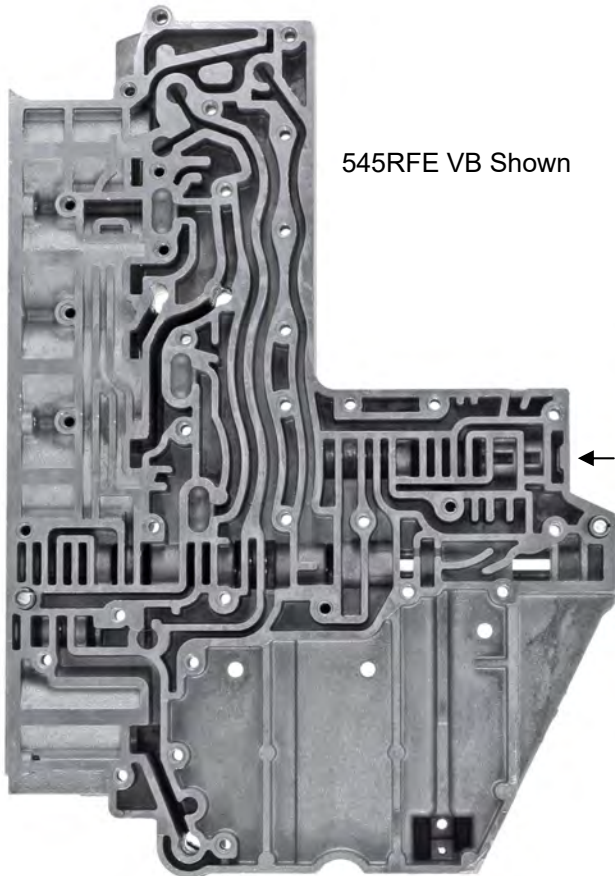


# RFE-SV453-WT (With Tools)

Solenoid Switch Valve Repair Kit.

## Corrects/Prevents/Reduces

Multiple codes on various models such as P1776 Solenoid Switch Valve latched in L/R, P1775 Solenoid Switch Valve latched in TCC, L/R pressure switch rational or circuit error, OD clutch failure, Kills engine at a stop, TCC Slip and/or TCC control stuck off or on.



545RFE VB Shown

This product fits 604, 606, 42RLE, 45, 545 & 68 RFE's equipped with a **.453 diameter** switch valve.

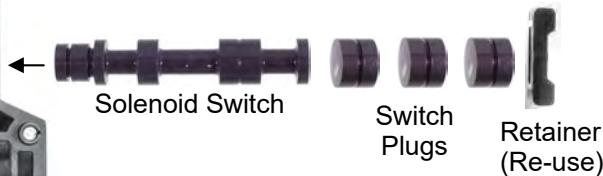


## Heads Up!

Make a note of small parts locations as they vary with transmission type and model years!

### Step 1

Disassemble VB to remove and measure your original valve as shown above. If your valve does **not** measure approx .453, **STOP!** This product does not fit your VB! If your valve **DOES** measure approx .453 then discard your original switch valve and switch plugs. Save the retainer for re-use.



Got a **.420** diameter Switch Valve?  
Order p/n **RFE-SV420-WT** (With Tool)  
For a parts only refill order **RFE-SV420-NT**

**Tip:** Have an old parts washer? Get 5 gals of WD-40 (approx \$80 bucks) and you'll have the perfect wet tank to keep the VB bore and reamer cool while you ream aluminum valve bodies. Flushes chips out as you go.



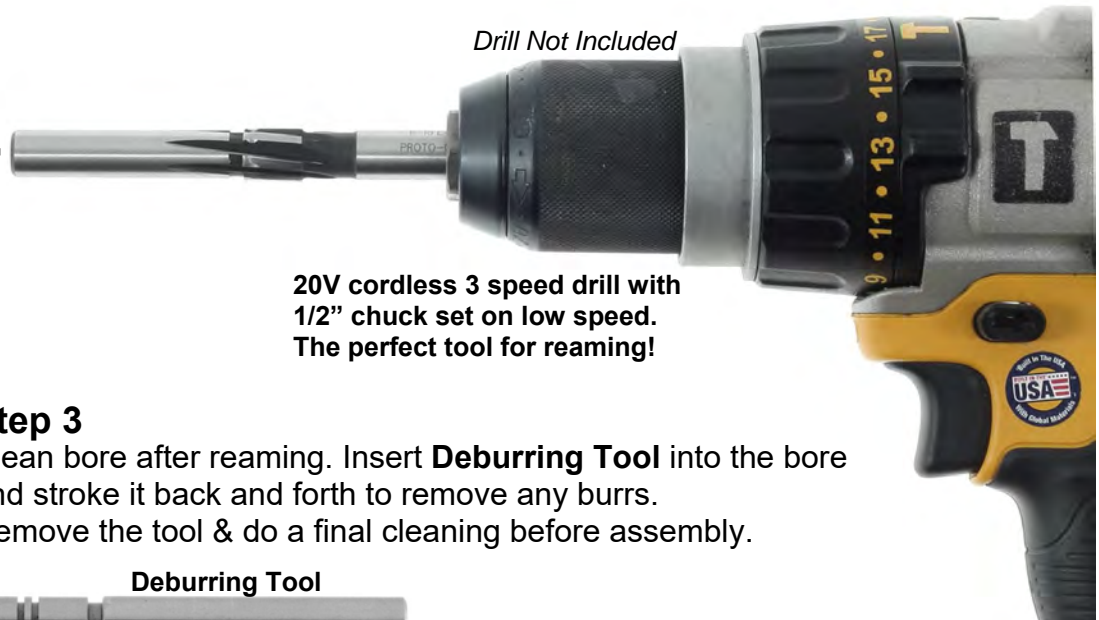
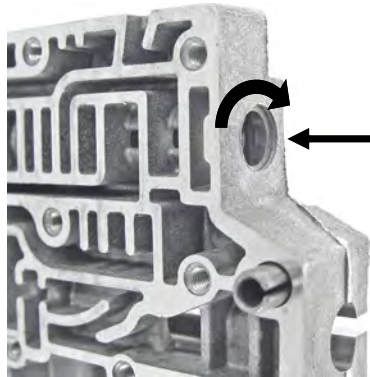
Save the reamer & de-burring tool!  
Order p/n **RFE-SV453-NT** refill kit!

Approx. 1/2"  
Inserted into Drill Chuck

## Step 2

Insert reamer into **drill chuck** about one half an inch. Using low speed and lots of WD-40 (we tried it all, WD-40 works best) insert reamer into bore and let leading edge guide the reamer down until the tip of reamer bottoms on the wall. When it bottoms out, stop. It will have resized the area the 3 switch plugs use, not the whole bore. Use light pressure, let the reamer & WD-40 do the work.

**Ream Clockwise**

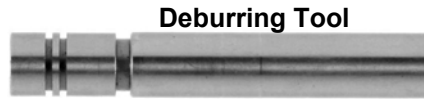


*Drill Not Included*

20V cordless 3 speed drill with 1/2" chuck set on low speed. The perfect tool for reaming!

## Step 3

Clean bore after reaming. Insert **Deburring Tool** into the bore and stroke it back and forth to remove any burrs. Remove the tool & do a final cleaning before assembly.



## Step 4

Use a small amount of assembly gel to hold the new **Blue** spring in hollow end of the **New Switch Valve** provided. Pour a little ATF into the VB bore and carefully insert the new switch valve (spring side first) into the bore. Insert **New Switch Plugs** and re-check for free movement before installing original retainer.

