

Oversized Clutch Holding Valve Kit

Part No.
35740-20K



- Valve
- Spring
- End Plug
- O-Rings (3) 1 Extra

NOTE: Fits 5 separate locations. Clutch holding valve locations HV-C and HV-E use an end plug, the HV-A, HV-D and HV-B1 locations do not.

Tool Kit

Part No.
F-35740-TL20

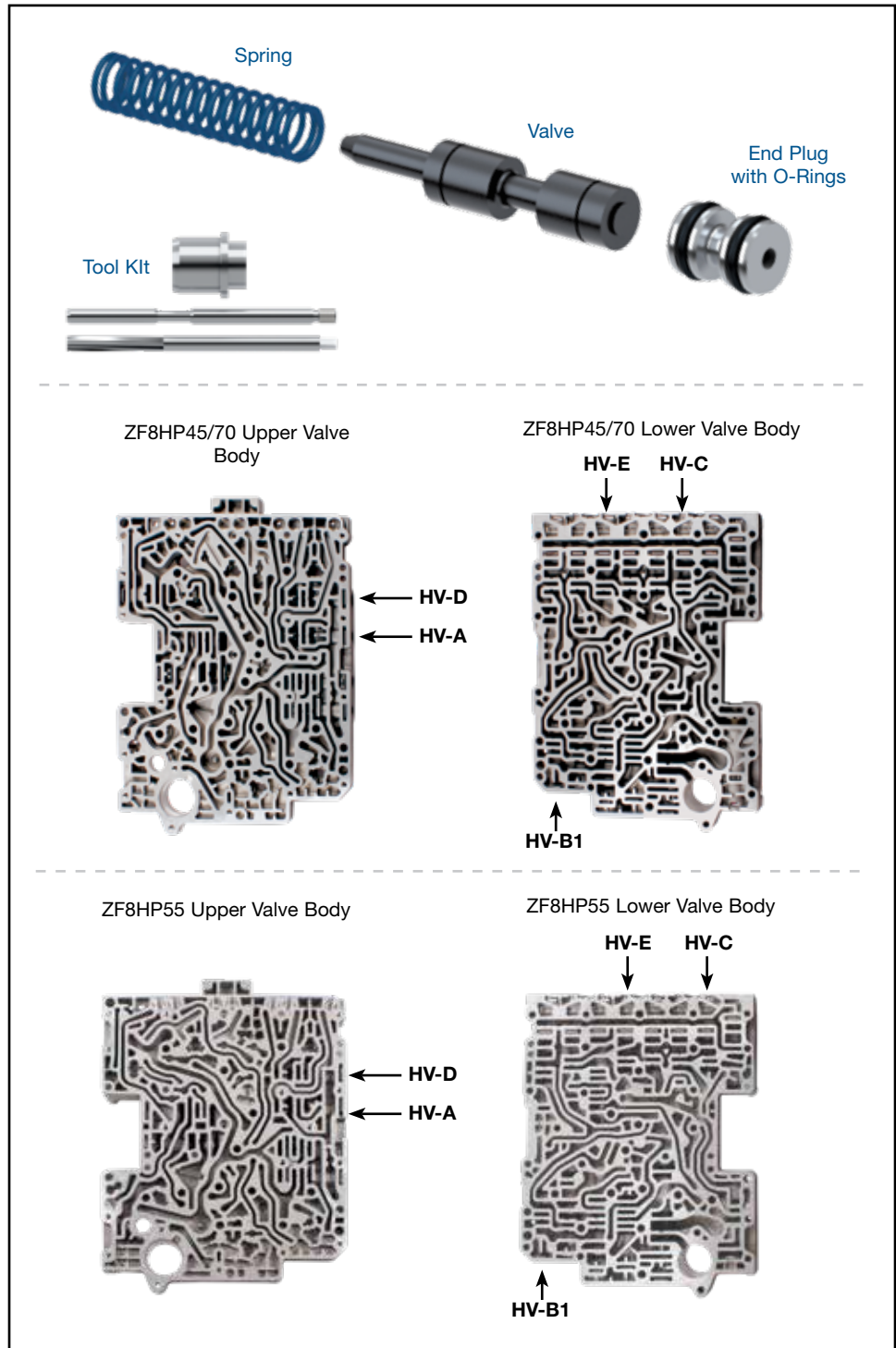


- Reamer
- Reamer Jig
- Guide Pin

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.

This tool kit can also be used for Sonnax oversized priming valve kit **35740-21K**.

Chrysler 845RE; ZF8HP45, ZF8HP55, ZF8HP70



1. Disassembly

HV-A, HV-D & HV-B1 Locations:

- Remove retaining clip and save for reuse.
- Remove and discard spring and valve.

HV-C & HV-E Locations:

- Remove solenoid retaining bracket and solenoid. Set aside for reuse.
- Remove retaining clip and save for reuse.
- Remove and discard OE end plug, valve and spring.

2. Bore Reaming

All Locations:

Ream clutch holding valve bore(s) (for reaming instructions/reamer care, please visit www.sonnax.com). Sonnax reaming tool kit **F-35740-TL20** and **VB-FIX** are required for this operation.



WARNING: For HV-A, HV-B1 and HV-D locations, ensure reamer reaches its full depth and no flashing remains at end of inner most bore! (Figures 1 & 2)
Clearing chips when reaming will help ensure reamer reaches its full depth.

Check valve to make sure it bottoms out in last pocket. Casting variations may cause reamer to leave small flashing edge which will stop the valve. Flashing should be removed carefully with small brush.

3. Installation & Assembly

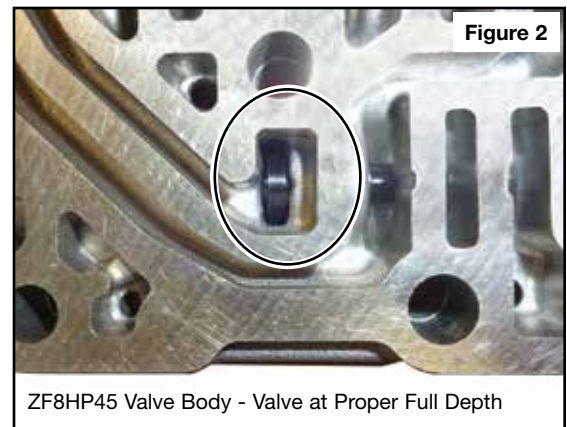
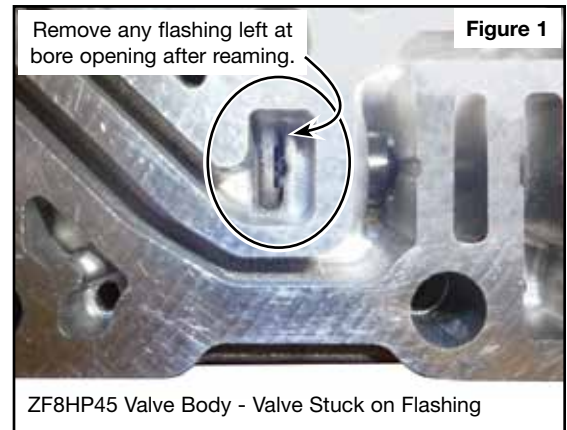
HV-A, HV-B1 & HV-D Locations:

NOTE: These locations do not require use of O-ringed end plug.

- Ensure all debris has been removed from valve bore and body.
- Install Sonnax oversized clutch holding valve followed by the Sonnax spring, ensuring spring is seated over spring guide on the valve. The spring guide faces outward.
- Reinstall OE retaining clip.

HV-C & HV-E Locations:

- Ensure all debris has been removed from valve bore and body.
- Install Sonnax spring followed by Sonnax oversized clutch holding valve, spring guide end first. Make sure spring guide is seated inside spring when installed.
- Install one O-ring in each shallow groove on Sonnax end plug and roll on a bench to size. Lubricate O-rings with Slippery Stick (Sonnax **O-LUBE**), and install end plug into bore, with threaded end facing outward.
- Reinstall OE retaining clip.
- Reinstall solenoid and solenoid retaining bracket.



4. Final Testing

Vacuum testing at the port(s) indicated holds the recommended minimum 16 or 18 in-Hg (Figures 3).



- NOTES:**
1. Some locations require blocking exhaust port on back of casting.
 2. Some locations may require larger test plate or plug in worm track.

