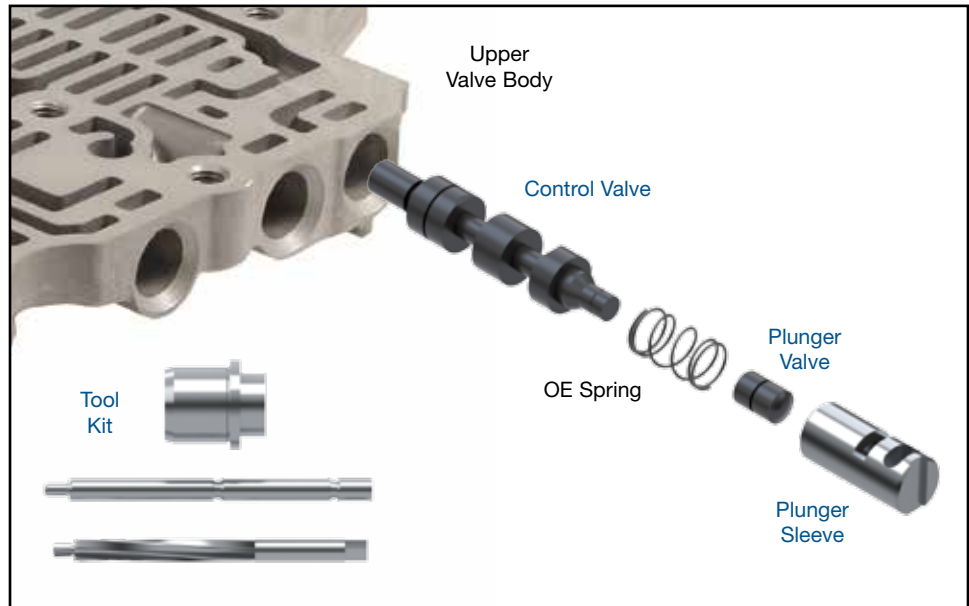
Part No.
F-47740-TL30



- Reamer
- Reamer Jig
- Guide Pin

NOTE: This tool kit can also be used to install oversized lockup control valve kit 47740-31K.

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.



1. Disassembly

- Remove OE retainer and set aside for reuse.
- Remove and discard OE plunger/sleeve assembly and lock-up control valve.
- Remove and save OE spring for reuse.

2. Bore Reaming



NOTE: Valve body is low-profile and must be secured 1/4" above the **VB-FIX** base plate in order to establish alignment with the bore. Sonnax adapter plate kit **F-85755-TL3PL** can be used for this function; pressure plates stacked under the valve body also work well.

If pressure plates are used, the valve body securing clamps **MUST** be placed directly over the plate stack. Clamping on an unsupported area of the valve body or over the bore to be reamed will cause distortion and result in irreparable damage to valve body.

Ream lockup control valve bore (for reaming instructions/reamer care, please visit www.sonnax.com). Sonnax reaming tool kit **F-47740-TL30** and **VB-FIX** are required for this operation.

3. Installation & Assembly

- Be certain all debris has been removed from the valve bore and valve body.
- Install Sonnax lockup control valve with spring stem facing out.
- Install OE spring followed by Sonnax plunger valve/sleeve assembly and OE retainer.

4. Final Testing

A vacuum test at the port indicated holds 18 in-Hg or more.

