

## Oversized 3-4 Accumulator Valve Kits

### 84754-55K 84754-58K

- Oversized Valve
- Spring

### Tool Kit

#### F-84754-TL55

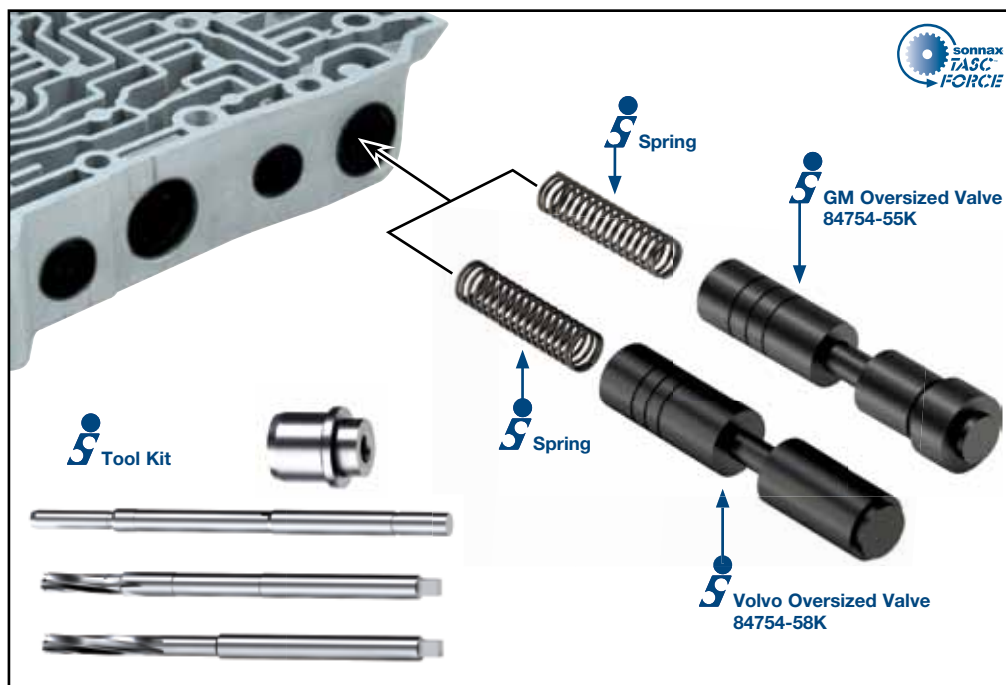
- Reamers (2)
- Guide Pin
- Reamer Jig

**NOTE:** Sonnax "F-Tool" kits designed to service a specific bore require the VB-FIX, a self-aligning valve body reaming fixture. More information and instructions are available at [www.sonnax.com](http://www.sonnax.com).

Also Available

### 2-3 Accumulator Valve Kit

84754-53K



### 1. Disassembly

- Remove OEM 2-3 accumulator sleeve/valve assembly. Examine for wear. Retain OEM assembly or replace in Step 4 with Sonnax 2-3 accumulator valve kit **84754-53K**.
- Remove and discard OEM 3-4 valve and spring.

### 2. Bore Preparation

- Clean the bore thoroughly in a solvent tank.
- 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. Mobilment S-122) during the reaming process.
- The reamers should be turned using a low RPM, high-torque air drill regulated to a maximum of 200 RPM.
- Examine the bore after cleaning for surface finish, debris and burrs. Flashing and burrs on the exit side of land and bores must be carefully removed. A small piece of Scotch-Brite™ material attached to a wire and powered with a drill motor is ideal for the task. Scotch-Brite™ is a very abrasive material and all residual must be cleaned to insure particles do not migrate or remain imbedded into the surface. Post cleaning involves several progressive steps with solvent on a lint-free rag.

#### Cautions and Suggestions:

- Turning the reamer backward will dull it prematurely.
- Pushing on the reamer will result in poor surface finish and inadequate and sporadic material removal.
- Never use a crescent wrench, ratchet or pliers to turn the reamer.
- 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 Sonnax reamer before resharpening or replacing averages 50-70 bores.

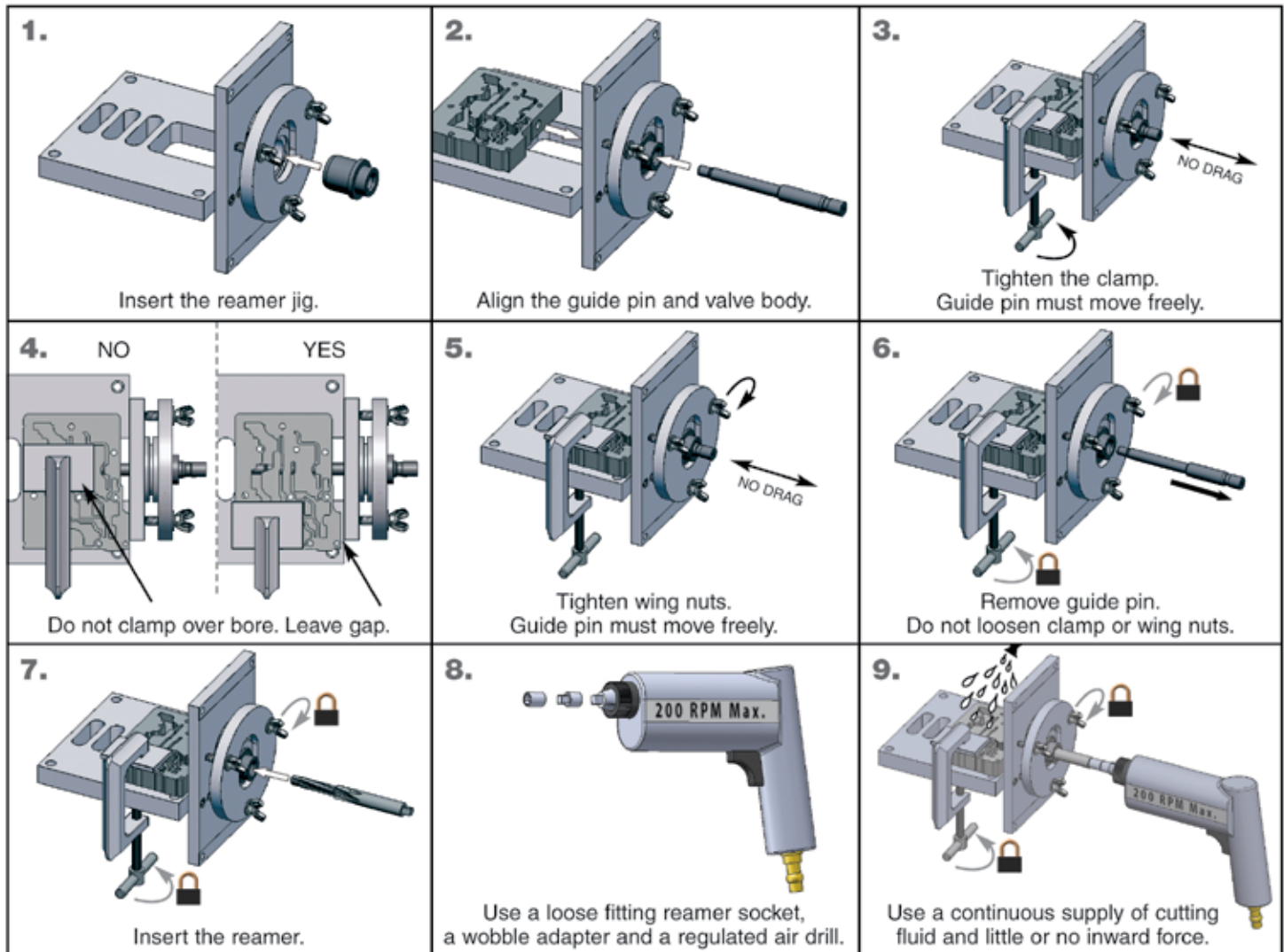
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## Oversized 3-4 Accumulator Valve Kits

PART NUMBERS 84754-55K, 84754-58K, F-84754-TL55

### 3. Bore Reaming

If using 84754-55K kit for GM models, use F-84754-RM55 reamer. If using 84754-58K kit for Volvo models, use F-84754-RM58 reamer. Both of these reamers are labeled and found in the F-84754-TL55 tool kit.



### 4. Installation & Assembly

- Place replacement spring into spring pocket of oversized Sonnax accumulator valve.
- Install spring and valve into reamed bore, spring end first.
- Install OEM 2-3 accumulator sleeve/valve assembly or Sonnax 2-3 accumulator valve kit 84754-53K and secure with OEM retainer.

### 5. Final Testing

A vacuum test at any port should hold 18" of vacuum or more.

