

Oversized Solenoid Switch Valve

92835-21

1 Valve



F-92835-TL

1 Reamer

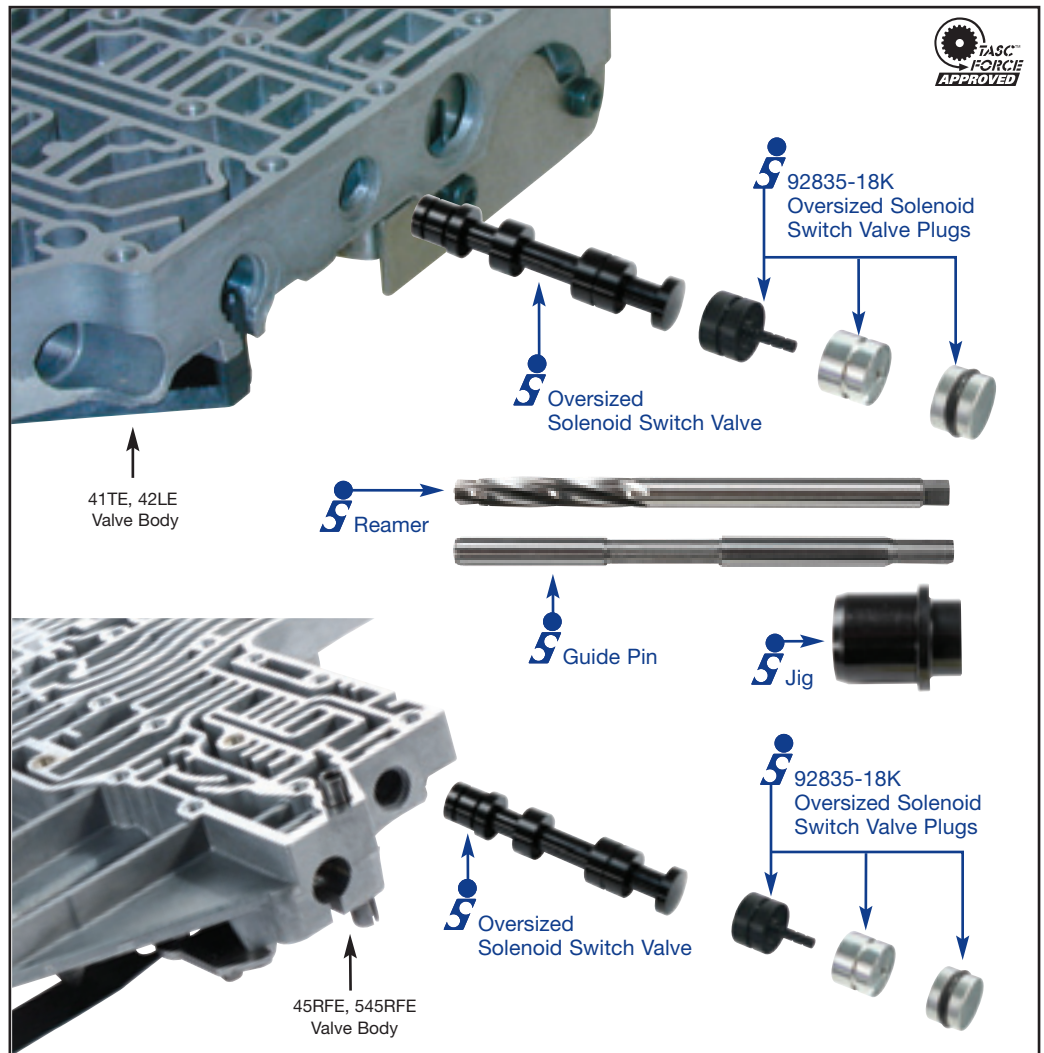
1 Guide Pin

1 Reamer Jig

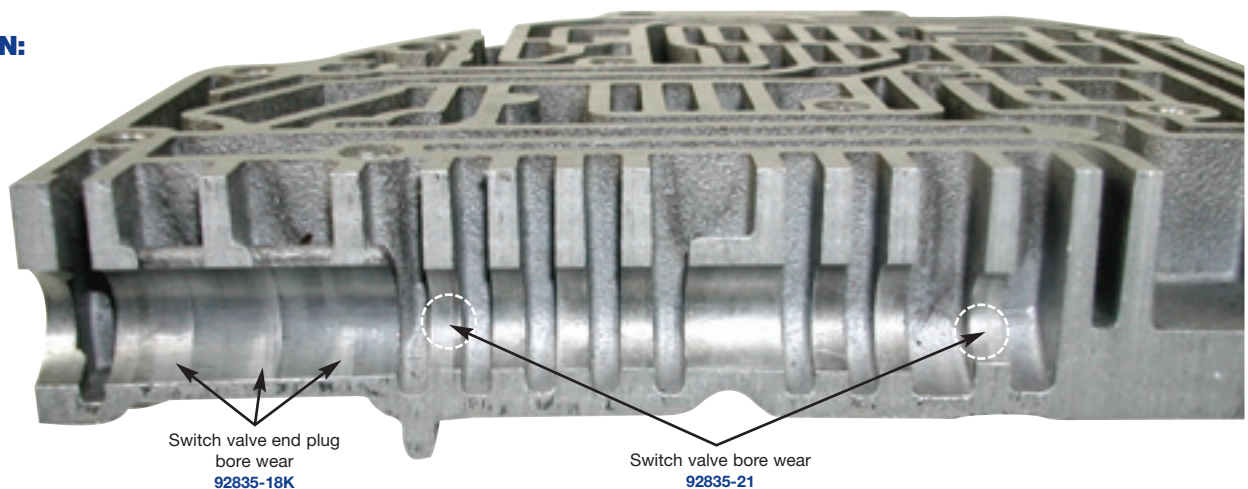


NOTES: To maintain proper hydraulic ratios, it is highly recommended that the Sonnax oversized solenoid switch valve end plugs **92835-18K** be installed along with this oversized switch valve. The bore for the oversized switch valve plugs must be reamed prior to reaming the solenoid switch valve bore.

Due to the nature of the OEM valve body design, the Sonnax Valve Body Reaming Fixture **VB-FIX** is required for use with this tool kit.



INSPECTION:



Visually inspect the valve bore for wear.



41TE, 42LE, 42RLE, 45RFE, 545RFE

Oversized Solenoid Switch Valve

PART NUMBERS 92835-21, F-92835-TL

DISASSEMBLY:

NOTE: To maintain proper hydraulic ratios, it is highly recommended that the Sonnax oversized switch valve plugs **92835-18K** be installed along with this oversized switch valve. **The bore for the oversized switch valve plugs must be reamed prior to reaming for installation of the oversized switch valve.**

1. Remove the three switch valve plugs and switch valve from bore.
2. Inspect the switch valve plug bore for signs of wear or ridges.
3. Replace worn plugs with Sonnax kit **92835-02K** (standard size switch valve plugs), or use kit **92835-18K** (oversized switch valve plugs) for a worn bore after enlarging with reamer **92835-RM**.
4. Discard the OEM switch valve.

REAMING INSTRUCTIONS:

Note: In certain applications there is no way to pilot a reamer to repair a worn casting bore. The self-aligning fixture **VB-FIX**, with specially designed tool kits, allows these bores to be repaired. The fixture provides an external rigid pilot bore for a reamer or drill guide. The self-aligning feature allows the fixture to be used on multiple castings and bores.

1. Place guide pin in switch valve bore. Make sure pin slides in and out freely. If pin does not slide smoothly, clean guide pin and casting bore, lubricate pin with cutting fluid and recheck the fit.
2. Put casting on base of **VB-FIX** reaming fixture. Do not clamp in place at this time.
3. Install the reamer jig (**F-92835-RJ**) into inner race of reaming fixture.
4. Install guide pin into reamer jig.
5. Align casting so guide pin fits into the bore, leaving wing nuts on fixture loose.
6. Using a "C" clamp, clamp casting securely to fixture base. It is recommended to use only one clamp, as two may distort the casting.
7. Place casting bore opening close to the reamer jig.
8. Check fit of guide pin. The pin should slide smoothly in the bore, with no binding.
9. Lightly tighten all three wing-nuts, recheck guide pin fit, then tighten wing-nuts securely by hand. Do not use pliers or tools to tighten wing-nuts. Do not overtighten one wing-nut, as this will pull the fixture out of alignment.
10. Recheck to see if guide pin slides smoothly in bore. If guide pin does not slide smoothly, loosen the wing-nuts and realign.
11. Remove guide pin and install the reamer (**F-92835-RM**).
12. The pilot (middle diameter) should fit into the first bore to be cut. Ream casting using standard procedure.

INSTALLATION:

1. Oversize the bore per the reaming instructions.
2. Lubricate the oversized valve with ATF and install into the reamed bore, small spool diameter first.
3. Install proper solenoid switch valve plugs.
4. Using a small pick on the end face of the plugs and switch valve, gently stroke the valve to ensure there is no sticking.

