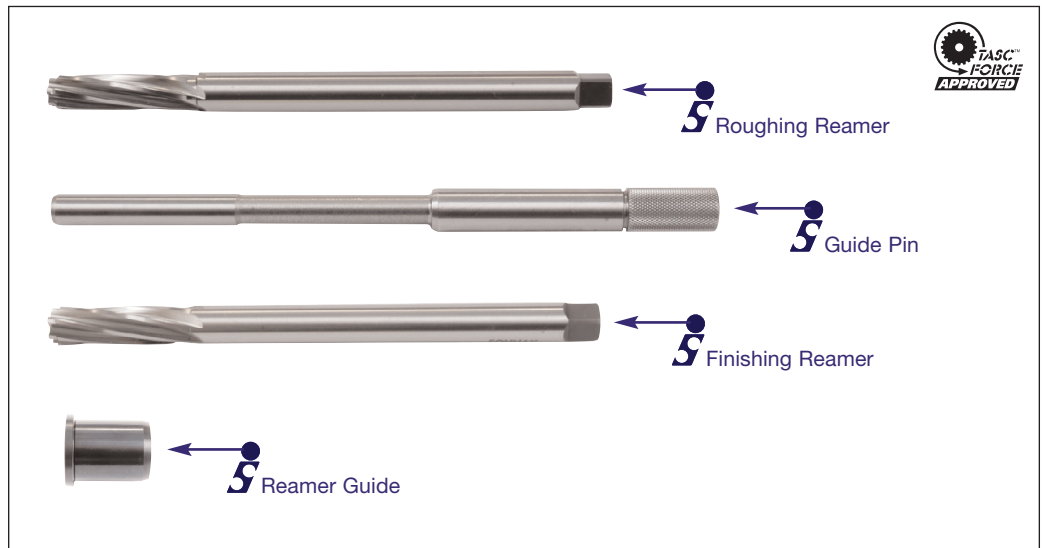


## Actuator Feed Limit Valve Tool Kit

### F-34200-TL16

1 Roughing Reamer  
1 Finishing Reamer  
1 Reamer Jig  
1 Guide Pin  
1 Drill Bit, .051"



### Reaming Instructions for Reaming with F-34200-TL16:

1. Remove valves from the bore to be reamed. Clean bore thoroughly in a solvent tank.
2. Align valve body on fixture according to **VB-FIX** instructions, using jig **F-77754-RJ9** and guide pin **F-34200-GP16**.  
**Note:** Do not unclamp valve body from the fixture until you have finished both reaming operations.
3. Begin with **F-34200-RM16**.
4. With the reamer carefully and securely positioned, use a speed handle to ream the bore. The reaming action should be clockwise in a smooth and continuous motion, at approximately 1 to 1½ revolutions per second.
5. The reamer should pull itself through the bore, so little or no forward pressure should be applied to the reamer or speed handle.
6. Continue reaming until the tip of the reamer bottoms in the bore. Spin the reamer 5-10 more times after bore bottoming to allow for excess material removal and better surface finish.
7. Using low air pressure, blow the chips free before removing the reamer.
8. To remove the reamer, turn clockwise while slowly pulling outward on the reamer.
9. Repeat steps 4 - 8, using finishing reamer **F-34200-RM17**.

### Cautions:

- Never turn the reamer backward.
- Pushing on the reamer will result in poor surface finish, inadequate and sporadic material removal, and material being left unremoved as the reamer exits a bore.
- Blow free any chips from the reamer after each use.
- Never use a crescent wrench, t-handle or ratchet to turn the reamer.

**Note:** The .051" drill bit will be used for the separator plate modifications as outlined in the AFL valve kit instructions.