

Oversized 2-3 Overlap Control Valve Kit



Part No.

68942-27K

- Overlap Control Valve
- Plunger Sleeve
- Plunger Valve
- O-Ring
- Spring

Tool Kit



Part No.

F-68942-TL27

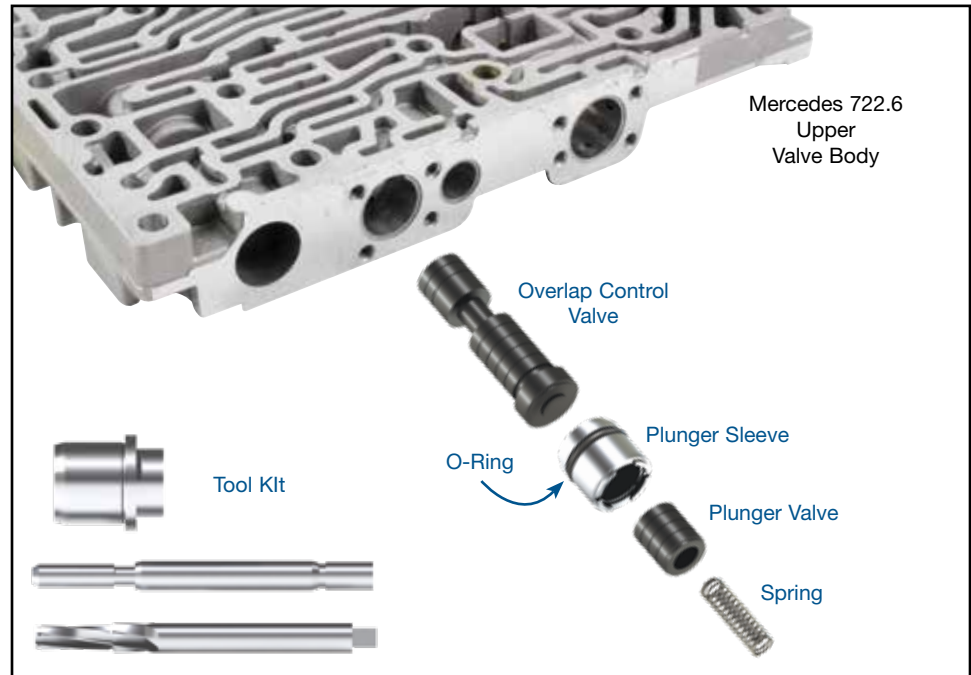
- Reamer
- Reamer Jig
- Guide Pin

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.



WARNING: Required tool kit F-147741-TL13 is no longer in production. Check with your distributor for availability.

Mercedes 722.6



1. Disassembly

- Remove OE screws and end plate, saving for reuse.
- Remove and discard OE spring, plunger valve and sleeve, and overlap control valve.

2. Bore Reaming

Ream overlap control valve bore (for reaming instructions/reamer care, please visit www.sonnax.com). Sonnax reaming tool kit **F-68942-TL27** and **VB-FIX** are required for this operation.

3. Installation & Assembly

- Ensure all debris has been removed from valve bore and valve body.
- Install oversized overlap control valve into bore, small diameter first.
- Install O-ring into sleeve groove and roll on bench to size. Lubricate sleeve and O-ring.
- Install spring into plunger valve spring pocket. Slide plunger valve into sleeve, with spring facing grooved end face of sleeve.
- Slowly install sleeve assembly into valve body bore, taking care not to shear O-ring. Ensure sleeve end face grooves are outward.

4. Final Testing

Vacuum testing at the port(s) indicated holds the recommended minimum 16 and 18 in.-Hg.

