

Oversized Manual Valve

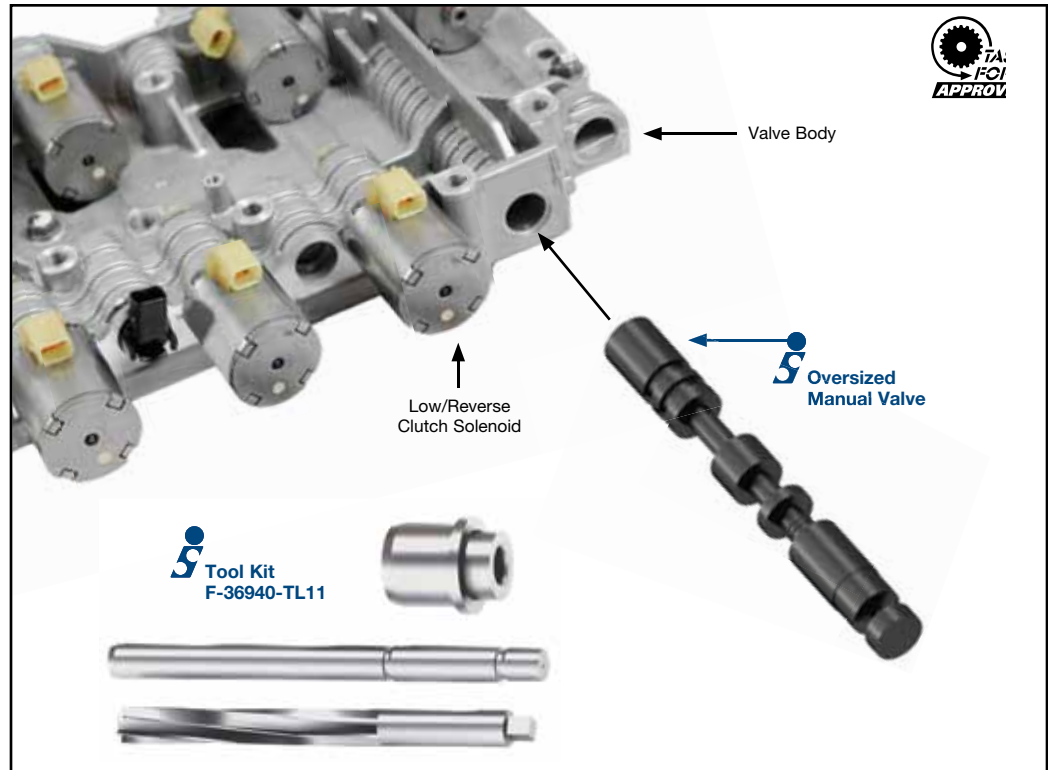
36940-11

1 Oversized Manual Valve



F-36940-TL11

1 Reamer
1 Reamer Jig
1 Guide Pin



Requirements

1. Sonnax **VB-FIX** and tool kit **F-36940-TL11** are required to properly oversize the bore prior to installing the 5R110W Oversized Manual Valve **36940-11**.
2. Removal of the Low/Reverse Clutch Solenoid from the valve body is required to mount the valve body onto the **VB-FIX** base plate.

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.

Reaming Prep & Set-up

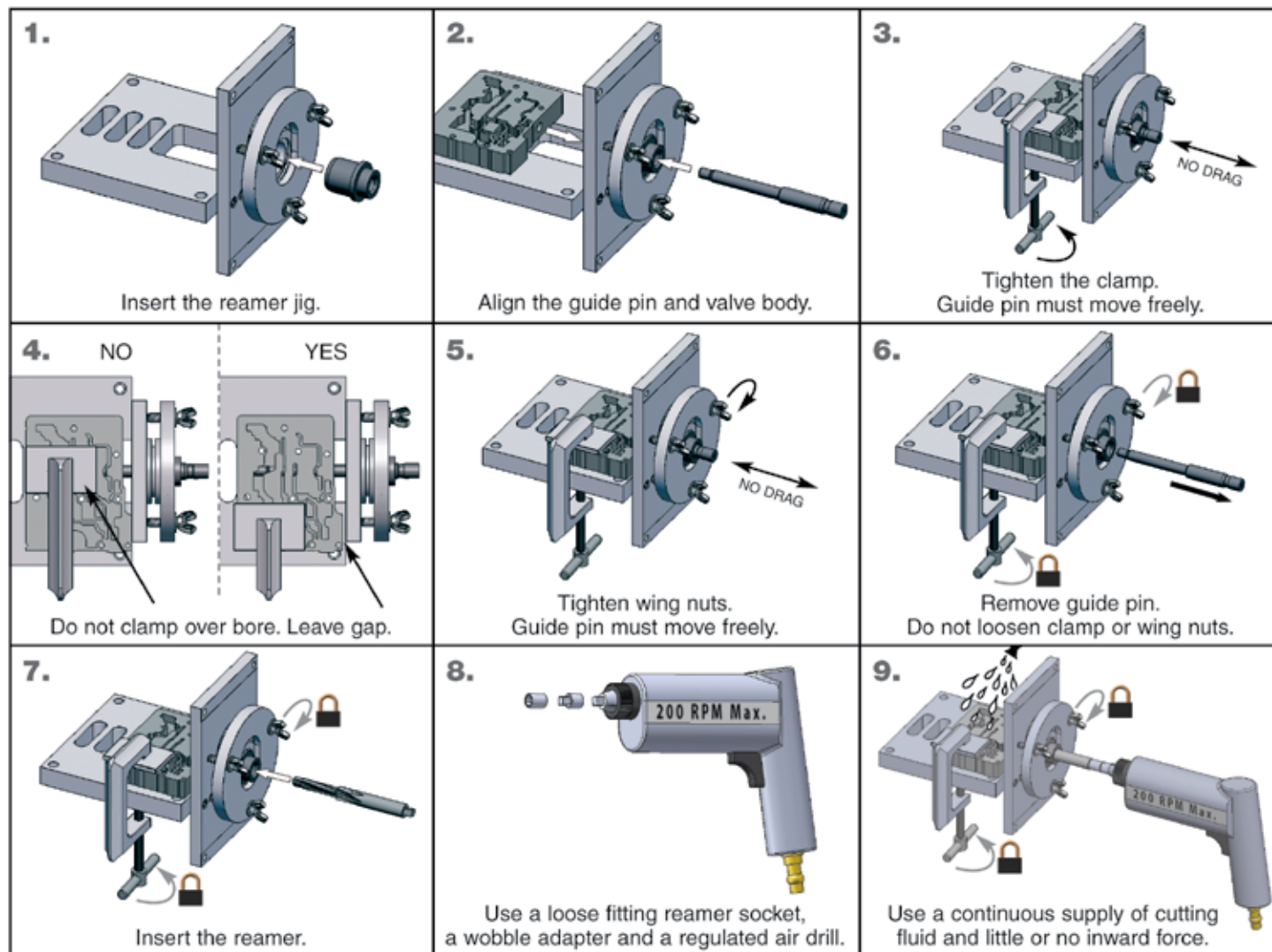
1. Remove all components from the bore.
2. Remove the Low/Reverse Clutch Solenoid from the valve body. It is the solenoid immediately adjacent to the manual valve bore.
3. Clean the bore thoroughly in a solvent tank.

4. Place the valve body on the reaming fixture **VB-FIX**. Align and secure the valve body to the fixture according to the **VB-FIX** instructions, using the guide pin and reamer jig from the **F-36940-TL11** tool kit. Do not loosen wing nuts or clamp, once position has been established until, the entire reaming process is complete.
5. Remove the guide pin.
6. Generously lubricate the bore and reamer with cutting fluid (i.e. 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.
7. Gently insert the reamer through the jig and into the bore until the cutting tip contacts the first bore to be reamed.
8. Select the correct sized socket to fit the square shank of the reamer, and attach it to a wobble/swivel socket drive.

Important Reaming Notes

1. The reamers should be turned using a low rpm, high torque air drill regulated to a maximum of 200 rpm.
2. Examine the bore after cleaning for surface finish, debris, and burrs. Flashing and burrs on the exit side of land and bores must be carefully removed. A small piece of Scotchbrite™ material attached to a wire and powered with a drill motor is ideal for the task.

Reaming Instructions



Installation/Assembly Steps

1. Insert the Oversized Manual Valve into the reamed and deburred bore.
2. Install the valve body onto the transmission case and assemble the selector linkage connection per accepted procedures.