

## TCC Regulator Valve Tool Kit & Isolator Sleeve Tool Kit

### TCC Regulator Valve Tool Kit

#### F-77754-TL4

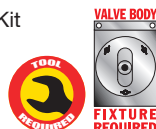
- 1 Roughing Reamer
- 1 Finishing Reamer
- 2 Reamer Jigs
- 1 Guide Pin
- 1 Stop Pin



### Isolator Sleeve Tool Kit

#### F-77754-SERV

- 1 Roughing Reamer
- 1 Guide Pin



**Note:** Use F-77754-SERV with F-77754-TL4 on previously remanufactured valve bodies.

Products above used for installation of the following kits:

**77754-03K** Elevated apply/firmer TCC

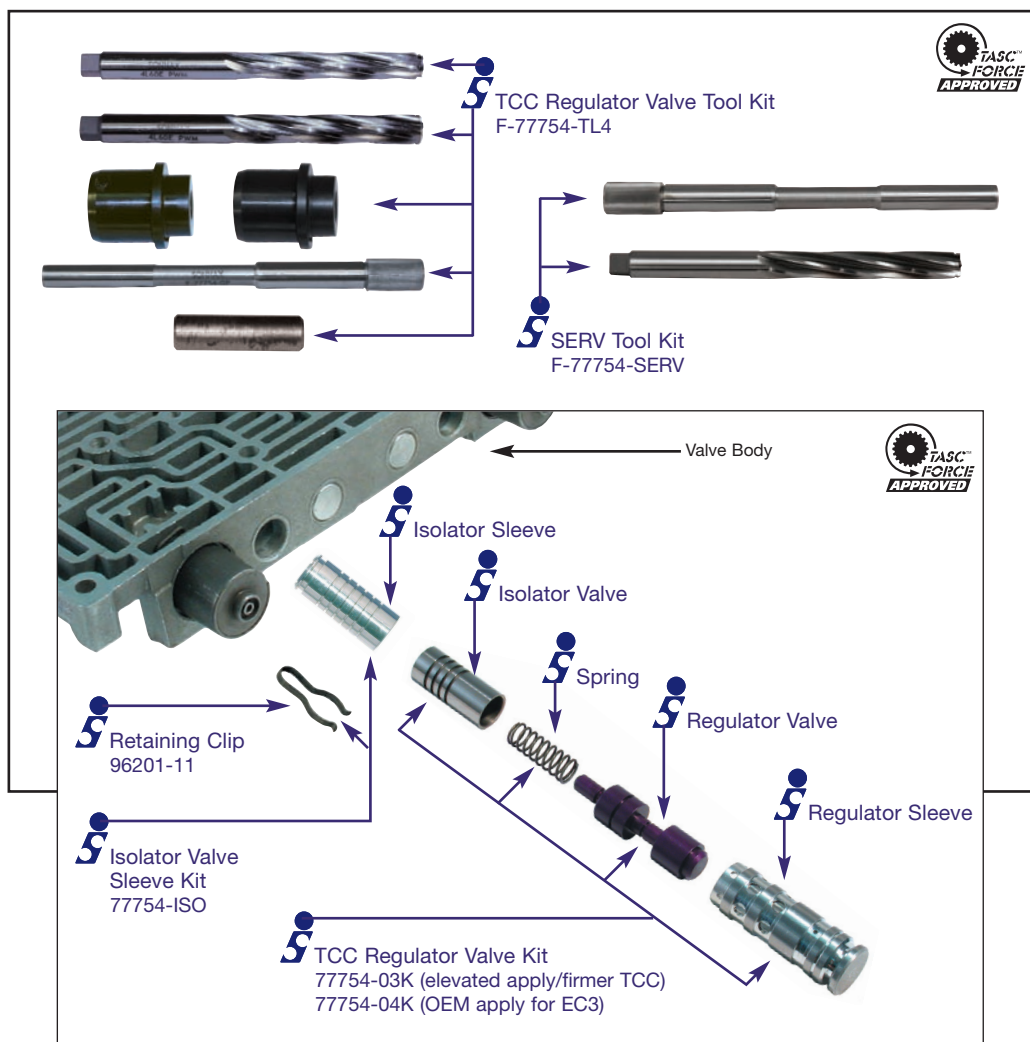
**77754-04K** OEM apply for EC3

Each kit includes the following

- 1 Isolator Valve
- 1 Sleeve
- 1 Regulator Valve
- 1 Spring

#### 77754-ISO

- 1 Isolator Valve Sleeve
- 1 Retaining Clip



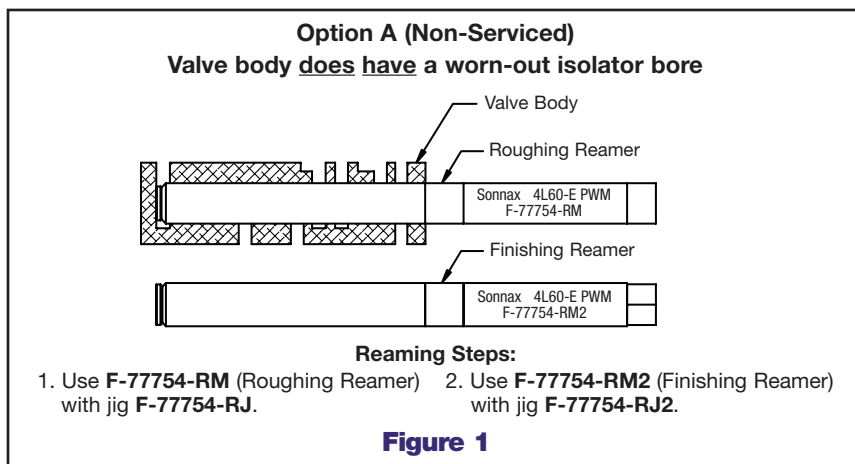
### Reaming Instructions

#### Prep and Set-up

##### Option A:

TCC regulator bore & isolator bore in non-remanufactured valve bodies

1. Clean bore thoroughly in a solvent tank.
2. Align the valve body on the fixture according to the VB-FIX instructions. Use jig F-77754-RJ and guide pin F-77754-GP, then ream using roughing reamer F-77754-RM. With low air pressure, blow the chips free before removing the reamer. Do not loosen any hardware.
3. Switch to jig F-77754-RJ2 and the finishing reamer F-77754-RM2. Ream until the reamer stops against the valve body casting (see Figure 1).



## Option B:

**TCC regulator bore only in non-remanufactured valve bodies**

1. Follow the same steps as in Option A but use stop pin **F-77754-01** to prevent reamers from entering the isolator bore (see Figure 2).

## Option C:

**TCC regulator bore & isolator bore in GM-serviced valve bodies**

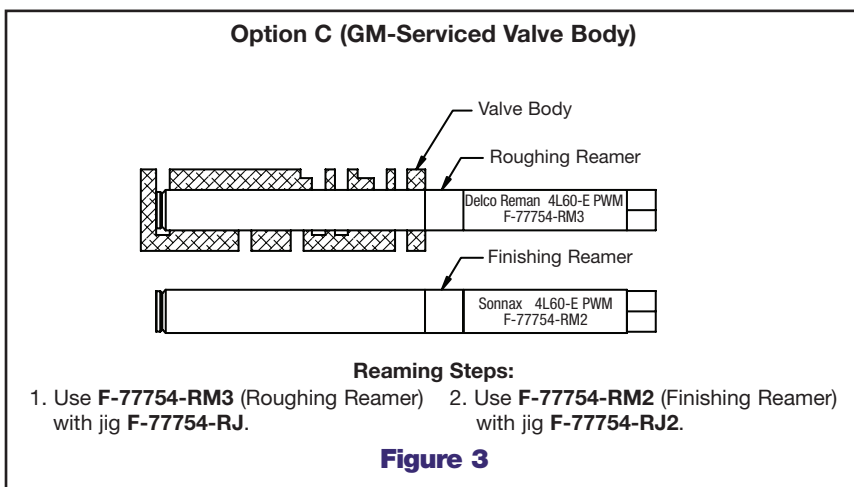
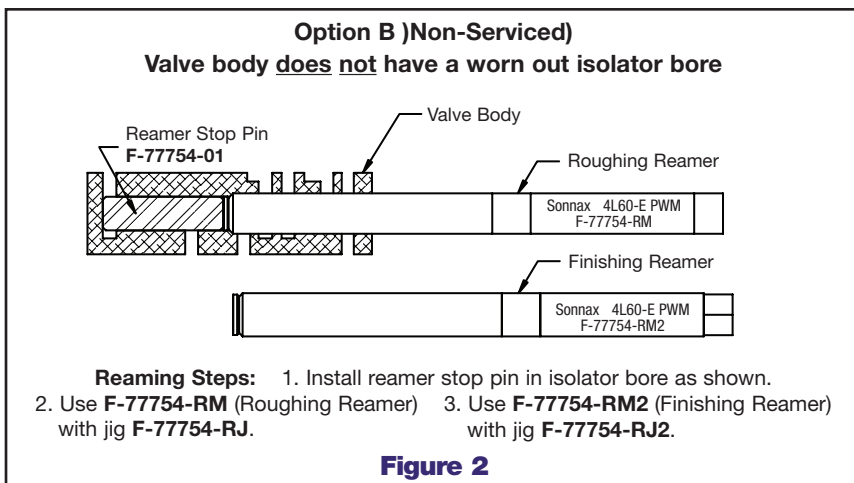
1. Clean bore thoroughly in a solvent tank.
2. Align the valve body on the fixture according to **VB-FIX** instructions. Use jig **F-77754-RJ** and guide pin **F-77754-GP2**, then ream using roughing reamer **F-77754-RM3**. With low air pressure, blow the chips free before removing the reamer. Do not loosen any hardware.
3. Switch to jig **F-77754-RJ2** and finishing reamer **F-77754-RM2**. Ream until the reamer stops against the valve body casting. Do not unclamp valve body from the fixture until you have finished with the finishing reamer **F-77754-RM2** (see Figure 3).

## 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 averages 50-70 bores.

## Installation

Follow the installation steps included with the **77754-03K**, **-04K** or **-ISO** kits.