

## Oversized Accumulator Pressure Control Valve

### 36948-20K

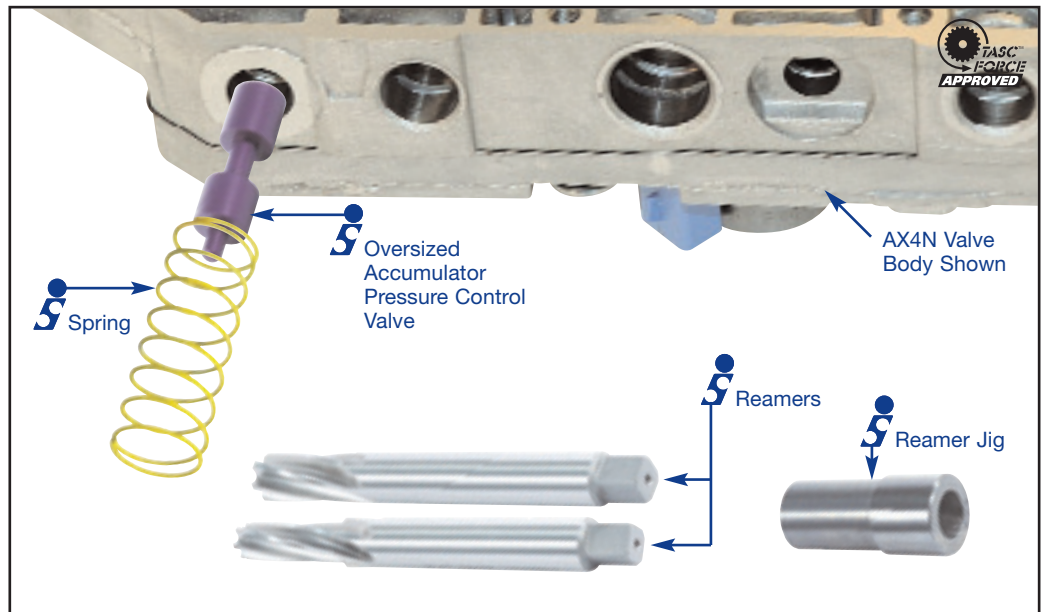
1 Valve  
1 Spring



### 36948-TL

1 Reamer Jig  
2 Reamers

**Note:** Tool kit also works E4OD and 4R100 applications.



### Reaming Instructions

**Note:** The '95-'97 AX4N applications use the reamer jig and reamer 36948-RM2. The tool kit also contains reamer 36948-RM for E4OD and 4R100 units. Each reamer should have the part number and application etched into the shank for identification purposes.

### Prep and Set-up

1. Remove all components from the bore. Save all parts except the accumulator pressure control valve.
2. Clean the bore thoroughly in a solvent tank.
3. Securely clamp the valve body to the bench, making sure not to clamp directly over the bore to be reamed.
4. Insert the reamer jig into the bore.
5. Soak the bore and reamer with cutting fluid (Mobilmet S-122, Lubegard Bio-Tap, Tap Magic™, etc.). For best results, provide a continuous flow of water-soluble cutting fluid (i.e. Mobilmet S-122) during the reaming process.
6. Gently insert the reamer through the jig and into the bore until the cutting tip contacts the first bore to be reamed.
7. Select the correct sized socket to fit the square shank of the reamer, and attach it to a wobble/swivel socket drive.

### Reaming

1. The reamer should be turned either by hand using a speed handle or by a low rpm, high torque air drill regulated to a maximum of 200 rpm.
2. The reaming action should be clockwise in a smooth and continuous motion, at 60-200 rpm. The reamer should actually pull itself through the bore, so little or no forward force should be applied.
3. Continue reaming until the reamer stop is reached. The approximate reaming time is 2 minutes.

## Finish and Clean-up

1. Using low air pressure, blow the chips free before removing the reamer.
2. To remove the reamer, turn clockwise while slowly pulling outward on the reamer.
3. Remove any remaining debris from the bore with low air pressure and clean in a solvent tank.
4. Examine the bore after cleaning for surface finish, debris, and burrs. Flashing and burrs on the exit side of casting bores can be carefully removed with a small piece of Scotchbrite™ on the end of a long wire.
5. Clean the reamer after each use and store in its protective tube.

## Cautions and Suggestions

1. Turning the reamer backward will dull it prematurely.
2. Pushing 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. A dull reamer will cut a smaller hole. Reamers can be sharpened, but should only be done by a professional machine tool sharpener. Actual life of a reamer before resharpener averages 50-70 bores.

## Installation/Assembly Steps

1. Remove all components from the bore. Retain the valve body clip and inner spring and spring seat assembly.
2. Discard the OEM accumulator pressure control valve.
3. Inspect the line pressure modulator sleeve and plunger valve kit for sleeve wear, and replace if necessary.
4. Ream the bore according to instructions.
5. Return all components to the bore as indicated below. The included yellow spring should replace the outer OEM spring in this application.

