

PR Valve & OEM-Sized Valve

95200-06

1 OEM-Sized PR Valve

Note: Fits both Type 1 and Type 2 valve body designs

95200-05K

1 Pressure Regulator
Valve Sleeve

1 Clip

Note: Fits both Type 1 and Type 2 valve body designs



95200-TL

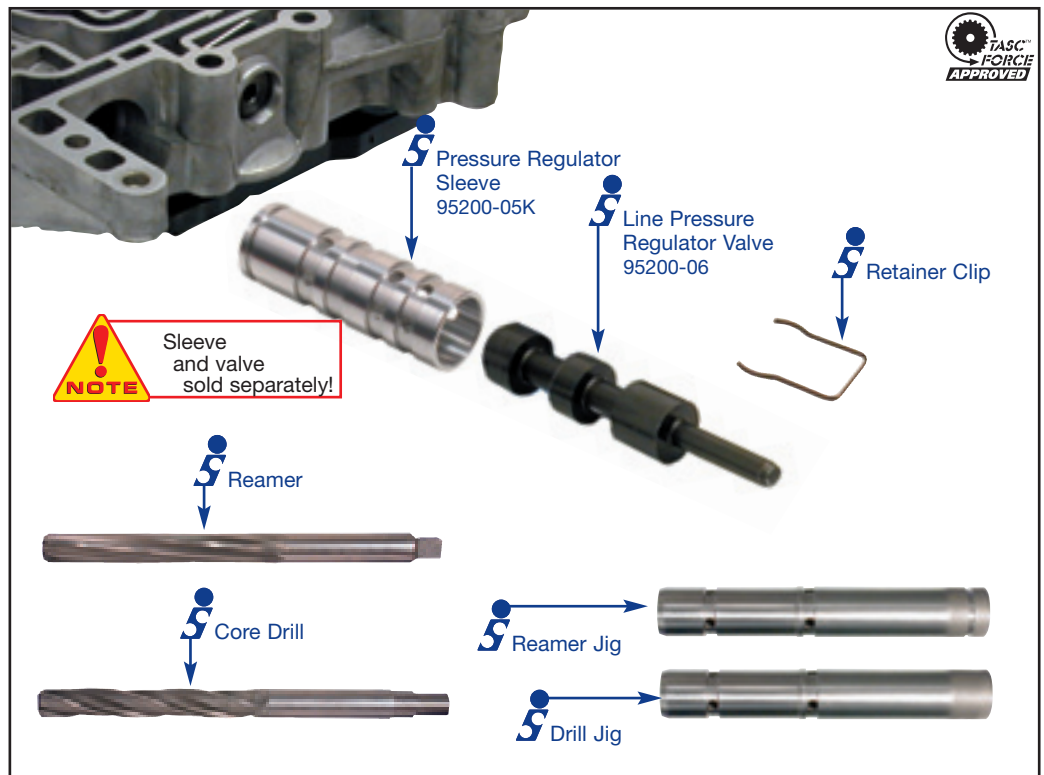
1 Core Drill

1 Reamer

1 Drill Jig

1 Reamer Jig

Note: Required for the 95200-05K only.



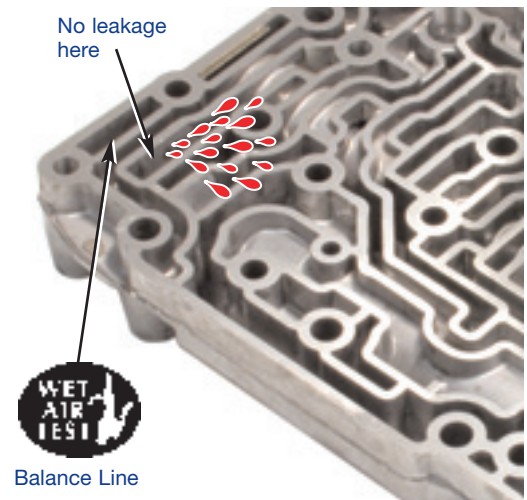
Wear Test:

Note: There are a number of methods for checking excessive wear in this bore line-up.

To Wet Air Test the pressure regulator valve, place a small amount of oil into the balance line port. Follow with low air pressure. There should be little or no leakage past the valve spool.

With only the pressure regulator valve installed, hold a flashlight directly over the pressure regulator valve at a 90-degree angle to the gasket surface. Hold the valve body up to your eye, looking into the bore as if you were looking into a telescope. If there is a substantial amount of light around the valve spools, the casting is worn.

To check for minimum and maximum pressures with the transmission still in the vehicle, connect a pressure gauge to the line pressure port. With the engine idling and the transmission in park, you should have between 58 and 72 psi. Remove the line pressure solenoid fuse, located in the fuse block in the engine compartment. With the fuse removed, line pressure should rise to between 175 and 245 psi. Engine rpm may need to be raised slightly to achieve maximum pressure.

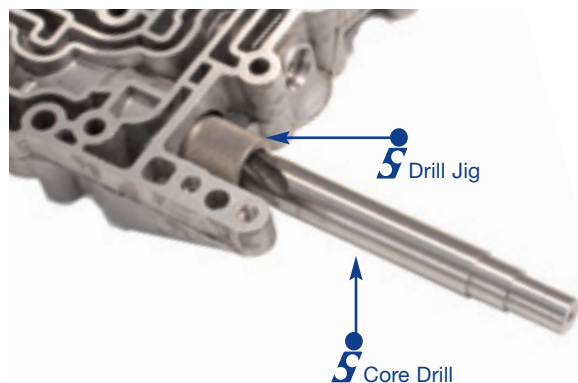


Disassembly Instructions:

1. Remove and save OEM boost valve retainer, boost valve assembly, PR springs, spring hat and PR valve.

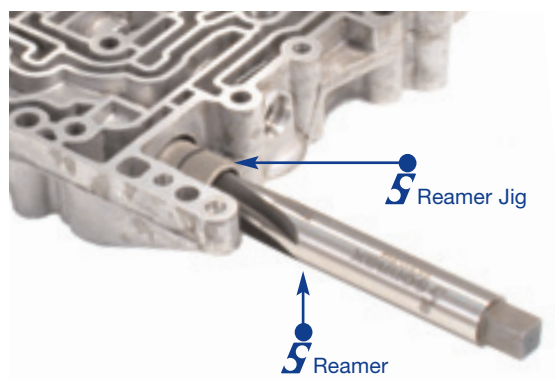
Drilling Instructions:

1. Clean the valve body in a solvent tank.
2. Clamp the valve body to bench horizontally, with circuits up. Do not clamp directly over the bore to be drilled and reamed.
3. Insert the drill jig into the bore, knurled end out, until it bottoms. The drill jig has NO identification groove on the knurled end and has "Saturn PR Valve Drill Jig" printed on it.
4. Fill bore and coat core drill with cutting fluid (Tap Magic®, etc.).
5. Insert core drill into the drill jig carefully, until it contacts the pressure regulator bore. Drill the bore carefully, at about 250 rpm, until the drill bottoms in the pressure regulator bore.
6. Using an air gun, blow out as many chips as possible before removing the drill.
7. Remove the drill and blow out any remaining chips. Clean again in the solvent tank.



Reaming Instructions:

1. Reclamp the valve body to bench horizontally, with circuits up.
2. Insert the reamer jig into the bore, knurled end out, until it bottoms. The reamer jig has one identification groove on the knurled end and has the text "Saturn PR Reamer Jig" on it.
3. Fill bore and coat reamer with cutting fluid (Tap Magic®, etc.).
4. Insert the reamer into the bore carefully, until it contacts the pressure regulator bore. Using a speed handle, turn the reamer clockwise at about 1 to 1 1/2 revolutions per second in a continuous motion. Continue until the reamer bottoms in the pressure regulator bore. Note: Hand-reaming the bore may take up to 15 minutes.
5. Using an air gun, blow out as many chips as possible before removing the reamer.
6. Remove the reamer by rotating clockwise while pulling outward. Blow out any remaining chips and clean the valve body again in the solvent tank.



Reaming 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 behind as the reamer exits a bore.
- Blow any chips free from the reamer after each use.
- Never use a crescent wrench or ratchet to turn the reamer.

Sleeve Installation Instructions:

1. Lubricate the bore and sleeve with ATF prior to assembly.
2. The pressure regulator valve sleeve should go into the valve body with the end notches and narrow clip groove first (inboard).
3. The sleeve will fit over the shank end of the core drill, which can be used as an installation tool for the sleeve (as shown on the next page).
4. Carefully insert the sleeve until it contacts the end of the bore. Install the sleeve clip provided in kit as shown.
5. Insert the OEM pressure regulator valve into the installed sleeve.
6. Reinstall the OEM spring hat, springs and boost valve assembly.





Pressure Regulator Valve Information:

- The OEM valve spools measure .569" diameter.
- A larger spool diameter indicates the valve body has been remanufactured. The Sonnax sleeve and tool kit may still be used, but requires the use of a new Sonnax valve, **95200-06**.
- If the OEM valve shows signs of wear or severe scoring, a new Sonnax valve is recommended.