

Oversized Pressure Regulator Valve

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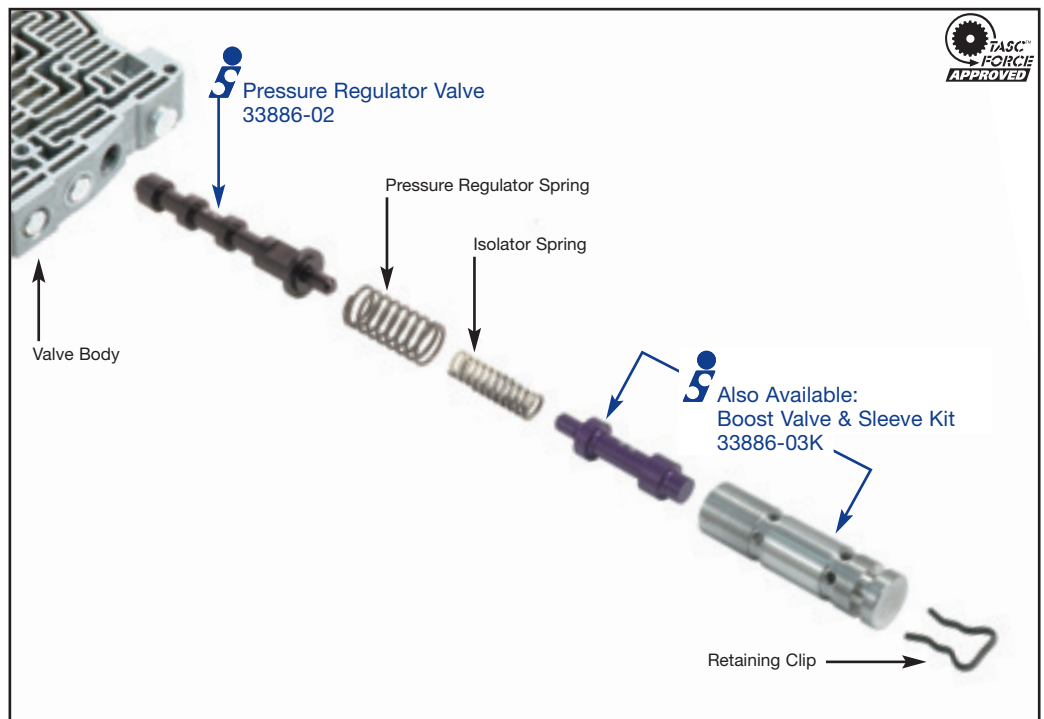
33886-02

1 Oversized Pressure Regulator Valve



33886-TL2

1 Reamer
1 Reamer Jig
1 Drill Bit



Wet Air Test

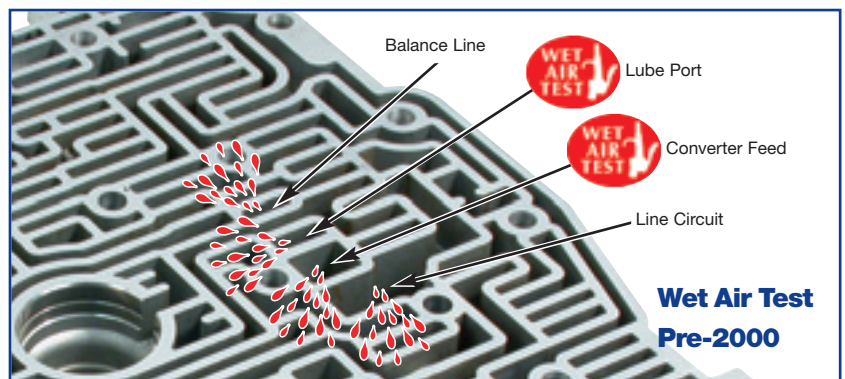
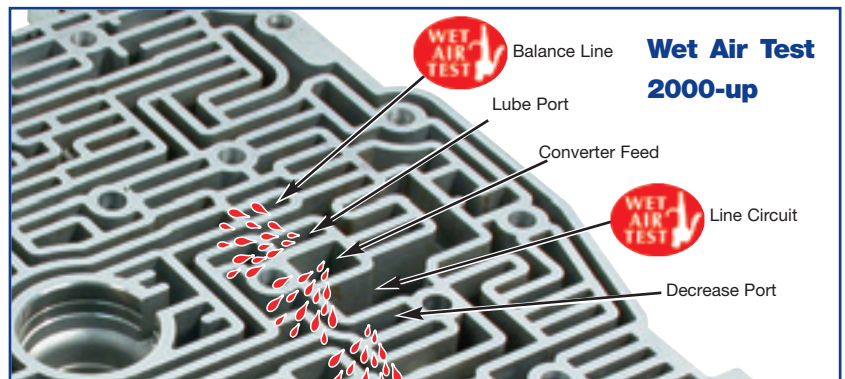
In 2000-up models without the cross-drilled valve:

1. Place a small amount of oil into the balance line circuit. Follow with low air pressure. There should be little or no leakage past the spool and into the lube port.
2. Place a small amount of oil into the line circuit. Follow with low air pressure. There should be little or no leakage past the valve spools and into the converter feed or decrease ports.

In pre-2000 models with the cross-drilled valve:

1. Place a small amount of oil into the lube circuit. Follow with low air pressure. There should be little or no leakage past the spools and into the converter feed or balance line ports.
2. Place a small amount of oil into the converter feed circuit. Follow with low air pressure. There should be little or no leakage past the spools and into the line or lube ports.

On a valve body tester machine, a worn bore has heavy leakage from the decrease circuit in all EPC settings. An unworn bore will have no leakage unless at minimum EPC pressure.



4T40-E, 4T45-E

PART NUMBERS 33886-02, -TL2

Oversized Pressure Regulator Valve

CRITICAL NOTE:

Inspect separator plate to be installed for presence of PR balance orifice. If no orifice, modify plate per illustrations.

Prep and Set-up

1. Remove all components from the bore.
2. Clean the bore thoroughly in a solvent tank.
3. Securely clamp the housing to the bench, making sure not to clamp directly over the bore to be reamed.
4. Insert the reamer jig into the bore.
5. Soak the bore and reamer with cutting fluid (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.
6. Gently insert the reamer through the jig and into the bore until the cutting tip contacts the first bore to be reamed.
7. Select a 1/4" square drive socket and attach it to a wobble/swivel socket drive.

Reaming

1. The reamer should be turned either by hand using a speed handle or by a low rpm, high-torque air drill regulated to a maximum of 200 rpm.
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 stop is reached. The approximate reaming time is 5 minutes.

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 casting bores can be carefully removed with a small 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 poor surface finish, and inadequate and sporadic material removal.
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 tool sharpener. Actual life of a reamer before resharpening averages 50-70 bores.

Installation and Assembly

In 2000-up models:

After reaming and cleaning the valve body, install the oversized valve, 2 OEM springs and boost valve assembly per the illustration.

In pre-2000 models:

1. After reaming and cleaning the valve body, install the oversized valve, 2 OEM springs and boost valve assembly per the illustration.
2. Modify the spacer plate and gasket as shown. Most gasket kits will have the oval hole cut out: then only the spacer plate would have to be drilled.

PR Balance Orifice Location on Separator Plate & Gasket

