

Oversized Manual Valve

36940-11

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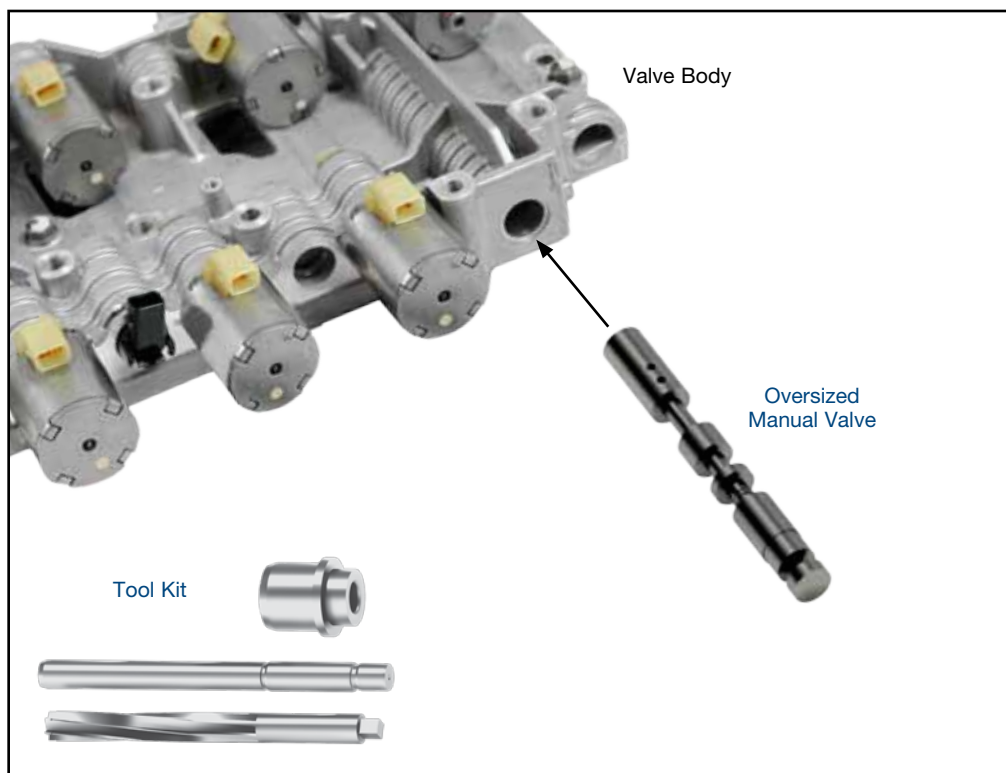
Tool Kit

F-36940-TL11

- Reamer
- Reamer Jig
- Guide Pin



NOTE: Sonnax "F-Tool" kits designed to service a specific bore require the VB-FIX, a self-aligning valve body reaming fixture. More information and instructions are available at www.sonnax.com.



1. Disassembly

- Removal of the low/reverse clutch solenoid from the valve body is required to mount the valve body onto the **VB-FIX** base plate. This solenoid is immediately adjacent to the manual valve bore.
- Remove all components from the bore.

2. Bore Preparation

- Clean the bore thoroughly in a solvent tank.
- Generously lubricate the bore and reamer with cutting fluid (i.e. Mobilmet S-122, Lubegard Bio-Tap, Tap Magic™, etc.). For best results, provide a continuous flow of water-soluble cutting fluid (i.e. Mobilment S-122) during the reaming process.
- The reamers should be turned using a low RPM, high-torque air drill regulated to a maximum of 200 RPM.
- Examine the bore after cleaning for surface finish, debris and burrs. Flashing and burrs on the exit side of land and bores must be carefully removed. A small piece of Scotch-Brite™ material attached to a wire and powered with a drill motor is ideal for the task. Scotch-Brite™ is a very abrasive material and all residual must be cleaned to insure particles do not migrate or remain imbedded into the surface. Post cleaning involves several progressive steps with solvent on a lint-free rag.

CAUTIONS AND SUGGESTIONS:

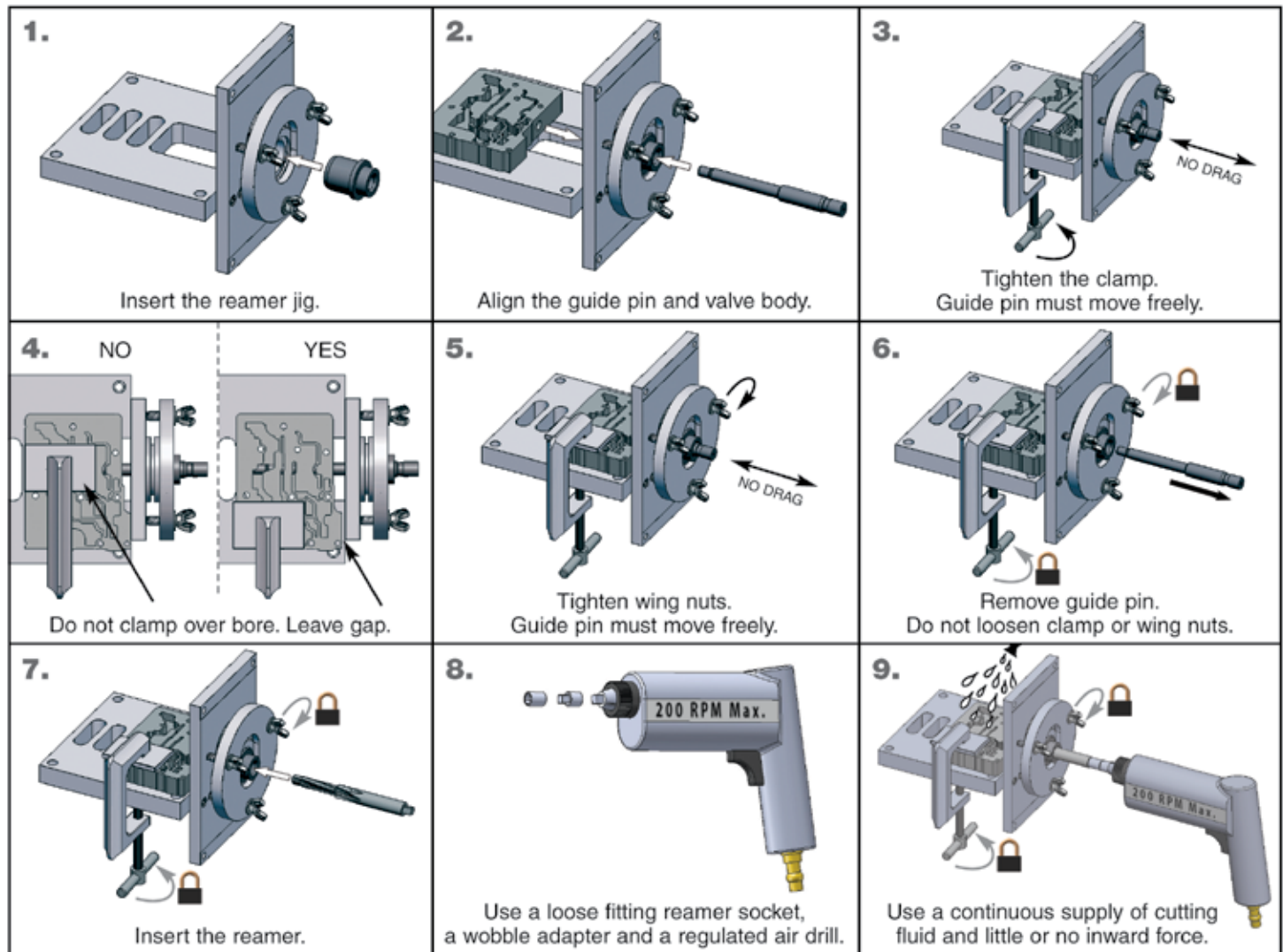
- Turning the reamer backward will dull it prematurely.
- Pushing on the reamer will result in poor surface finish and inadequate and sporadic material removal.
- Never use a crescent wrench, ratchet or pliers to turn the reamer.
- A dull reamer will cut a smaller hole. Reamers can be sharpened, but should only be done by a professional tool sharpener. Actual life of a Sonnax reamer before resharpener or replacing averages 50-70 bores.

3. Bore Reaming

Continued on following page.

3. Bore Reaming

Use the associated "F-Tool" kit F-36940-TL11 and VB-FIX reaming fixture as illustrated below to ream the bore.



4. Installation & Assembly

- Insert the oversized manual valve into the reamed and deburred bore.
- Reinstall the low/reverse clutch solenoid.
- Install the valve body onto the transmission case and assemble the selector linkage connection per accepted procedures.