

TCC Regulated Apply Valve Sleeve

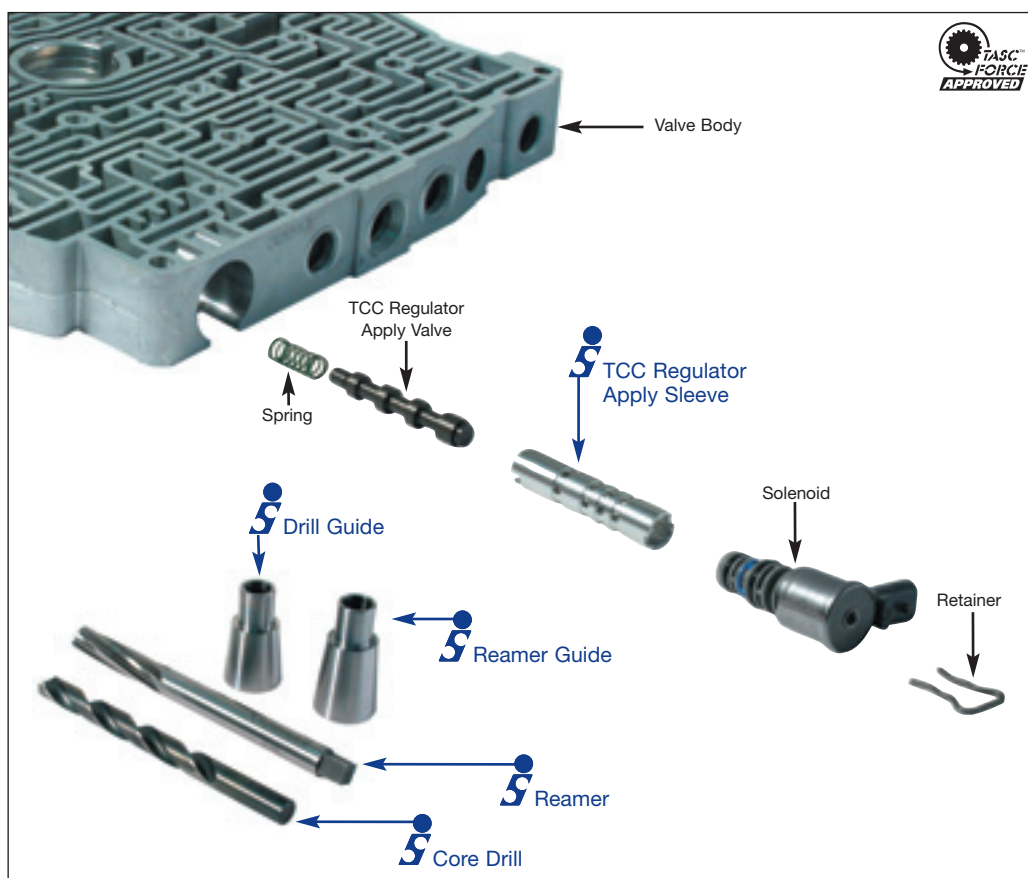
33000-02

TCC Regulator Apply Sleeve



33000-TL

1 Core Drill
1 Drill Guide
1 Reamer
1 Reamer Guide



4T40-E, 4T45-E '95-UP

PART NUMBERS 33000-02, -TL

**TCC Regulated Apply
Valve Sleeve**

Instructions:

For Drilling and Reaming:

1. Remove the OEM retainer clip, TCC control solenoid, regulated apply valve and valve spring. Save these components for reinstallation.
2. To drill the valve bore, install the drill bushing **33000-DJ** into the bore. Insert the drill into the bushing as illustrated (see Figure A). Drill the valve bore using plenty of cutting fluid and take care not to drill through the valve bore end wall.
3. Clean out or blow free any chips before and after removing the drill.
4. To ream the valve bore, install the reamer guide **33000-DJ2** into the bore. Insert the reamer **33000-RM2** into the reamer guide as illustrated (see Figure B). Ream the valve bore by rotating the reamer in a clockwise direction and use plenty of cutting fluid. Use a speed handle to turn or rotate the reamer.

Note: Never rotate the reamer backward. Clean out or blow free any chips before removing the reamer. Remove any remaining debris from the valve bore.

For Sleeve Installation

1. Be certain that all debris has been removed from the valve bore and valve body.
2. Install the new Sonnax valve sleeve **33000-02**; stepped end goes in first.
3. Push the sleeve in until it bottoms on the valve bore end wall as illustrated below (see Figure C).
4. Install the TCC valve spring, regulated apply valve, control solenoid with o-rings and retainer clip as illustrated below (see Figure C).

