41TE, 42LE, 45RFE

PART NUMBERS **92835-18K, 92835-RM, 92835-02K**

Solenoid Switch Valve Plugs

92835-18K
2 Oversized Replacement Plugs
1 End Plug
1 O-Ring

Note: U.S. Patent No. 7,001,300

92835-RM
1 Reamer
(for use with 92835-18K only)

92835-02K
2 Replacement Plugs

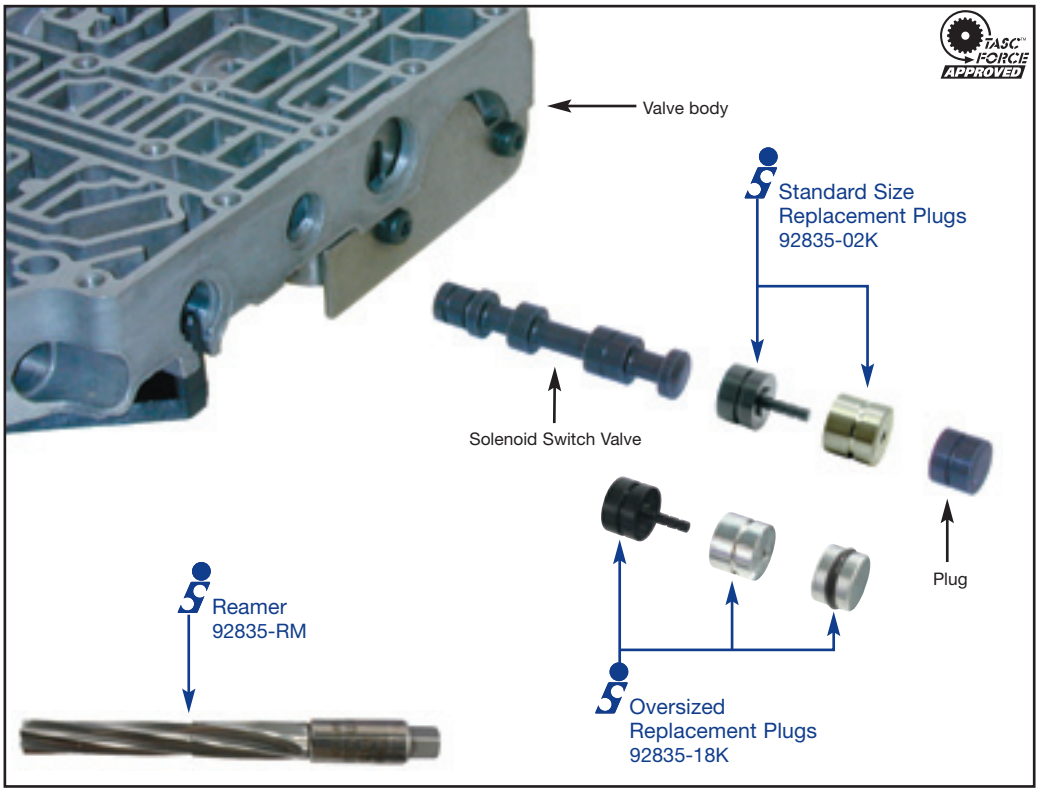
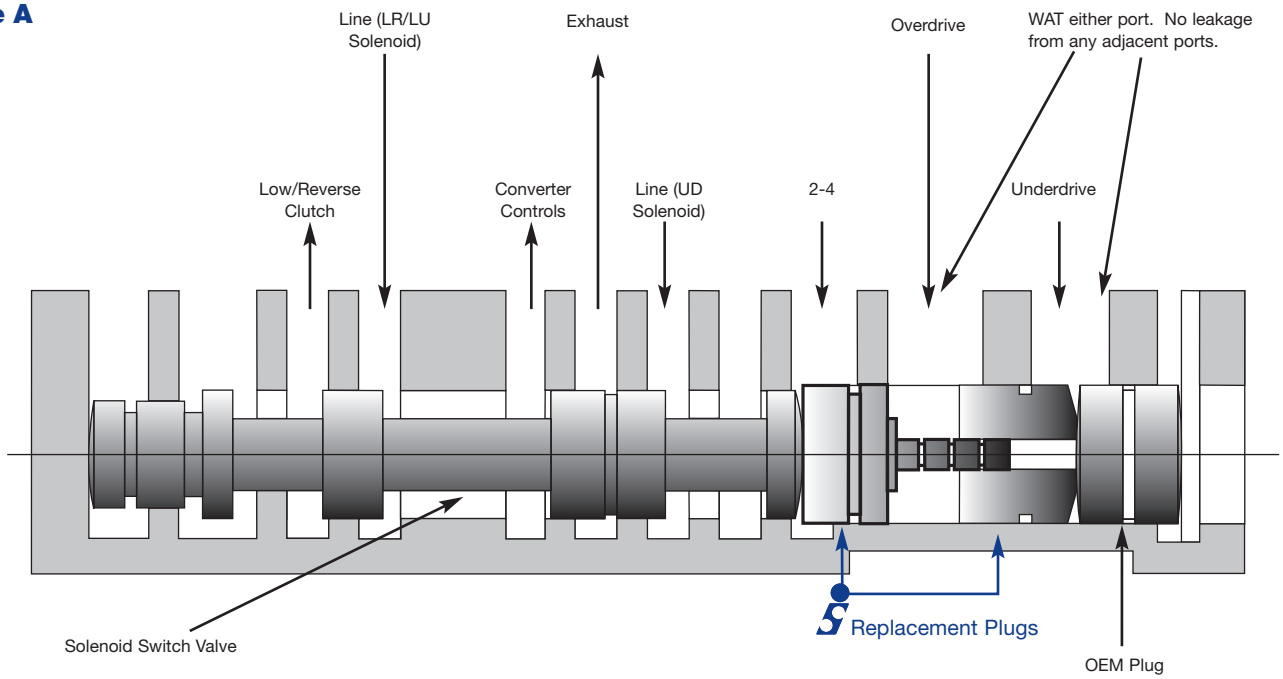


Figure A



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92835-02K Rev:-, 92835-18K Rev:-, 92835-02K(in) 09-14-06
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92835-02K Standard Size:

1. Remove the original three solenoid switch valve plugs, saving one.
2. Buff out the valve body bore to remove any ridged aluminum.
3. Install the Sonnax replacement plugs as shown in Figure A on page 1.
4. Return the original plug to the valve body bore end and install the retainer.

92835-18K Oversized Plug Kit

1. Remove and discard all three solenoid switch valve plugs.
2. Remove and retain the solenoid switch valve.
3. Oversize the bore utilizing reamer **92835-RM**, and adhering to the instructions provided.
4. Reinstall the OEM solenoid switch valve.
5. Install the Sonnax replacement plugs as shown in Figure B.
6. Ensure that the o-ringed end plug is positioned so that the small stepped diameter is inboard, and is pushed in just far enough to re-install the OEM retainer.

Hint: For best results installing the o-ringed end plug, lubricate the plug and o-ring with Sonnax Slippery Stick first.

Wet Air Test

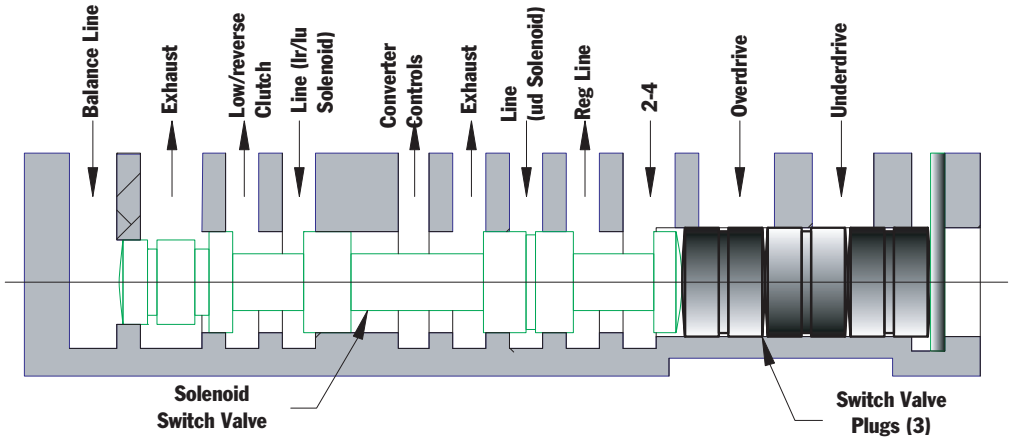
To test for excessive bore wear at the solenoid switch valve plugs, a Wet Air Test can be performed. Place a small amount of oil into either the overdrive or underdrive ports and follow with low air pressure. There should be little or no leakage past the plugs and out any adjacent port (2-4, underdrive, overdrive or retainer clip port).

Reaming Instructions

Note: Prior to reaming the valve body, examine the outer face of the valve body casting at the bore opening. If there is any raised material (e.g. due to cast counterbore), sand the face flat. This face acts as a critical positional stop for the reamer.

1. Remove all components from the bore. Discard the three OEM plugs. Retain the OEM switch valve and retaining clip.
2. Clean the valve body bore thoroughly in a solvent tank.
3. Securely clamp the valve body horizontally to the bench, with circuits facing up, making sure not to clamp directly over the bore to be reamed. Small wood blocks may be used under the valve body casting for better support.
4. Soak the bore and reamer with cutting fluid.
5. The reamer is self-piloting. Insert the reamer into the bore until the cutting tip contacts the outer face of the casting.
6. Use a speed handle to turn the reamer in the bore. The reaming action should be clockwise in a smooth and continuous motion, at 60-120 rpm.
7. Continue reaming until the large shank diameter contacts the face of the valve body casting. Approximate reaming time is 5 minutes.
8. Using low air pressure, blow the chips free prior to removing the reamer.
9. To remove the reamer, turn clockwise while slowly pulling outward on the reamer.
10. Remove any remaining debris from the bore with air pressure and clean in the solvent tank.

Figure B



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