

## Oversized Gain Valve Kit



**Part No.**  
**37000-24K**

- Gain Valves (2)
- O-Ring

**NOTE:** Fits '00-'09 units only.

## Tool Kit

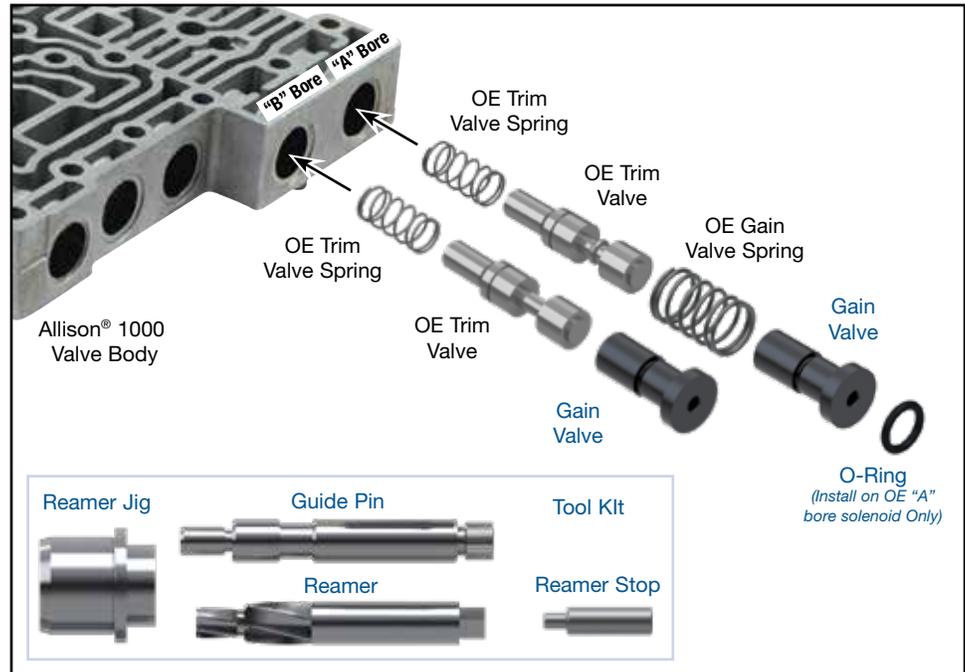


**Part No.**  
**F-37000-TL24**

- Reamer
- Reamer Jig
- Reamer Stop
- Guide Pin

**NOTE:** Sonnax "F-Tool" kits designed to service a specific bore require the VB-FIX, a self-aligning valve body reaming fixture. More information and instructions can be found online at [www.sonnax.com](http://www.sonnax.com).

## Allison® 1000/2000/2400



**NOTE:** "A" and "B" trim pressure valve trains are visually similar but are not the same.

### 1. Disassembly

- Remove OE solenoid retainer, solenoid, gain valve, gain valve spring (*found in "A" bore only*), trim valve and trim valve spring.
- Discard OE gain valve, while saving all other parts for reuse.
- Thoroughly clean bore prior to reaming.

### 2. Bore Reaming

- Insert reamer stop tool into bore with small diameter inboard. Ensure reamer stop contacts bottom of bore.



**NOTE:** The reamer stop tool must be inserted all the way into the bore (small diameter inboard) prior to reaming. Failure to use the reamer stop tool will permit the reamer to over-travel in the bore and will destroy the casting.

- Ream bore (for reaming instructions/reamer care, please visit [www.sonnax.com](http://www.sonnax.com)). Sonnax reaming tool kit **F-37000-TL24** and **VB-FIX** are required for this operation.

### 3. Installation & Assembly

Be certain all debris has been removed from the valve bores and valve body.

#### "A" Bore:

- Remove small dia. O-ring from OE "A" trim solenoid snout and replace with Sonnax O-ring.
- Install OE trim valve spring, trim valve, and gain valve spring.
- Install Sonnax gain valve, OE solenoid and solenoid retainer.

### 3. Installation & Assembly (continued)

#### "B" Bore:

- Install OE trim valve spring, trim valve, and Sonnax gain valve.
- Install Sonnax gain valve, OE solenoid and solenoid retainer.

### 4. Final Testing

Vacuum testing at the port(s) indicated holds the recommended minimum 14 in-Hg.

