

## Tool Kit for 84754-40K

### 84754-TL2

1 Reamer #1  
1 Reamer #2  
1 Reamer Guide

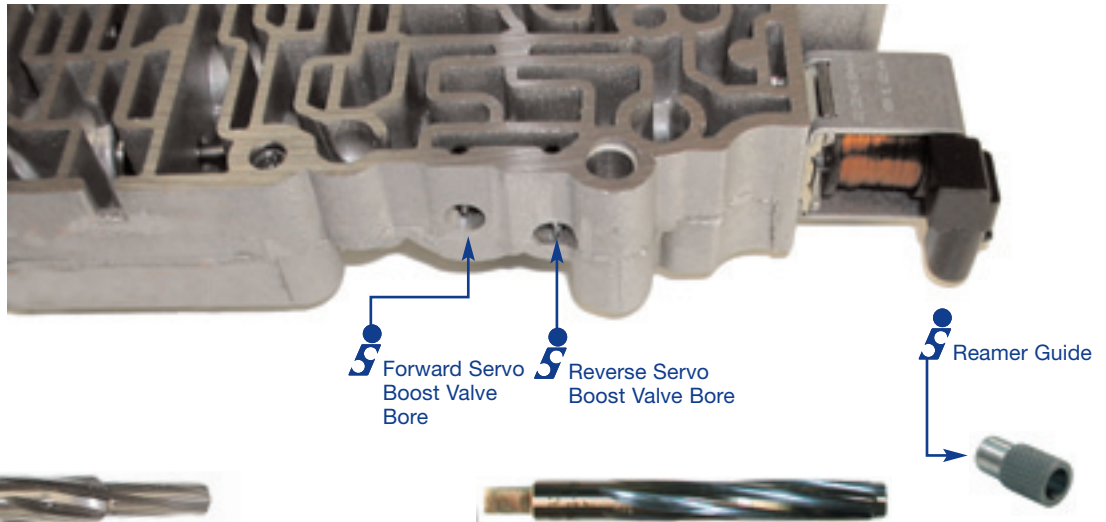
**More technical information**  
is available at [www.sonnax.com](http://www.sonnax.com). Type  
in this part number under "Part Finder."

### 4T60-E and 4T65-E applications use 84754-TL2



### For 4T60-E & 4T65-E 1-2 Servo Boost Valve & Reverse Servo Boost Valve Bores

#### 4T60-E & 4T65-E



The piloted reamer labeled "4T60E/4T65E #1" is used first on both the 1-2 and reverse servo boost valve bores in the 4T65-E and the 1-2 servo boost bore in the 4T60-E.

The reamer labeled "4T60E/4T65E #2" and reamer guide are used to ream both the 1-2 and reverse servo bores to their final sizes.

**Note:** The 4T60-E reverse servo does not require this reamer as the end plug bore accepts the reamer guide and #2 reamer.

### Valve Body Preparation

- STEP 1** Remove and discard all OEM parts from 1-2 (forward) or reverse servo boost valve bore.
- STEP 2** Clean valve body bore with solvent to remove any sludge or metal shavings.
- STEP 3** Clamp valve body to bench horizontally with open circuits up. Do not clamp directly over bore to be reamed as this may distort the bore.

# 4T60-E & 4T65-E

PART NUMBER 84754-TL2

Tool Kit for 84754-40K

## First Reaming Operation: 1-2 & reverse servo bores

**Note:** The 4T60-E reverse servo bore does not require this first reaming operation. Skip to finish reaming operation.

### Step 1

Ream the servo bore with the stepped reamer marked "4T60E/4T65E#1". Note: This piloted reamer does not require a reamer guide. Lubricate reamer and valve body bore with cutting fluid.

### Step 2

Insert reamer into bore until chamfered cutting tip contacts inner bore opening. Using a speed handle, ream bore clockwise at 1 to 1-1/2 turns per second. This reaming operation should take approximately 1 minute.

### Step 3

With low air pressure and reamer still in the bore, blow chips out of bore.

### Step 4

Turning clockwise, remove the reamer from the bore. Clean the remaining chips from the bore.

## Finish Reaming Operation: for 1-2 & reverse servo bores

### Step 1

Insert reamer guide in bore. Lubricate "4T60E/4T65E#2" reamer and bore with cutting fluid.

### Step 2

Insert reamer through guide and into bore until chamfered cutting tip contacts inner bore to be reamed.

### Step 3

Using a speed handle, ream bore clockwise at 1 to 1-1/2 turns per second. Continue until reamer tip bottoms in bore. Approximate time = 1.5 minutes

### Step 4

With low air pressure and reamer still in the bore, blow chips out of bore.

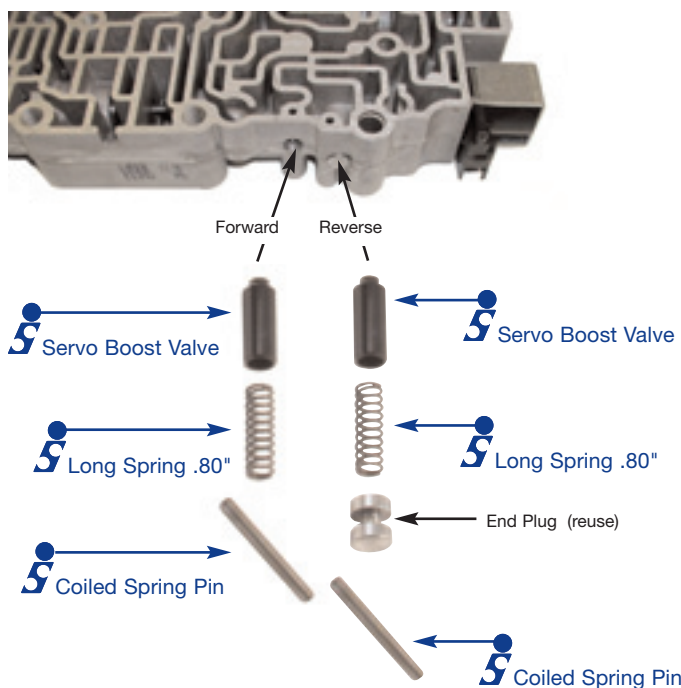
### Step 5

Turning clockwise, remove the reamer from the bore. Clean the remaining chips from the bore.

## Valve Body Assembly

The valve body is now ready to accept new Sonnax servo boost valves. Install valve, spring and retainer as shown below.

### 4T60-E



### 4T65-E

