

Oversized TCC Apply Valve Kit

84754-50K

1 Oversized TCC Apply Valve
1 O-Ring

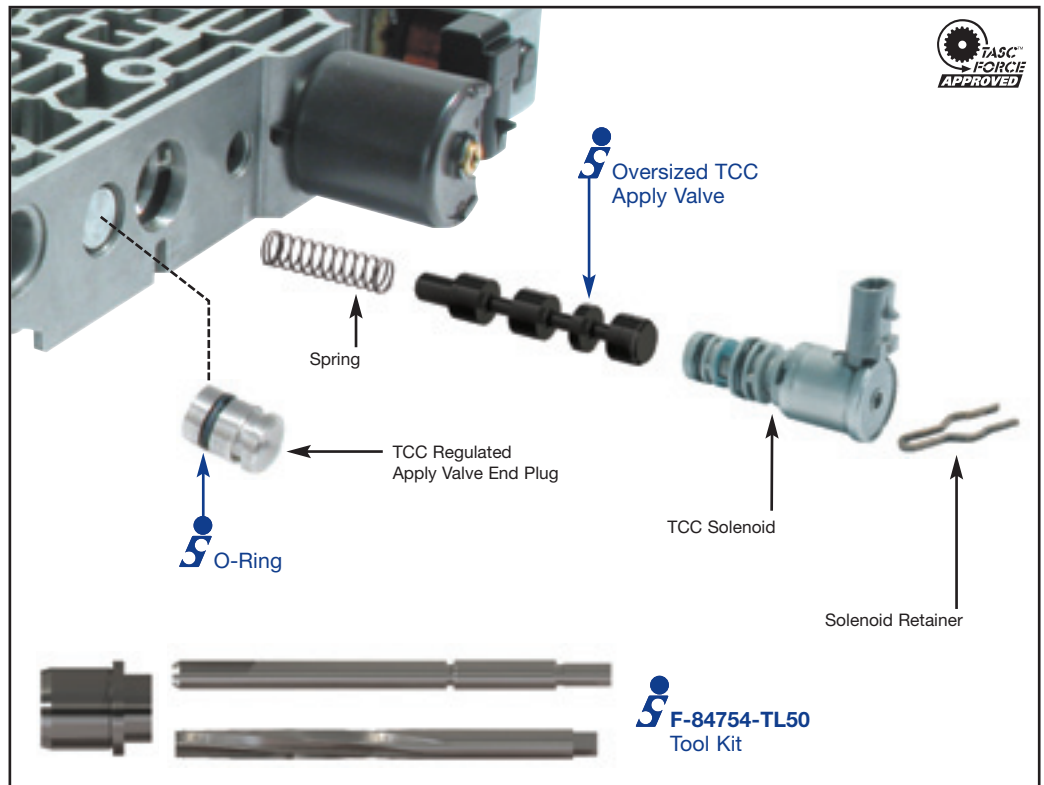


F-84754-TL50

1 Reamer
1 Guide Pin
1 Reamer Jig



Note: Always inspect the TCC regulated apply valve for wear. The o-ring in this kit should be used to replace the original end plug o-ring after inspection. Worn valves or bores can be repaired using the Sonnax TCC regulated apply valve & sleeve kit **84754-34K**.



Prep and Set-Up:

1. Remove all components from the bore and save the OEM spring for re-use.
2. Clean the bore thoroughly in a solvent tank.
3. Align the valve body on the fixture according to **VB-FIX** instructions using the guide pin and reamer jig from **F-84754-TL50** tool kit.

Important Note: Once alignment is complete, do not loosen wing nuts or unclamp valve body from fixture until entire reaming process is completed.

4. We strongly recommend a continuous flow of reaming fluid to remove chips, improve bore finish and extend reamer life. Two water soluble reaming fluids are Mobilmet S-122 and Lubegard 80903. Lubegard Bio-Tap is another alternative.
5. Gently insert the reamer through the jig and into the bore until the cutting tip contacts the first bore to be reamed.
6. Select the correct sized socket to fit the square shank of the reamer, and attach it to a swivel socket drive.

Reaming:

(We recommend you review the Sonnax reaming DVD or go the Sonnax website for a video preview of reaming.)

1. The reamer should be turned by a low rpm, high torque air drill regulated to a maximum of 200 rpm or by hand using a speed handle.
2. The reaming action should be clockwise in a smooth and continuous motion at 60-200 rpm. The reamer should actually pull itself through the bore, so little or no forward force should be applied.
3. Continue reaming until the reamer bottoms in the bore.

Finish and Clean-Up:

1. Using low air pressure, blow the chips free before removing the reamer.
2. To remove the reamer, turn clockwise while slowly pulling outward on the reamer.
3. Remove any remaining debris from the bore with low air pressure and clean in a solvent tank.
4. Examine the bore after cleaning for surface finish, debris, and burrs. Flashing and burrs on the exit side of the casting bores can be carefully removed with a piece of Scotchbrite on the end of a long wire.
5. Clean the reamer after each use and store in its protective tube.

Cautions And Suggestions:

1. Turning the reamer backward will dull it prematurely.
2. Pushing on the reamer will result in a poor surface finish as well as inadequate and sporadic material removal. The leading cutting edge will hold material if inward force and turning speed are incorrect. If a burr occurs, remove it by drawing a tool along the edge of the flute from the rear of the tool toward the tip.
3. Never use a crescent wrench, ratchet or pliers to turn the reamer.
4. A dull reamer will cut a smaller hole. Reamers can be sharpened, but should only be done by a professional machine tool sharpener.

Key Areas to Inspect:

1. Check the solenoid for clogged filter screens prior to reinstallation.
2. Lockup on top of 2nd gear or no lockup are common complaints due to a bad TCC/PWM solenoid.
3. Converter slip can be related to: PCM calibration, bad EPC force motor, or a worn TCC regulator bore.
4. Always inspect the TCC regulated apply valve for wear. The o-ring in this kit should be used to replace the original end plug o-ring after inspection. Worn valves or bores can be repaired using the Sonnax TCC regulated apply valve & sleeve kit **84754-34K**.

Installation/Assembly Steps:

1. Be certain all debris has been removed from the valve bores and valve body.
2. Install the new Sonnax TCC Apply valve & OEM spring.