

### Oversized Actuator Feed Limit Valve

**Part No.**  
**104740-12**



### Tool Kit

**Part No.**  
**F-104740-TL12**

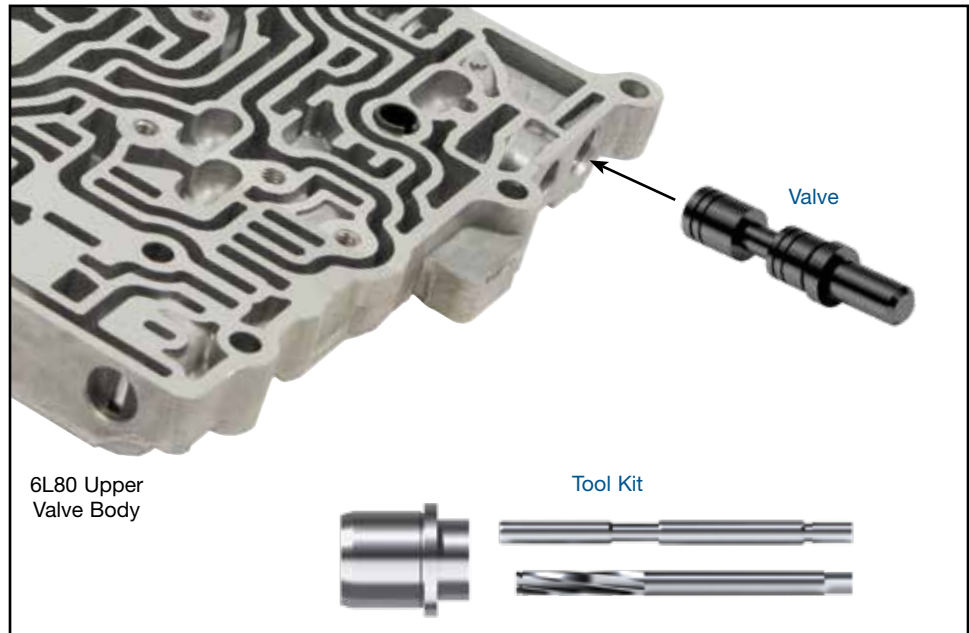


- Reamer
- Reamer Jig
- Guide Pin

**NOTE:** This tool kit can also be used to install oversized AFL valve kit **124740-01** in GM 6T70/75 (Gen. 1) and Ford 6F50/55 valve bodies.

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).

### GM 6L45, 6L50, 6L80, 6L90



#### 1. Disassembly

- Remove OE retainer and spring. Save for reuse.
- Remove and discard OE valve.

#### 2. Bore Reaming



**NOTE:** Valve body is low-profile and must be secured 1/2" above the VB-FIX base plate in order to establish alignment with the bore. Pressure plates stacked under valve body work well for this purpose.

If pressure plates are used, the valve body securing clamp **MUST** be placed directly over the plate stack. Clamping on an unsupported area of the valve body or over the bore to be reamed will cause distortion and result in irreparable damage to valve body.

Ream actuator feed limit bore (for reaming instructions/reamer care, please visit [www.sonnax.com](http://www.sonnax.com)). Sonnax reaming tool kit **F-104740-TL12** and **VB-FIX** are required for this operation.

#### 3. Installation & Assembly

- Install Sonnax valve, spring stem outward as shown in main photo.
- Reinstall OE spring and retainer.

#### 4. Final Testing

Vacuum testing at the port indicated holds the recommended minimum 16 in-Hg.

