

## AFL Valve Kit



Part No.

**55211-01K**

- Sleeve
- Valve
- Spring
- Retaining Clip

## Tool Kit



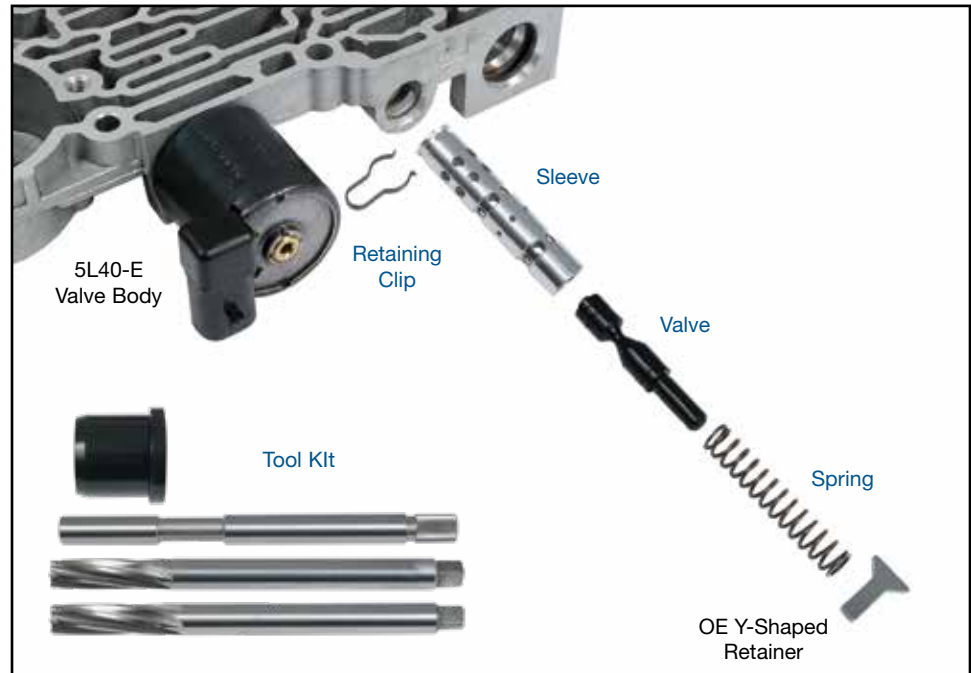
Part No.

**F-55211-TL**

- Roughing Reamer
- Finishing 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](http://www.sonnax.com).

## GM 5L40-E, 5L50-E



### 1. Disassembly

- Remove OE Y-shaped retaining clip and keep for reuse.
- Remove and discard OE valve and spring.

### 2. Bore Reaming

Ream AFL bore (for reaming instructions/reamer care, please visit [www.sonnax.com](http://www.sonnax.com)). Sonnax reaming tool kit **F-55211-TL** and **VB-FIX** are required for this operation.

### 3. Installation & Assembly

- Be certain all debris has been removed from the valve bore and valve body.
- Assemble Sonnax valve and sleeve as shown above, (with long valve stem opposite side of end grooves in sleeve).
- Install the valve/sleeve assembly into the reamed bore, with the end grooves inboard and valve stem outboard.
- Secure sleeve with Sonnax retaining clip, in the groove exposed in the balance port.
- Install Sonnax spring into the bore, ensuring its seated over valve stem.
- Compress Sonnax spring and return OE Y-shaped retainer to the outboard port.

**NOTE:** The sleeve is designed as a linear line-to-line fit in the bore to aid in proper retention. If the Y clip does not fit initially, carefully grind about .005" from the outboard face of the sleeve.