

Oversized Solenoid Switch Valve Plug Kit

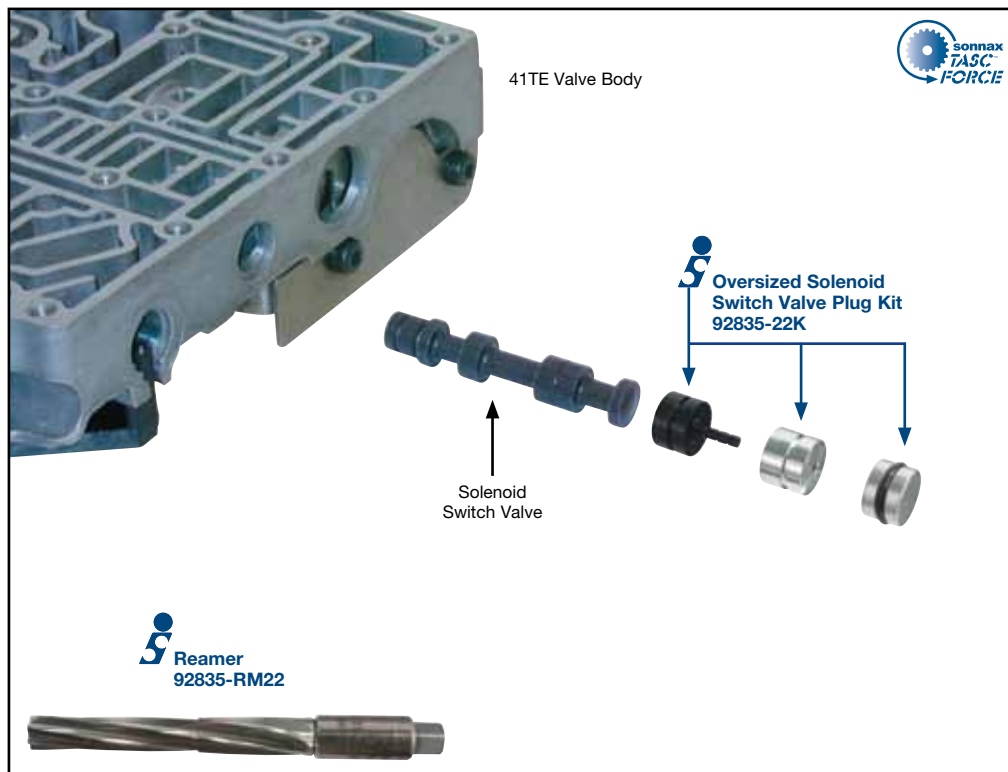
92835-22K

- Oversized Replacement Plugs (2)
- End Plug
- O-Ring

NOTE: For VLP units only

92835-RM22

Reamer



For VLP units with excessive wear, Sonnax offers the oversized solenoid switch valve plug kit **92835-22K** that requires reamer **92835-RM22**.

1. Disassemble valve.

- Remove and discard the three OEM solenoid switch valve plugs.
- Remove and retain solenoid switch valve.

2. Prepare the bore.

- Clean the bore thoroughly in a solvent tank.
- Securely clamp the valve body horizontally to the bench, with circuits facing up, making sure not to clamp directly over the ore to be reamed. Small wood blocks may be used under the valve body casting for better support.
- Generously lubricate the bore and reamer with cutting fluid (i.e. 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.

3. Oversize the bore.

- The **92835-RM22** reamer is self-piloting - insert into the bore until the cutting tip contacts the outer face of the casting.
- Use a speed handle to turn the reamer in the bore. Reaming action should be clockwise in a smooth and continuous motion at 60-120 RPM. Continue reaming until the large shank diameter contacts the face of the valve body casting. Approximate reaming time is 5 minutes.

- Using low air pressure, blow chips free.

- Remove the reamer by turning it clockwise while slowing pulling outward.

4. Clean the bore.

Remove any remaining debris from the bore with air pressure and clean in the solvent tank.

5. Install and assemble part(s).

- Reinstall the OEM solenoid switch valve.
- Install the Sonnax switch valve plugs as shown.
- Install the O-ringed end plug, ensuring it's positioned so that the small stepped diameter is inbound and pushed in just far enough to reinstall the OEM retainer. For best results, lubricate the end plug and O-ring with Sonnax Slippery Stick™ (**Part No. O-LUBE**) first.
- Install OEM retainer.