

Tool Kit for 84754-40K

84754-TL4

1 Reamer #1
1 Reamer #2
1 Reamer Guide

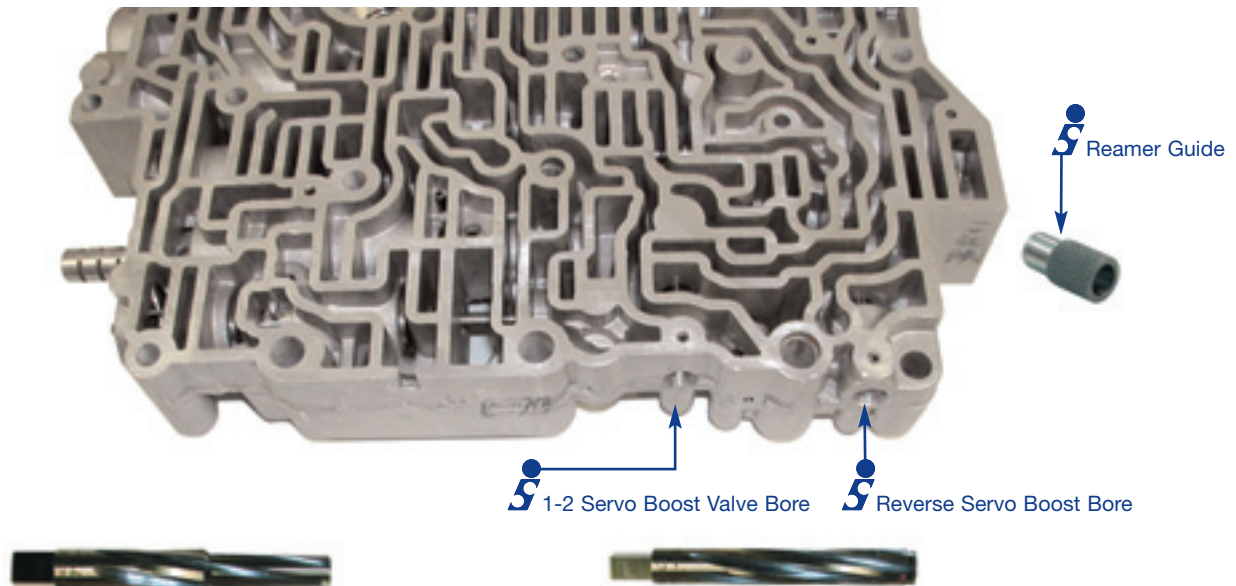
More technical information
is available at www.sonnax.com. Type
in this part number under "Part Finder."

4T60 (440-T4) Applications use 84754-TL4



For 4T60 (440-T4) 1-2 Servo Boost Valve & Reverse Servo Boost Valve Bores

4T60 (440-T4)



The piloted reamer labeled "4T60 #1" is used first on both the 1-2 and reverse servo boost valve bores.

The reamer labeled "4T60 #2" and reamer guide are used after the bore has been reamed by "4T60 #1" reamer.

Valve Body Preparation

- STEP 1** Remove and discard all OEM parts from 1-2 (forward) or reverse servo boost valve bore.
- STEP 2** Clean valve body bore with solvent to remove any sludge or metal shavings.
- STEP 3** Clamp valve body to bench horizontally with open circuits up. Do not clamp directly over bore to be reamed as this may distort the bore.

First Reaming Operation

Step 1

Ream the servo bore with the stepped reamer marked "4T60#1". Note: This piloted reamer does not require a reamer guide. Lubricate reamer and valve body bore with cutting fluid.

Step 2

Insert reamer into bore until chamfered cutting tip contacts inner bore opening. Using a speed handle ream bore clockwise at 1 to 1 1/2 turns per second. This reaming operation should take approximately 1 minute.

Step 3

With low air pressure and reamer still in the bore, blow chips out of bore.

Step 4

Turning clockwise, remove the reamer from the bore. Clean the remaining chips from the bore.

Second Reaming Operation

Step 1

Insert reamer guide in bore. Lubricate "4T60#2" reamer and bore with cutting fluid.

Step 2

Insert reamer through guide and into bore until chamfered cutting tip contacts inner bore to be reamed.

Step 3

Using a speed handle, ream bore clockwise at 1 to 1-1/2 turns per second. Continue until reamer tip bottoms in bore. Approximate time = 1.5 minutes

Step 4

With low air pressure and reamer still in the bore, blow chips out of bore.

Step 5

Turning clockwise, remove the reamer from the bore. Clean the remaining chips from the bore.

Valve Body Assembly

The valve body is now ready to accept new Sonnax servo boost valves. Install valve, spring and retainer as shown below.

