

TV Control Valve & Valve Plunger Kit

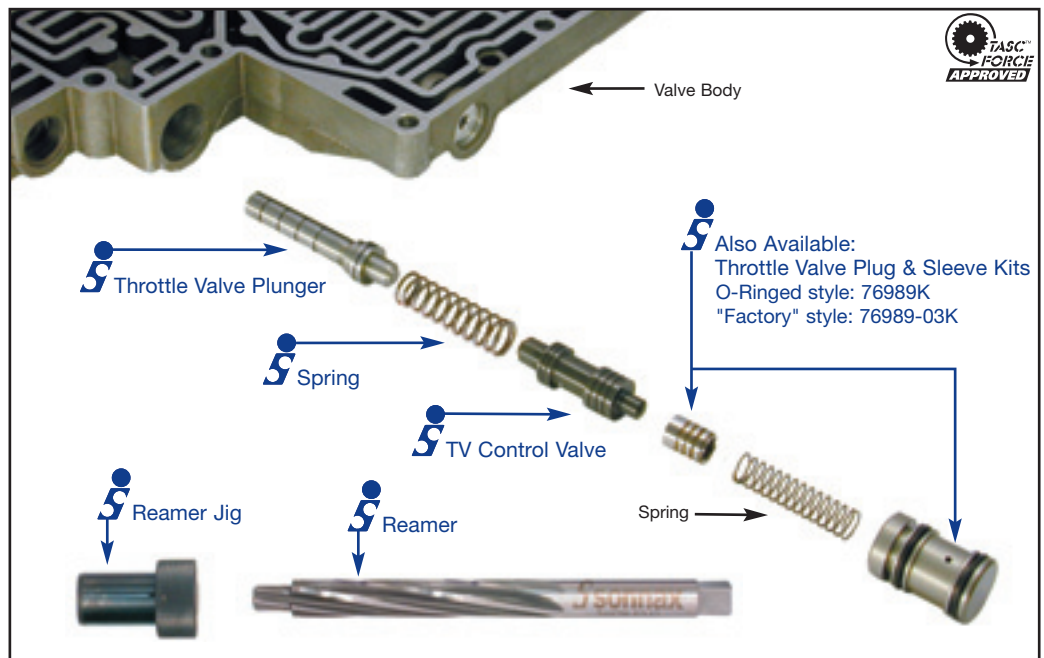
76970-02K

1 TV Control Valve
1 Throttle Valve Plunger
1 Throttle Valve Spring



76970-TL

1 Reamer
1 Reamer Jig



Wet Air Test

Note: To Wet Air Test the valve assembly, the separator plate must be installed.

Throttle Plunger

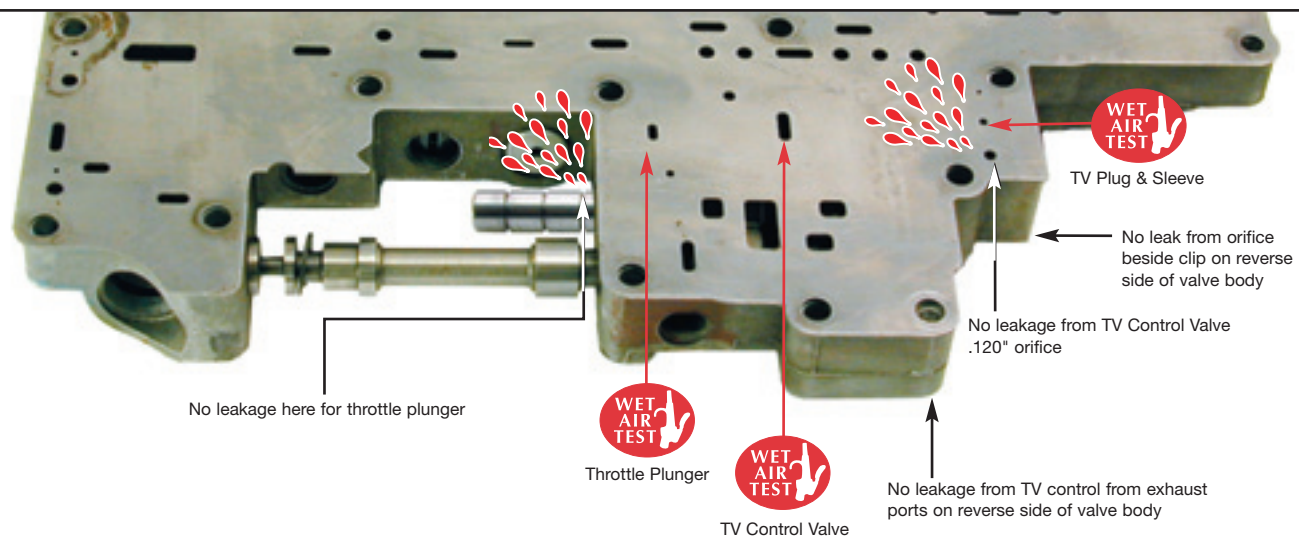
Place a small amount of oil into the indicated orifice. Follow this oil with low air pressure. Excessive oil leakage should not occur where the throttle plunger exits the valve body bore.

TV Control Valve

Place a small amount of oil into the indicated orifice. Follow with low air pressure. Excessive oil/air leakage should not occur at the .120" diameter orifice or exhaust ports on the reverse side of the valve body.

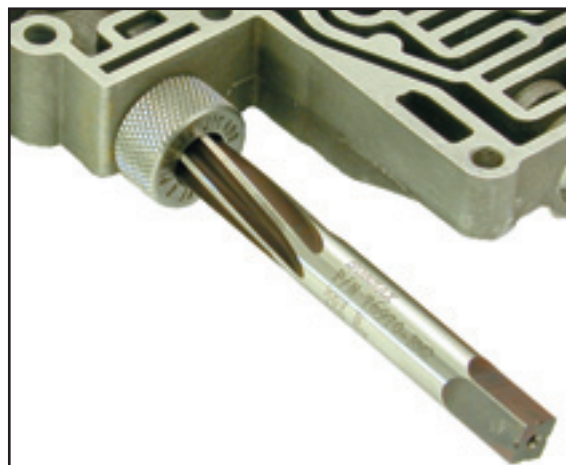
TV Plug/Sleeve

Place a small amount of oil into the indicated orifice. Follow with low air pressure. Excessive oil leakage should not occur at the orifice beside the retaining clip on the reverse side of the valve body.



Reaming Instructions

1. Remove valves from the bore to be reamed.
2. Clean valve body. A mix of mineral spirits and degreaser is recommended.
3. Clamp the valve body to bench with open circuits up.
4. Fill bore with cutting fluid (Kerosene, Tap Magic™, etc.).
5. Insert the reamer jig into bore.
6. Soak fluted end of reamer with cutting fluid.
7. Insert reamer into reamer jig until reamer tip contacts the first bore to be cut. Securely position the reamer in the forward position to remove any reamer wobble. The chamfer at the reamer tip will help stabilize and center the reamer.
8. With the reamer carefully and securely positioned, use a speed handle to rotate the reamer. The reamer should actually pull itself through the bore, so little or no back pressure should be applied to the reamer or speed handle.
9. The reaming action should be clockwise in a smooth and continuous motion, at approximately 1 to 1-½ revolutions per second.
10. There is a considerable amount of material being removed from this bore. About halfway through reaming the bore, the chips should be blown free to prevent the reamer from binding.
11. Continue reaming until 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.
12. Using low air pressure, blow the chips free before removing the reamer.
13. To remove the reamer, turn clockwise while slowly pulling outward on the reamer.
14. Remove any remaining debris from the bore with low air pressure and mineral spirits/degreaser.
15. Lubricate the replacement valves with ATF. Fit the valve into the reamed bore. If snug, repeat the reaming procedure with an air drill at 500 rpm.



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 any chips free from the reamer after each use.
- Never use a crescent wrench or ratchet to turn the reamer.

Installation Instructions

Refer to the photos for proper valve orientation.

