

Oversized Manual Valve

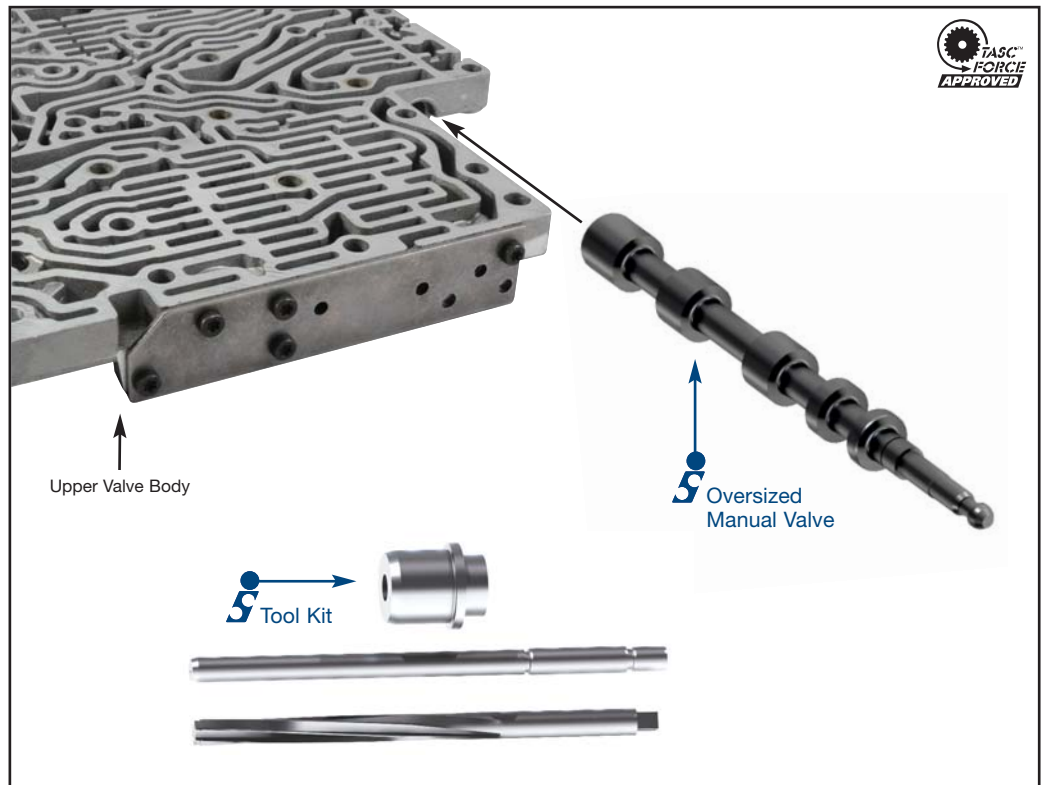
68942-16

1 Oversized Manual Valve



F-68942-TL16

1 Reamer
1 Guide Pin
1 Reamer Jig



Notes

Sonnax **VB-FIX** and Tool Kit **F-68942-TL16** are required to properly oversize the bore prior to installing the new manual valve.

Dissassembly Steps

Remove the OE plastic linkage connector from the end of the manual valve. Use a small flat-blade screwdriver to carefully pry up the retaining arm of the connector. Then pull the manual valve out of the connector. Discard the OE manual valve and save the OE plastic connector for reuse with the oversize Sonnax manual valve.



Important Notes:

1. Clean the bore thoroughly in a solvent tank.
2. 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. Mobilmet S-122) during the reaming process.
3. The reamers should be turned using a low rpm, high torque air drill regulated to a maximum of 200 rpm.
4. Examine the bore after cleaning for surface finish, debris, and burrs. Flashing and burrs on the exit side of lands and bores must be carefully removed. A small piece of Scotchbrite™ material attached to a wire and powered with a drill motor is ideal for the task.

Cautions and Suggestions

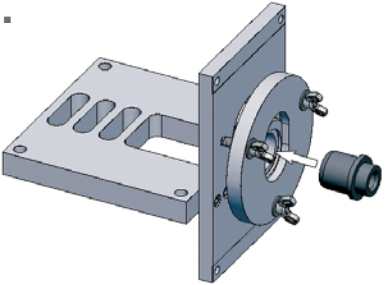
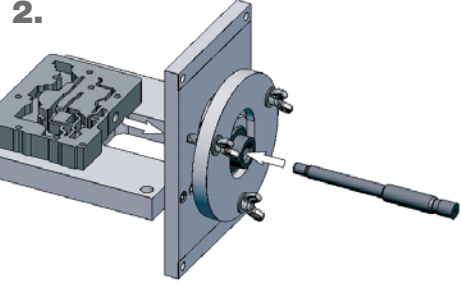
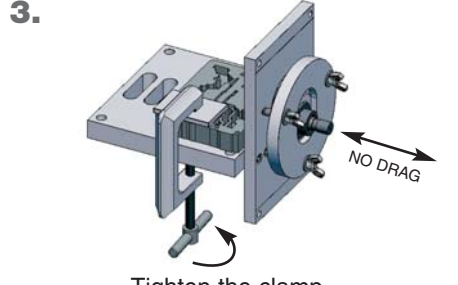
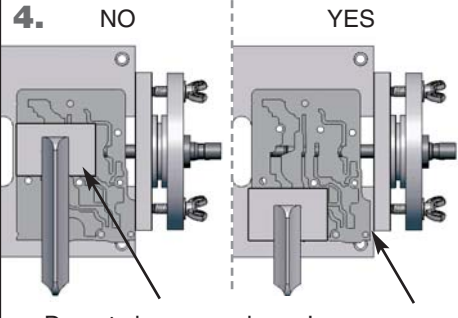
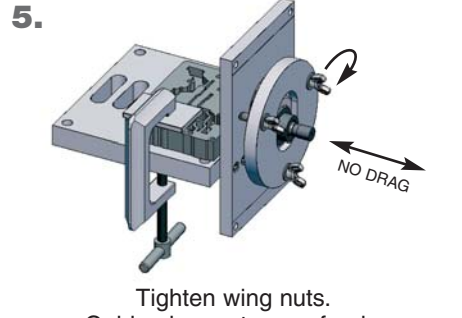
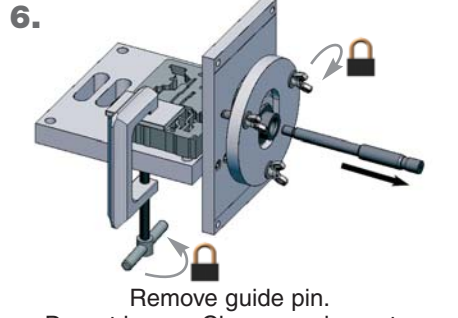
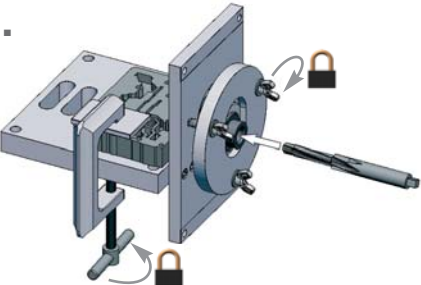
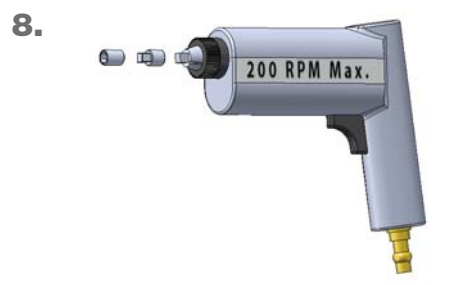
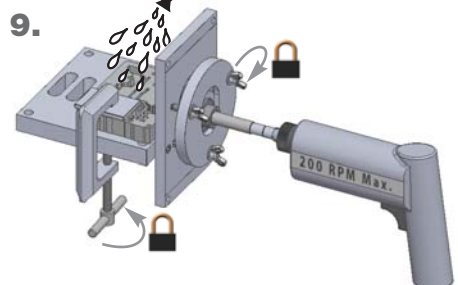
1. Turning the reamer backward will dull it prematurely.
2. Pushing on the reamer will result in poor surface finish and inadequate and sporadic material removal.
3. Never use a crescent wrench, ratchet or pliers to turn the reamer.
4. A dull reamer will cut a smaller hole. Reamers can be sharpened,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

MERCEDES 722.6

PART NUMBER 68942-16, F-68942-TL16

**Oversized
Manual Valve**

Reaming Instructions

<p>1.</p>  <p>Insert the reamer jig.</p>	<p>2.</p>  <p>Align the guide pin and valve body.</p>	<p>3.</p>  <p>Tighten the clamp. Guide pin must move freely.</p>
<p>4.</p>  <p>Do not clamp over bore. Leave gap.</p>	<p>5.</p>  <p>Tighten wing nuts. Guide pin must move freely.</p>	<p>6.</p>  <p>Remove guide pin. Do not loosen Clamp or wing nuts.</p>
<p>7.</p>  <p>Insert the Reamer.</p>	<p>8.</p>  <p>Use a loose fitting reamer socket, a wobble adapter and a regulated air drill.</p>	<p>9.</p>  <p>Use a continuous supply of cutting fluid and little or no inward force.</p>

Installation Steps

1. Install the OE linkage connector onto the SONNAX oversized manual valve.
2. Vac test prior to final assembly with transmission case.
3. Install the valve body onto the transmission case and assemble the selector linkage connection per accepted procedures.

Final Verification Steps

Vacuum testing at indicated VB cavities after reaming must yield results at or above 14 in-Hg.

