4T80-E

PART NUMBERS **72854-03K, -TL2**

TCC Regulator Valve Kit

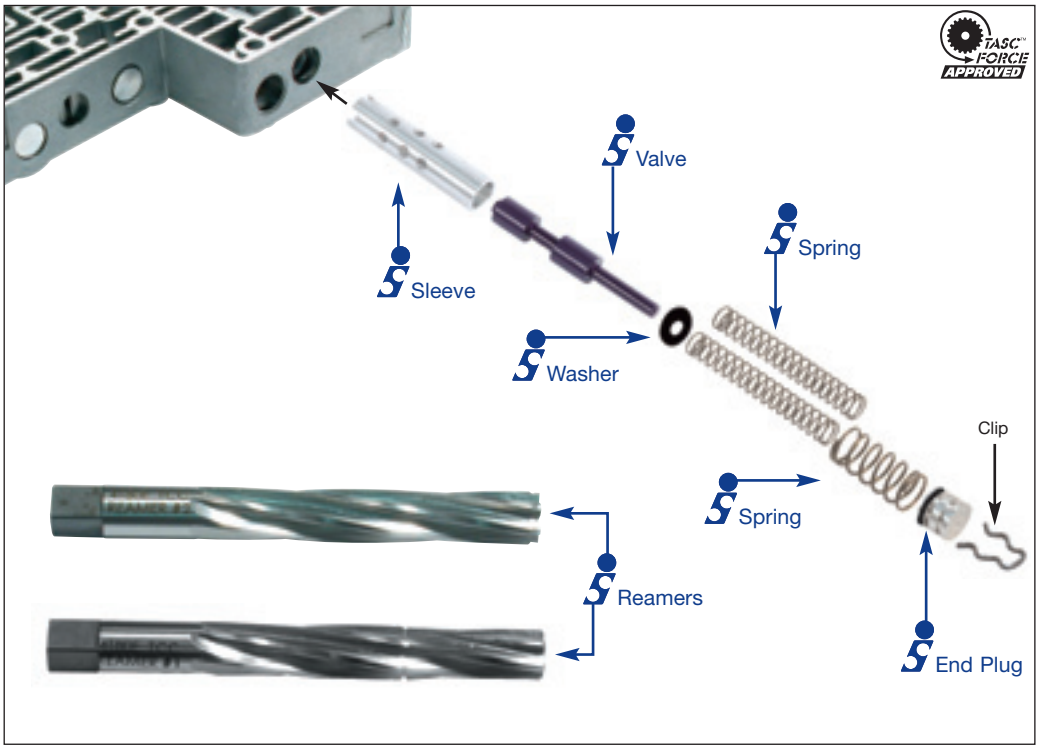
72854-03K
1 Sleeve
1 Valve
3 Springs
1 Washer
1 O-Ringed End Plug

72854-TL2
2 Reamers

Note: Reamer tool kit **72854-TL2** us necessary to enlarge the bore to accept the sleeve and valve assembly.

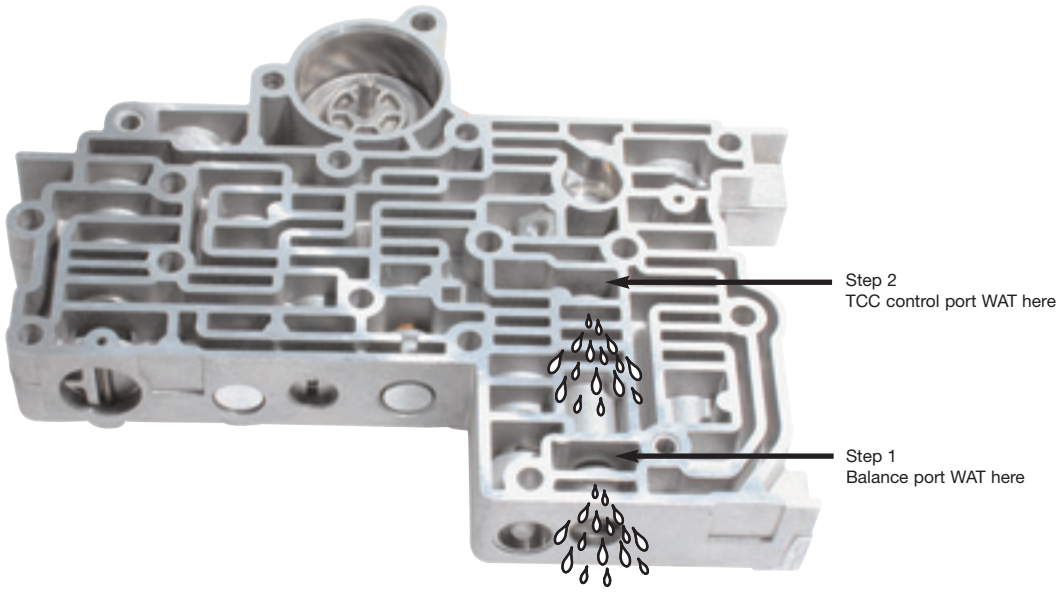
Also Available:

72754-01K
4T80-E Boost Valve Assembly



Wet Air Test

1. Place a small amount of oil into the balance port. Follow with low air pressure. There should be minimal/no leakage past the end plug or past the valve spool and out the line port.
2. Place a small amount of oil into the TCC control port. Follow with low air pressure. There should be minimal/no leakage past the valve spool and out the exhaust port.
3. If there is excessive oil or air leakage, the valve bore should be enlarged and an oversized valve installed.



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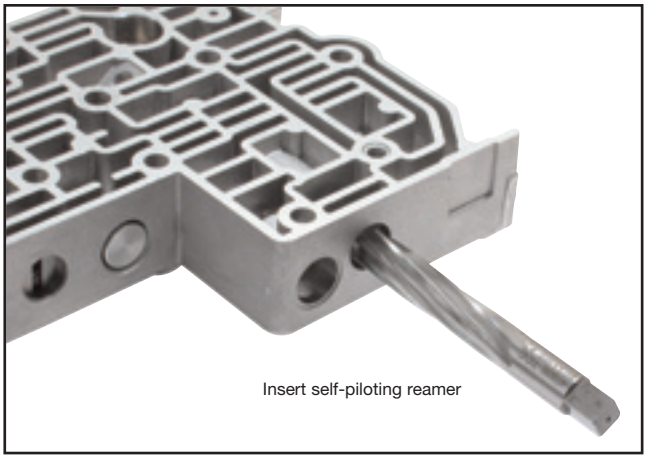
Reaming Instructions


Insert self-piloting reamer

1. Remove all components from the bore.
2. Clean the valve body bore thoroughly in a solvent tank.
3. Securely clamp the valve body horizontally to the bench, making sure not to clamp directly over the bore to be reamed.
4. Soak the bore and reamer with cutting fluid (Tap Magic®, Mobilmet, etc.).
5. Place self-piloting reamer #1 into the bore, and ease forward until the cutting tip contacts the first bore to be reamed. (See photo)
6. Turn the reamer in a smooth and continuous clockwise motion, at 60-200 rpm. Continue reaming until the reamer bottoms in the bore.
7. Using low air pressure, blow the chips free prior to removing the reamer.
8. To remove the reamer, turn clockwise while slowly pulling outward on the reamer.
9. Remove any remaining debris from the bore with air pressure and clean in a solvent tank.
10. Repeat steps 4 through 9 using self-piloting reamer #2.

Cautions

1. Never turn the reamer backward. This will dull the reamer.
2. Pushing forward 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. Clean the reamer after each use and store in its protective tube
5. A dull reamer will cut a smaller hole. Reamers can be sharpened. Actual life of a reamer before resharpening averages 50 to 70 bores, and depends on oil and turning process. Take the reamer to a professional tool sharpener for resharpening.

Installation Instructions

1. Remove all components from the bore. Keep the OEM retainer and discard the valve, spring and end plug.
2. Ream the bore according to the instructions.
3. Push the sleeve into the bore, notched end first, until it bottoms in the bore (see photo on front page).
4. Push the valve into the installed sleeve, stem end facing out (see photo on front page).
5. Select ONE of the 2 longer and narrower springs per the following application, and place over the installed valve stem:
   - For OEM TCC Apply (25psi cracking) use the **UNPAINTED** spring
   - For firm TCC Apply (18psi cracking) and less slippage, use the **WHITE** spring
6. Install the washer so that it sits flush with the outer face of the installed sleeve.
7. Install the shorter and wider spring into the bore, over the valve stem and inner spring, flush with the washer.
8. Lubricate the o-ring with O-Lube, and install into the small groove on the end plug. Gently push the o-ringed end plug into the bore, recessed pocket facing inward, until the OEM retaining clip can be installed into the end plug.