

Oversized Regulating Valve Pressure Control Valve Kit

Part No.
68942-17K

- Valve
- Spring
- Plugs (2) .062"

NOTE: Fits early and late units.

Tool Kit

Part No.
F-68942-TL14

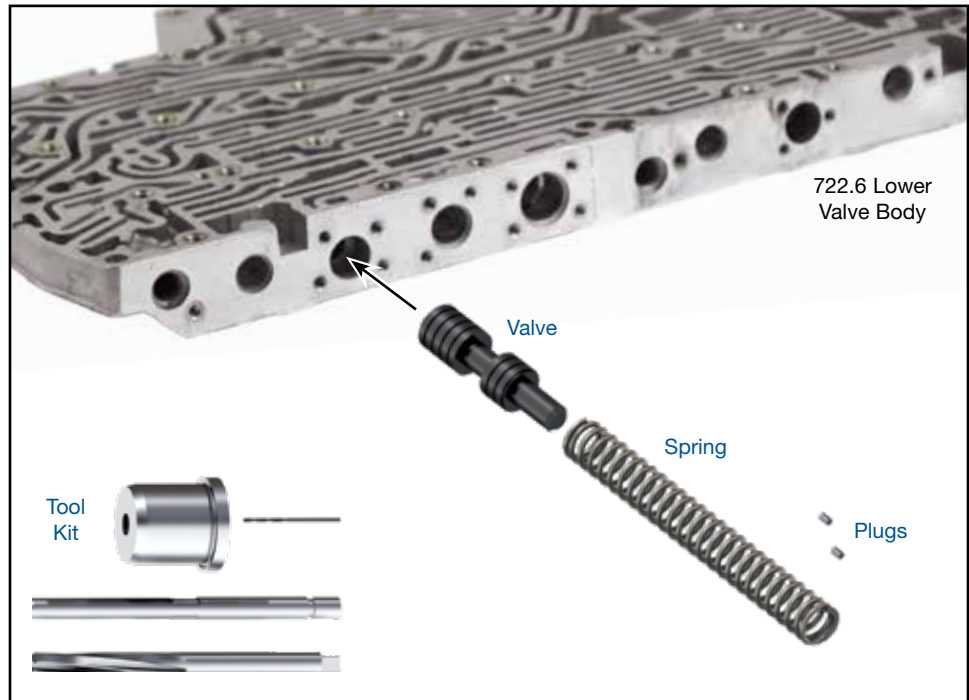
- Reamer
- Reamer Jig
- Guide Pin
- Drill Bit .0625"

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.

NOTE: Tool kit F-68942-TL14 can also be used for lubricating pressure control valve 68942-14K.



Mercedes 722.6



1. Disassembly

- Remove OE retainer plate.
- Remove and discard OE valve and spring.

2. Bore Reaming

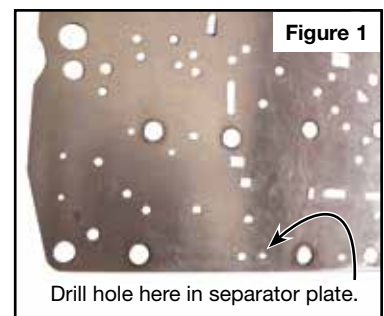
Ream regulating valve pressure control bore (for reaming instructions/reamer care, please visit www.sonnax.com). Sonnax reaming tool kit **F-68942-TL14** and **VB-FIX** are required for this operation.

3. Installation & Assembly

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

Early Application (Figure 2):

- Using Sonnax .0625" drill bit, drill through indicated hole in separator plate (**Figure 1**).
- Then countersink both sides of the hole just drilled with either a 1/8" or 3/16" drill (not included).
- Install aluminum plug. Peen shut on both sides to close off hole.
- Install Sonnax valve and spring.
- Install OE retainer plate.



- It is recommended to verify the latest TCM software level is installed, and to perform an adaptive relearn after repairs are made to adjust for the revised calibration.



3. Installation & Assembly

Late Application (Figure 3):

- Install Sonnax valve and spring.
- Install OE retainer plate.

4. Final Testing

Vacuum testing at the port(s) indicated holds the recommended minimum 18 in-Hg (Figure 4).

