

## TC Lockup Clutch Regulator Valve Kit

### 68942-10K

1 Valve  
1 Spring

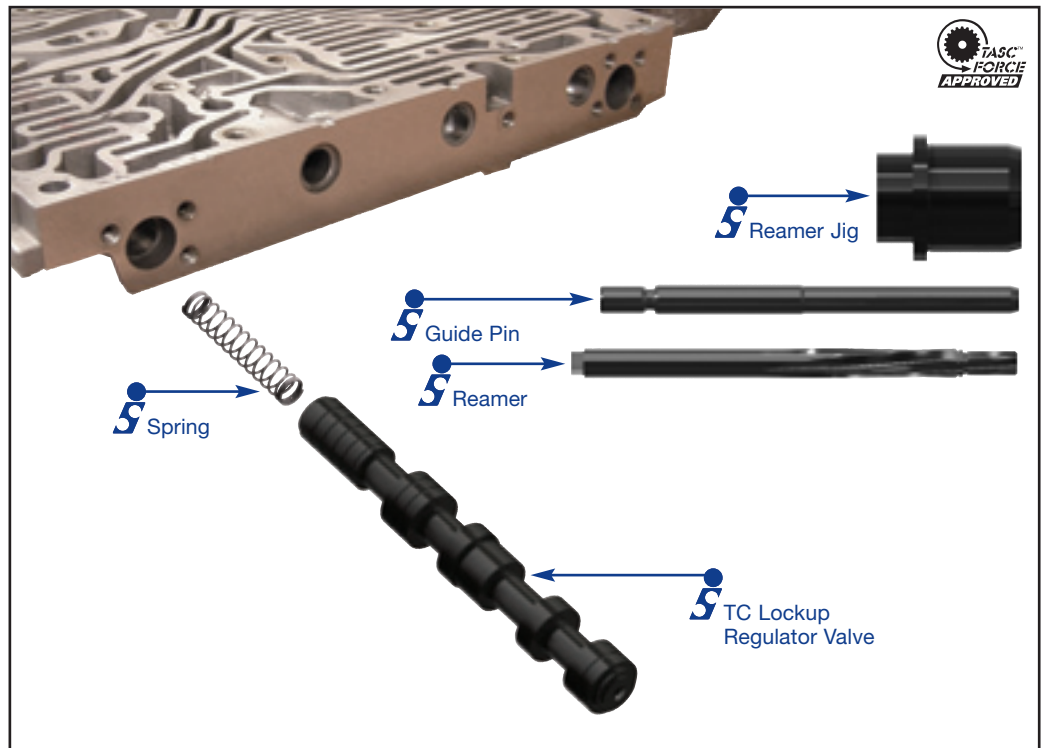


### F-68942-TL10

1 Reamer  
1 Reamer Jig  
1 Guide Pin



**Note:** This sleeve will fit Chrysler 300 & 300C, '05-'07; Chrysler Aspen, '07; Chrysler Crossfire, '04-'07; Dodge Charger SRT, '06-'07; Dodge Magnum R/T, SXT, SRT-8, '05-'07; Dodge Nitro, '07; Dodge Sprinter Van, Diesel 2500-3500, '04-'07; Jeep Commander, '06-'07; and Jeep Grand Cherokee, Laredo and SRT-8, '05-'07.



### Disassembly:

Disassemble the valve body and discard the OEM TC lockup clutch regulator valve and spring.

### Reaming Instructions:

1. Clean bore thoroughly in a solvent tank.
2. Align valve body on fixture according to **VB-FIX** instructions using jig **F-68942-RJ10** and guide pin **F-68942-GP10**, then ream using **F-68942-RM10**.
3. 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.
4. 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.
5. Continue reaming until the reamer stop is reached. Spin the reamer 5-10 more times after bore bottoming to allow for excess material removal and better surface finish.
6. Using low air pressure, blow the chips free before removing the reamer.
7. To remove the reamer, turn clockwise while slowly pulling outward on the reamer.

### Cautions:

1. Never turn the reamer backward
2. Pushing on the reamer will result in poor surface finish, inadequate and sporadic material removal, and material being left un-reamed as the reamer exists the bore.
3. Using low pressure air blow any chips from the reamer after each use.
4. Never use a crescent wrench, t-handle or ratchet to turn the reamer.

### Installation:

1. Thoroughly clean the valve body.
2. Install the Sonnax spring into the pocket of the Sonnax TC lockup clutch regulator valve.
3. Insert assembled valve and spring into valve body bore as shown on above.
4. Install the OEM valve retaining plate.