

## GM 4T80-E

### AFL Valve Kit

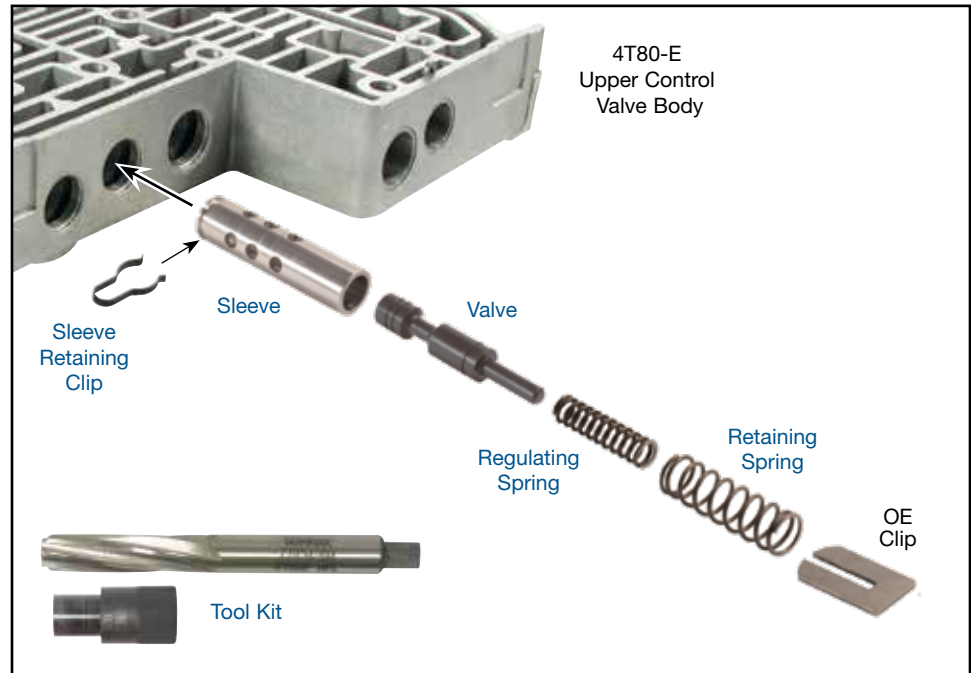
**Part No.**  
**72854-01K**

- Sleeve
- Valve
- Regulating Spring
- Retaining Spring
- Sleeve Retaining Clip

### Tool

**Part No.**  
**72854-TL**

- Reamer
- Reamer Jig



#### 1. Disassembly

- Remove all components from the bore.
- Keep OE valve body clip for reuse and discard the rest.

#### 2. Bore Reaming

Ream AFL bore (for reaming instructions/reamer care, please visit [www.sonnax.com](http://www.sonnax.com)). Sonnax reaming tool kit 72854-TL is required for this operation.

#### 3. Installation & Assembly

- Be certain all debris has been removed from the valve bore and valve body.
- Insert Sonnax valve into Sonnax sleeve and install the assembly into the bore, with the grooved and notched end of the sleeve inboard, until sleeve bottoms in bore.

**NOTE:** A 7/16" drill shank can be used to help.

- Secure with Sonnax sleeve retaining clip inserted into the sleeve groove at the balance AFL port.
- Insert Sonnax regulating spring into the bore and over Sonnax valve stem.

- Insert Sonnax retaining spring into the bore and over Sonnax regulating spring, flush with the outboard end of the sleeve.
- Reinstall OE valve body clip.

**NOTE:** A flat-head screwdriver can be used to compress the springs.



**NOTE:** Ensure the two Sonnax springs are not contacting each other, or coil binding could occur during application.

#### 3. Final Testing

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

