

## Oversized Modulator Valve Kit

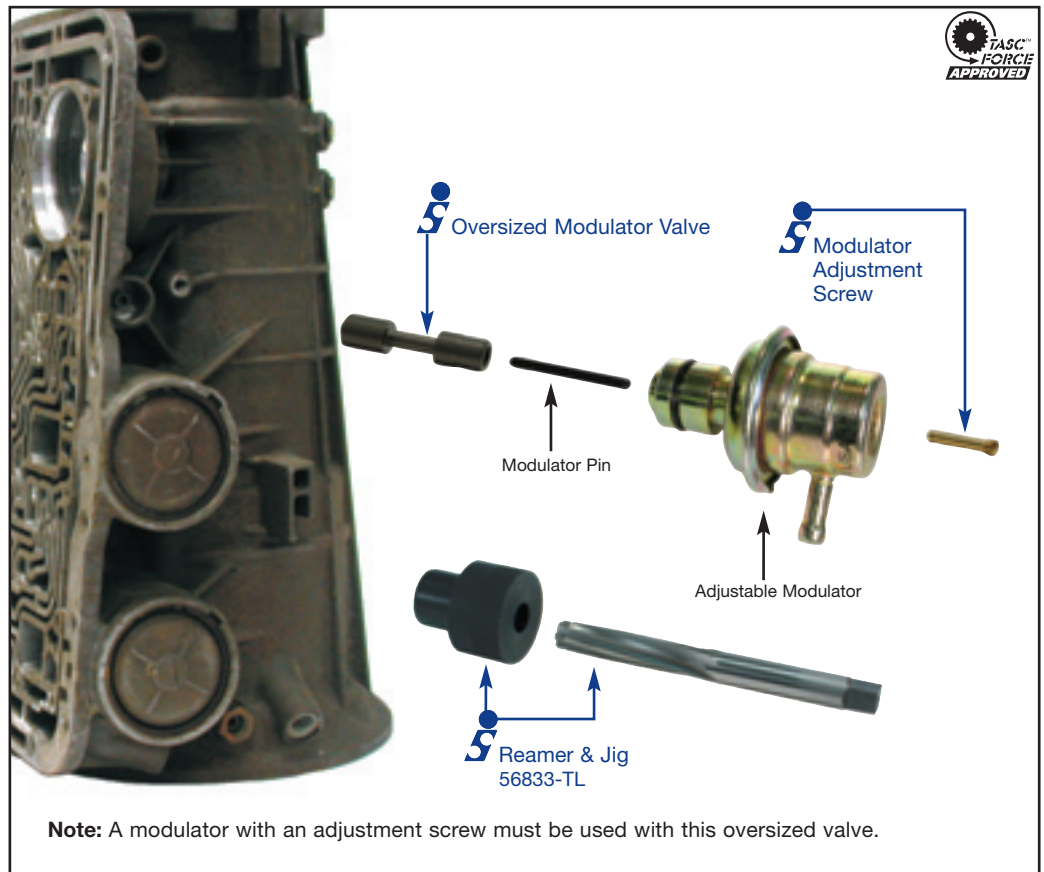
### 56833-01K

- 1 Oversized Modulator Valve
- 1 Modulator Adjustment Screw



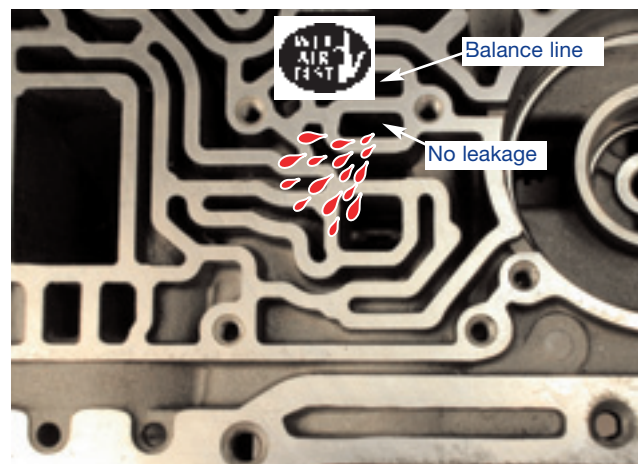
### 56833-TL

- 1 Reamer
- 1 Reamer Jig



### Wear Test:

To Wet Air Test the bore for leakage, place a small amount of oil into the balance line circuit. Follow with low air pressure. There should be little or no air/oil leakage past the valve through the line circuit.



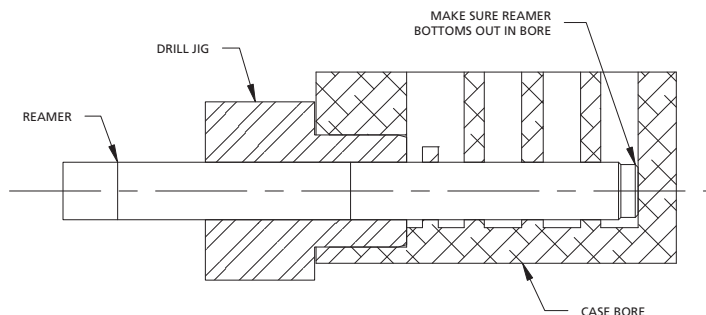
## Reaming Instructions:

1. Remove modulator and valve. Clean bore thoroughly.
2. Clamp/position the case so it is secure and there is access to the modulator bore.
3. Insert the reamer jig into bore. Due to some casting inconsistencies, some slight buffing/honing of the case bore may be necessary. Remove just enough material to fit the reamer jig.

Slight buffing may be necessary for jig to fit.



4. Fill the bore and soak the reamer flutes with cutting fluid (kerosene, Tap Magic®, etc.).
5. Insert the reamer through the jig and into the bore, just until the reamer guide nub contacts the bore to be cut. Using a SPEED HANDLE, rotate the reamer CLOCKWISE at 1-2 revolutions per second. Continue reaming until the reamer bottoms in the bore. Spin the reamer 5-10 more times.



6. Blow chips free with low air pressure BEFORE removing reamer. Rotate the reamer clockwise while removing it from the bore. Thoroughly clean bore.



7. Lubricate the bore and Sonnax valve with ATF prior to installation. If snug, repeat the reaming process with an air drill at 500 rpm.

## Cautions:

Never turn the reamer backward.

Pushing on the reamer will result in poor surface finish, inadequate and sporadic material removal, and material being left unremoved as the reamer exits a bore.

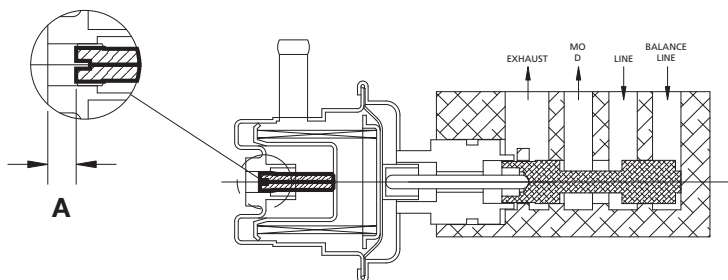
Clean the reamer after each use and store in its protective tube.

Never use a crescent wrench, ratchet or pliers to turn the reamer.

Lubricate the replacement valve prior to installation. Install the valve with the pin pocket facing out of the bore.

## Modulator Adjustment Screw Installation

1. Prior to replacing or reinstalling the modulator, the pre-existing adjustment screw height must be measured. Reference distance "A" in the illustration.
2. Once the height has been noted, the adjustment screw in the modulator should be removed. Measure the length of the original adjustment screw, then add .109 to the measurement, and record this reading.
3. The Sonnax pin needs to be shortened to the length calculated in Step 2. The intent is to have the Sonnax adjusting screw .109" longer than the original.
4. Install the longer Sonnax adjusting screw such that the measured height "A" from Step 1 is re-established.
5. Install the modulator and pin in accordance with manufacturer's specifications.



Sonnax adjustment screw



Original adjustment screw

Also available parts/kits:

- 56001X.....Bell Housing Bushing, Finish-in-Place
- 56250-01K.....Thrust Washer and Sprag End Cap Kit
- 56521-K.....Rear Band Anchor Pin Kit
- 56532-01K.....Reverse Servo Sleeve Kit
- 56600.....Rear Sprag Inner Race (2.50" Diameter)
- 56600B.....Rear Sprag Inner Race (2.70" Diameter)