

## TCC Regulator & Isolator Valve Kit

'93-up PWM units

### 84754-06

1 Isolator Valve Sleeve

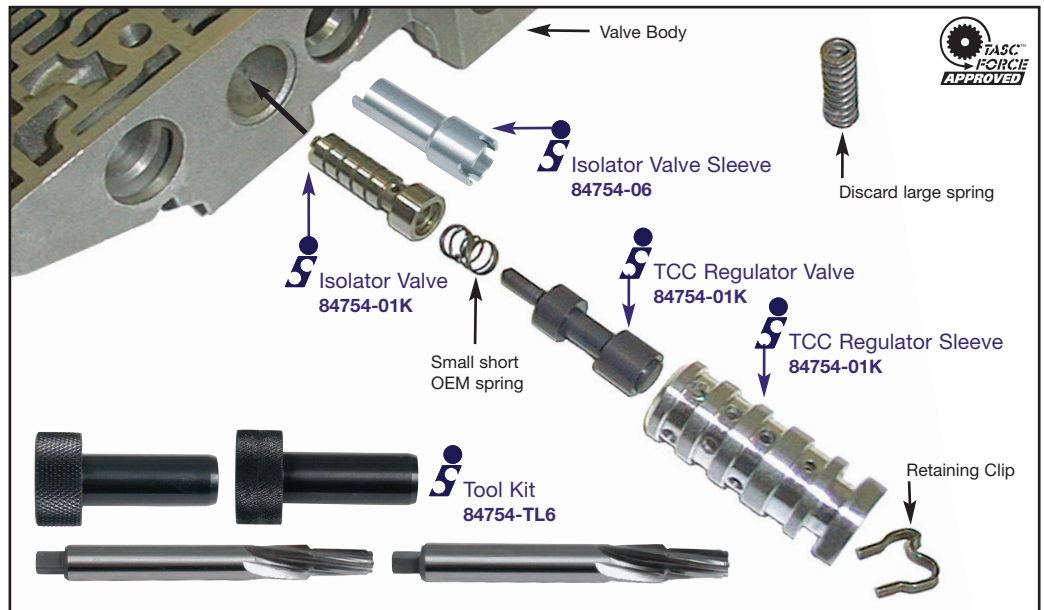
### 84754-TL6

1 Roughing Reamer

1 Finishing Reamer

1 Roughing Reamer Jig

1 Finishing Reamer Jig



### Disassembly:

Remove the OEM isolator and regulator valve line-up. Save the short OEM spring and retainer. If Sonnax kit **84754-01K** was previously installed, retain the entire line-up.

### Reaming Instructions:

1. Lubricate the reamer jig, valve body bore and reamer with cutting fluid.
2. Insert and bottom the rough reamer jig **84754-RJ7** in the TCC regulator bore at the front of the isolator valve bore. Pass the reamer marked **84754-RM9** through the jig until the chamfered cutting surface contacts the bore end.
3. Using a speed handle, ream the bore clockwise at 1 to 1 ½ turns per second. This reaming operation should take approximately 2 minutes.
4. Using low air pressure (35 psi) and with the reamer still in the bore, blow the chips out of the bore.
5. While turning the reamer clockwise, remove it from the bore. Clean the remaining chips from the bore.
6. Remove **84754-RJ7** and install **84754-RJ6**. Using the reamer marked **84754-RM10**, repeat steps 3, 4 and 5 for the finish reaming operation.

### Installation:

1. After reaming and thoroughly cleaning the valve body, lubricate the isolator sleeve with ATF and install it, small OD first, into the bore.
2. Ensure the end of the sleeve seats against the bottom of the bore.
3. Rotate the sleeve as necessary to set the step end at the very bottom of the bore.
4. The isolator sleeve is held in place by the regulator sleeve supplied with **84754-01K**. Variations in the valve body casting may cause misalignment of the clip groove on the regulator sleeve with the clip opening in the valve body. Measure the misalignment and remove that amount of material from the large OD end of the isolator valve sleeve. The recommended gap between the two sleeves is .005"/.025". Once the proper gap has been established, insert the isolator sleeve, **84754-06**, followed by the components of the Sonnax TCC regulator valve kit, **84754-01K**, according to the instructions included in that kit.