ZF5HP19

PART NUMBERS 85755-01-02, F-85755-TL1-TL2

Oversized Pressure Regulator Valves

85755-01 early (E17) valve body

85755-02 later (E18.2) valve body

Each includes the following

1 Oversized Pressure Regulator Valve

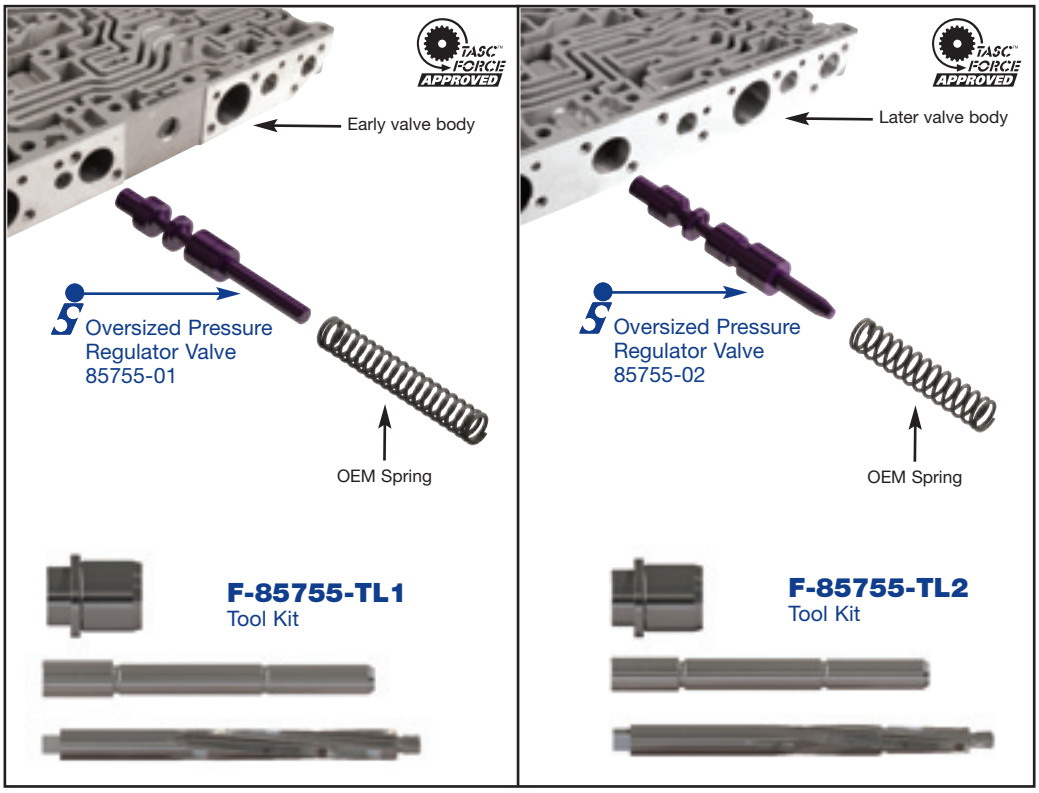
85755-TL1 early (E17) valve body

85755-TL2 later (E18.2) valve body

Each includes the following

1 Reamer
1 Jig
1 Guide Pin

VALVE BODY FIXTURE REQUIRED



Reaming - Prep and Set-up

1. Remove all components from the bore, and save the OEM spring.
2. Clean the bore thoroughly in a solvent tank.
3. Align the valve body on the fixture according to **VB-FIX** instructions. For the E17 valve body with the 4-spool pressure regulator valve, use **F-85755-RJ1** reamer jig and **F-85755-GP1** guide pin from tool kit **F-85755-TL1**. For the E18.2 valve body with the 5-spool pressure regulator valve use **F-85755-RJ2** reamer jig and **F-85755-GP2** guide pin from tool kit **F-85755-TL2**.

Note: Once alignment is complete, do not loosen wing nuts or unclamp valve body from fixture until entire reaming process is completed.

4. Soak the bore and reamer with cutting fluid (Mobilmet S-122, Lubegard Bio-Tap, Tap Magic™, etc). For best results, provide a continuous flow of water-soluble cutting fluid (i.e. Mobilmet S-122) during the reaming process.
5. Gently insert the reamer through the jig and into the bore until the cutting tip contacts the first bore to be reamed. For the E17 valve body with the 4-spool valve use **F-85755-RM1** reamer. For the E18.2 valve body with the 5-spool valve, use **F-85755-RM2** reamer.
6. Select the correct sized socket to fit the square shank of the reamer, and attach it to a wobble/swivel socket drive.

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. Continue reaming until the reamer stop is reached.

Finish and Clean-up

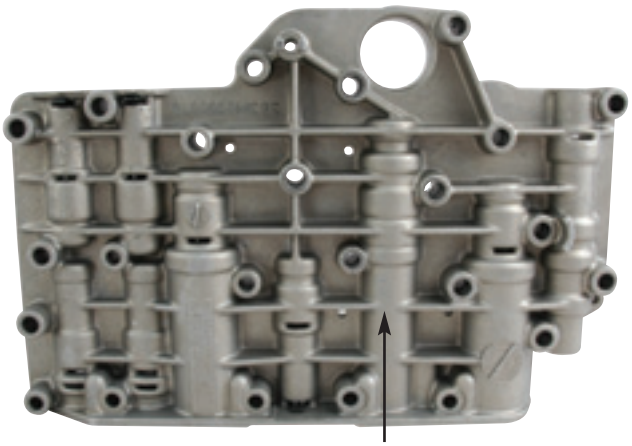
1. Using low air pressure, blow the chips free before removing the reamer.
2. To remove the reamer, turn clockwise while slowly pulling outward on the reamer.
3. Remove any remaining debris from the bore with low air pressure and clean in a solvent tank.
4. Examine the bore after cleaning for surface 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

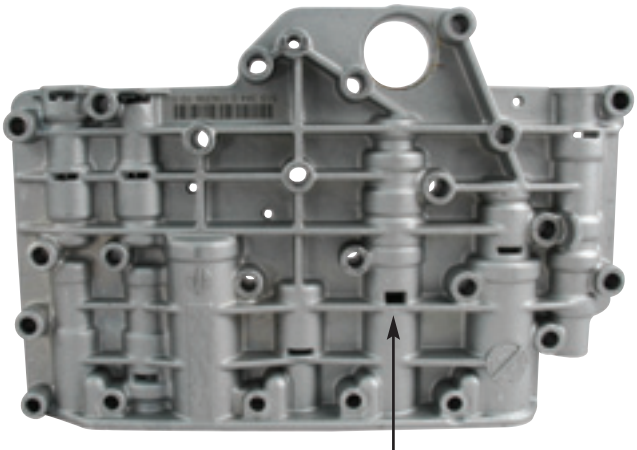
1. Turning the reamer backward will dull it prematurely.
2. Pushing on the reamer will result in poor surface finish and inadequate and sporadic material removal.
3. Never use a crescent wrench, ratchet or pliers to turn the reamer.
4. A dull reamer will cut a smaller hole. Reamers can be sharpened, but should only be done by a professional tool sharpener. Actual life of a reamer before resharpening or replacing averages 50-70 bores.

INSTALLATION

1. Be certain all debris has been removed from the valve bore and valve body.
2 Install the new Sonnax valve and OEM spring.
3. Reattach the valve body casting end plate.



No slot here indicates early valve body



Slot here indicates late valve body