

# Instructions

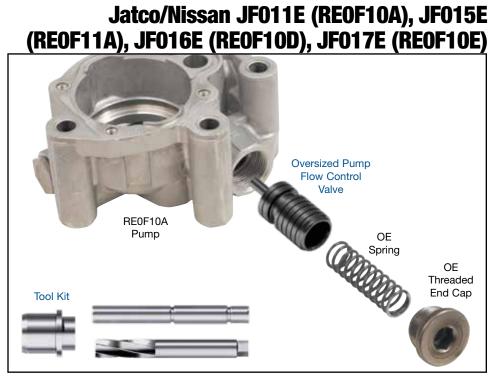
# **Oversized Pump** Flow Control Valve





- Reamer
- Reamer Jig
- 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.



## 1. Disassembly

- a. Remove OE valve train from the pump flow control valve bore.
- b. Save the OE spring and threaded end cap for reuse.
- c. Discard OE valve.

#### 2. Bore Reaming

Ream pump flow control bore (for reaming instructions/reamer care, please visit www.sonnax.com). Sonnax reaming tool kit **F-33510N-TL** and **VB-FIX** are required for this operation.

# 3. Installation & Assembly

- a. Insert Sonnax valve into bore with projecting stem inboard as shown above.
- b. Check for free movement of the valve in the bore.
- c. Reinstall OE spring into bore.
- d. Reinstall and tighten OE threaded end cap.

## 4. Final Testing

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

