TCC Regulator Valve Kit

34994-01K
1 TCC Regulator Valve
1 Scarf Cut Seal
2 Springs

Also Available:
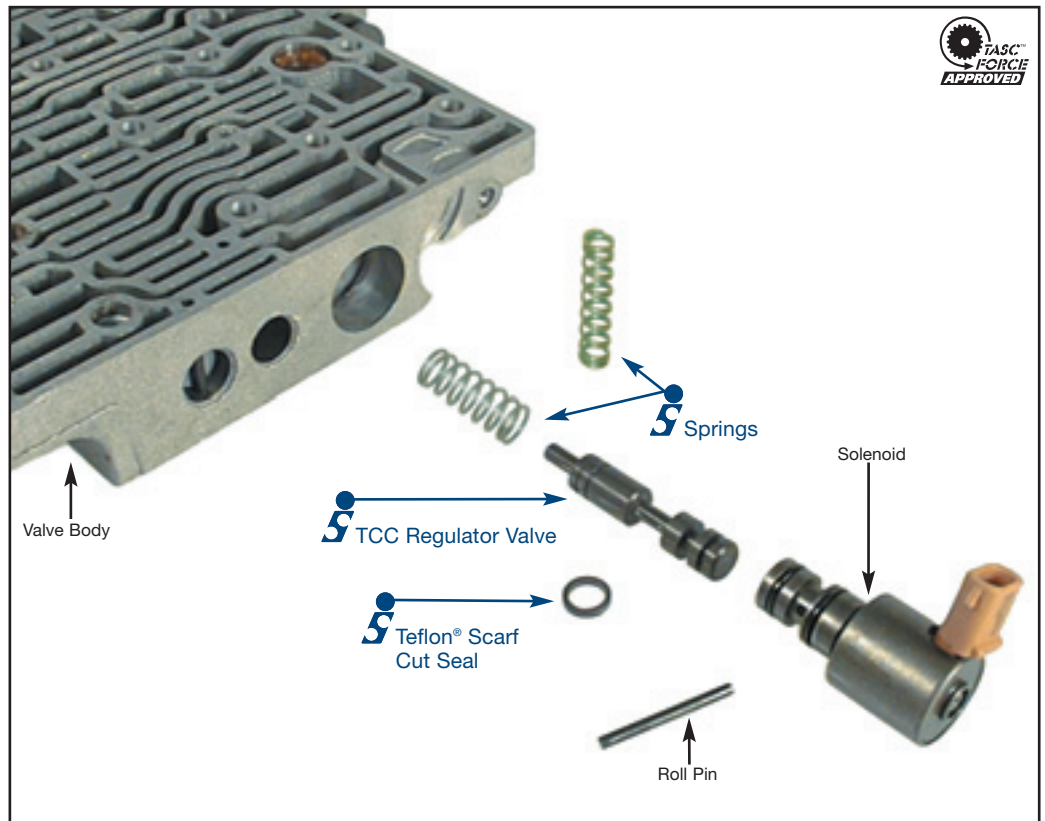
34994-18K
1 TCC Regulator Valve
1 TCC Regulator Valve Sleeve
2 Springs
1 Retaining Pin

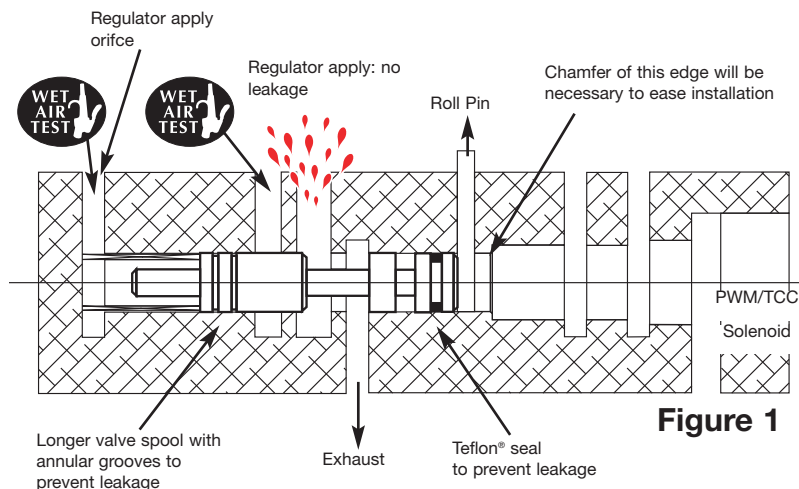TOOL REQUIRED

F-34994-TL18
1 Reamer
1 Reamer Jig
1 Guide Pin

VALVE BODY FIXTURE REQUIRED

TASC FORCE APPROVED

Springs

Solenoid

Valve Body

TCC Regulator Valve
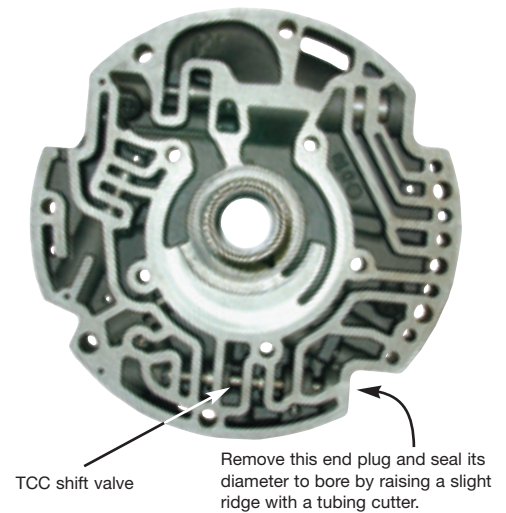
Teflon® Scarf Cut Seal

Roll Pin

Wet Air Test

To Wet Air Test the assembly, place a small amount of oil into the line circuit. Follow with low air pressure. There should be little or no leakage from the regulator apply or exhaust ports.

Regulator apply orifce

Regulator apply: no leakage

Roll Pin

Chamfer of this edge will be necessary to ease installation

WET AIR TEST

WET AIR TEST

PWM/TCC Solenoid

Longer valve spool with annular grooves to prevent leakage

Exhaust

Teflon® seal to prevent leakage

Figure 1

Tech Tip

TCC shift valve

Remove this end plug and seal its diameter to bore by raising a slight ridge with a tubing cutter.

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Installation Instructions

1. To install the Sonnax replacement assembly, remove the retaining clip from the PWM solenoid and the roll pin from the valve body.

2. Remove the TCC regulator valve and spring and discard.

3. Grease the seal groove on the replacement valve, and carefully insert the scarf-cut seal so that the tips are not raised above the valve spool diameter.

4. **Spring selection**

   a) For OEM shift feel, select the HEAVIER (.420" diameter) spring.

   b) For a firmer lockup (best suited for towing applications), select the LIGHTER spring (.300" diameter) and restrict the feed orifice to .025" by peening closed and redrilling (see Figure 2).

5. Place the selected replacement spring over the long stem on the TCC valve.

6. Carefully push the spring and valve assembly into the valve bore, spring end first.

7. Make sure that the seal remains fully seated in the groove as it is pushed past open valve body ports.

8. Reinstall the roll pin to secure the valve and spring.

9. With a pick or small screwdriver, carefully stroke the valve in the bore to make sure that the seal has not hung-up during assembly.

10. Return the PWM solenoid to the valve body.

Note: A small chamfer may need to be machined into the valve body bore to aid in the installation of the valve/Teflon® seal. A $^{15}\!/_{32}$" drill or counterbore is recommended. Remove any debris created prior to installing valve assembly parts.

Installation Instructions (continued)

Figure 2

Reg. Apply Orfice

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