Instruction Data Sheet

U140E/F, U240E, U241E

PART NUMBERS **57917E-08K, 57917E-TL8**

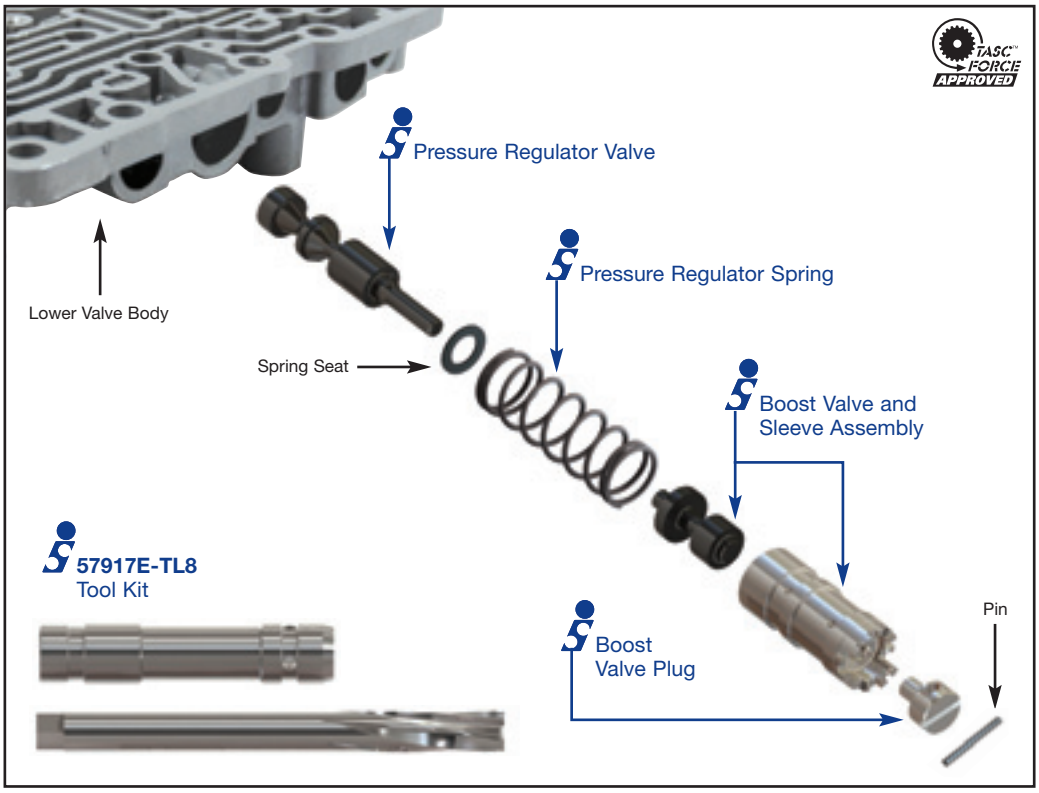
Oversized Pressure Regulator and Boost Valve Kit

57917E-08K

1 Pressure Regulator Valve
1 Pressure Regulator Spring
1 Boost Valve Assembly
1 Boost Valve Plug

57917E-TL8

1 Reamer
1 Reamer Jig



Wear Identification

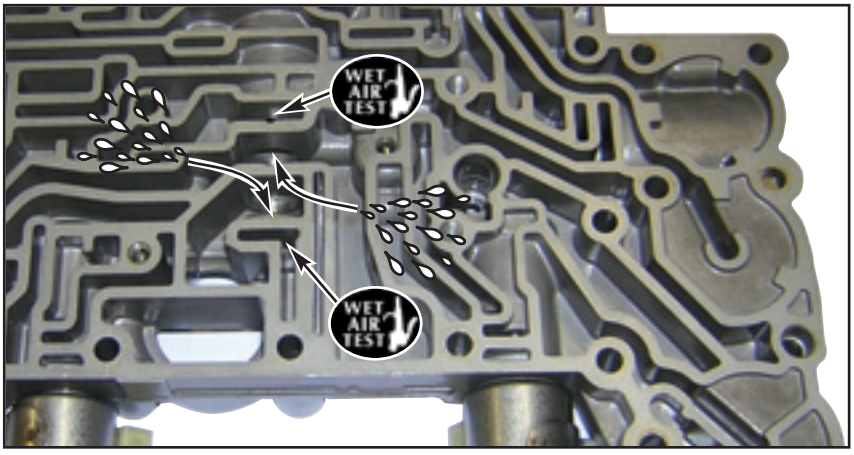
Visible wear is often seen as a shiny patch on the inside diameter of the sleeve or valve bore.

- **Pressure regulator valve wear test:** Place a small amount of ATF into the balance line circuit. Follow with low air pressure while holding the valve inboard. There should be little or no leakage of air or oil past the valve spool and out the regulated line port.

- **Pressure regulator boost valve wear test:** Place a small amount of ATF into the EPC port. Follow with low air pressure. There should be little or no leakage of air/oil past the valve spools and out the reverse port.

Dissasembly Steps

Note: This assembly is adjustable, and set for the particular application at the factory. Make note of which end step of the sleeve the retainer resides on prior to removing from the valve body.



Reaming Instructions

Prep and Set-up

1. Remove all components from the bore.
2. Clean the bore thoroughly in a solvent tank.
3. Securely clamp the housing to the bench, making sure not to clamp directly over the bore to be reamed.
4. Insert the reamer jig into the bore.
5. Soak the bore and reamer with cutting fluid (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.
6. Gently insert the reamer through the jig and into the bore until the cutting tip contacts the first bore to be reamed.
7. Select the correct sized socket to fit the square shank of the reamer, and attach it to a wobble/swivel socket drive..

Reaming

1. The reamer should be turned either by hand using a speed handle or by a low rpm, high torque air drill regulated to a maximum of 200 rpm.
2. The reaming action should be clockwise in a smooth and continuous motion at 60-200 rpm. The reamer should actually pull itself through the bore, so little or no forward force should be applied.
3. Continue reaming until the reamer stop is reached.

Finish and Clean-up

1. Using low air pressure, blow the chips free before removing the reamer.
2. To remove the reamer, turn clockwise while slowly pulling outward on the reamer.
3. Remove any remaining debris from the bore with low air pressure and clean in a solvent tank.
4. Examine the bore after cleaning for surface finish, debris, and burrs. Flashing and burrs on the exit side of casting bores can be carefully removed with a small piece of Scotchbrite™ on the end of a long wire.
5. Clean the reamer after each use and store in its protective tube.

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 resharpening or replacing averages 50-70 bores.

Installation/Assembly Steps

Take note of the position of the adjustable step on the original boost sleeve. When installing the new sleeve, ensure that the retaining pin goes through the new sleeve in the same position as the original adjustable step in the OEM sleeve. Discard the OEM pressure regulator valve, spring and boost valve and boost valve sleeve. Re-use the OEM washer with the replacement valve and spring.

1. Install the new oversized pressure regulator valve.
2. Install the original OEM spring seat.
3. Install the new pressure regulator spring.
4. Install the boost valve assembly.
5. Install the new boost valve plug and place the retaining pin into the same notch step as noted prior to disassembly.