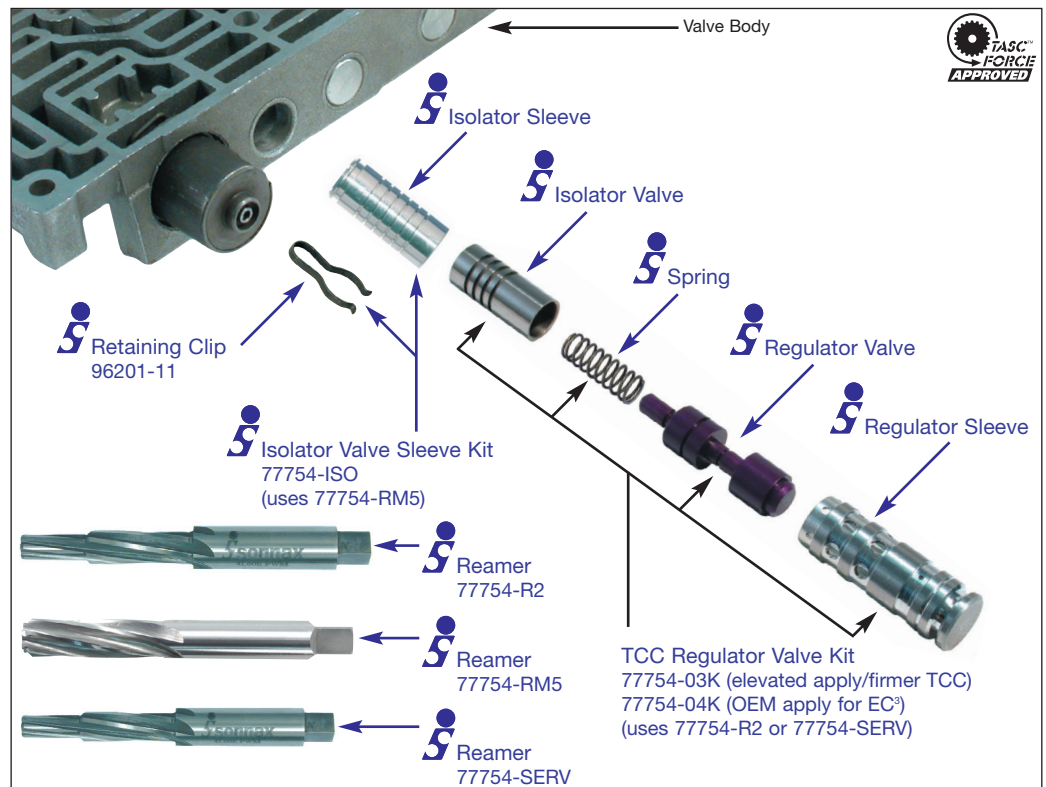


## Reamer for 77754-ISO

### 77754-RM5

Required for 77754-ISO. Regulator bore must be reamed first.

1 Reamer



### Part and Tool Use Options

#### Option 1

If the valve body has NOT been serviced (GM Remanufactured) and does NOT have a worn-out isolator bore:

Use: 77754-R2 Reamer

Install: 77754-03K or 77754-04K

#### Option 2

If the valve body has NOT been serviced (GM Remanufactured) but DOES have a worn-out isolator bore:

Use: 77754-R2 Reamer first (to cut regulator sleeve pocket)

Then: 77754-RM5 Reamer next (to cut ISO sleeve pocket)

Install: 77754-ISO and either 77754-03K or 77754-04K

#### Option 3

If the valve body HAS been serviced (GM Remanufactured):

Use: 77754-SERV Reamer first (to cut regulator sleeve pocket)

Then: 77754-RM5 Reamer next (to cut ISO sleeve pocket)

Install: 77754-ISO and either 77754-03K or 77754-04K

## Reaming Instructions

- Use **77754-R2** for stock OEM regulator bore.
  - Use **77754-SERV** for GM remanufactured regulator bore.
  - Use **77754-RM5** for isolator bore after regulator bore has been reamed.
1. Remove all components from the bore and clean thoroughly in a solvent tank.
  2. Securely clamp the valve body horizontally to the bench, making sure not to clamp directly over the bore to be reamed.
  3. Soak the bore and reamer with cutting fluid (Tap Magic™, etc.).
  4. Gently insert the reamer into the bore until the cutting tip contacts the first bore to be reamed.
  5. Use a speed handle to ream the bore. The reaming action should be clockwise in a smooth and continuous motion, at 60-120 rpm.
  6. On the **77754-R2** and **77754-SERV** reamers, continue reaming until the stepped reamer shank bottoms on the face of the valve body bore. Approximate reaming time is 5 minutes.
  7. On the **77754-RM5** reamer, continue reaming until the reamer bottoms in the bore. Approximate reaming time is 5 minutes.
  8. Using low air pressure, blow the chips free prior to removing the reamer.
  9. To remove the reamer, turn clockwise while slowly pulling outward on the reamer.
  10. Removing any remaining debris from the bore with air pressure and clean in the solvent tank.

## Reaming Cautions:

- Never turn the reamer backwards. This will dull the reamer.
- Pushing on the reamer or using a power tool will result in poor surface finish and inadequate and sporadic material removal.
- Never use a crescent wrench, ratchet or pliers to turn the reamer.
- Clean the reamer after each use and store in its protective tube.
- A dull reamer will cut a smaller hole. Reamers can be sharpened. Actual life of a reamer before resharpening averages 50 to 70 bores, and depends on oil and turning process.