

## Actuator Feed Limit Valve Kit



**Part No.**  
**77754-09K**

- Valve
- Sleeve
- Spring
- Retaining Clip

Patent No. 6,634,377

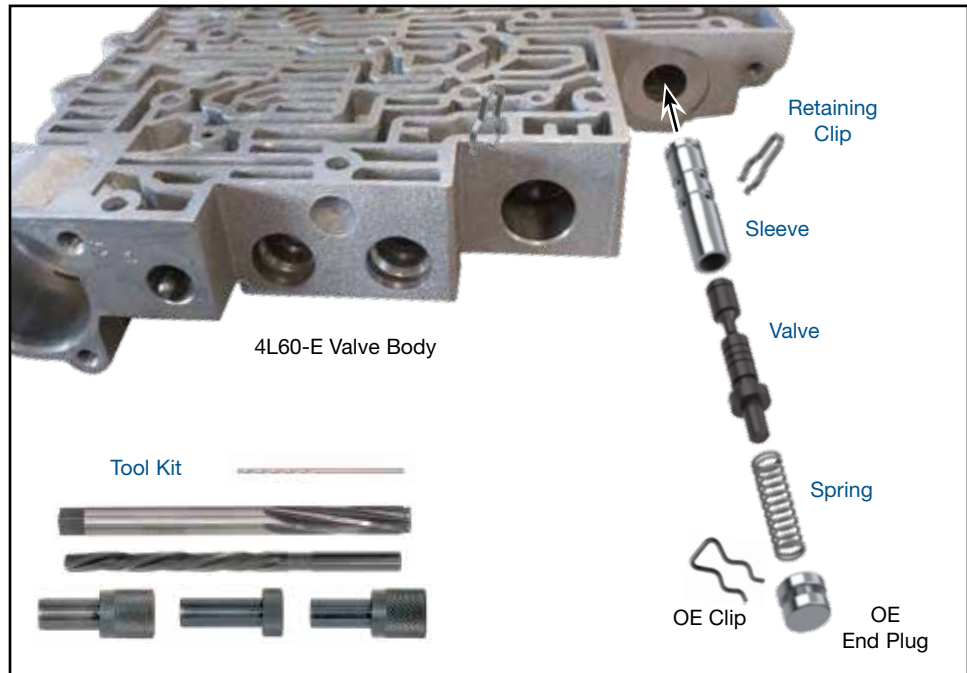
## Tool Kit

**Part No.**  
**77754-TL**

- Core Drill 4L80-E only
- Reamer
- Guides (3) 1 4L60-E & 2 4L80-E
- Drill Bit .052"

**NOTE:** This tool kit works for 4L60-E and 4L80-E AFL valve repairs. More reaming information and instructions can be found online at [www.sonnax.com](http://www.sonnax.com).

## 4L60-E, 4L65-E, 4L70-E



### 1. Disassembly

- Remove OE actuator feed limit valve train lineup.
- Keep OE end plug and end plug clip for reuse.
- Discard OE valve and spring all other parts.

### 2. Bore Reaming

Ream actuator feed limit bore (for reaming instructions/reamer care, please visit [www.sonnax.com](http://www.sonnax.com)). Sonnax reaming tool kit 77754-TL is required for this operation.

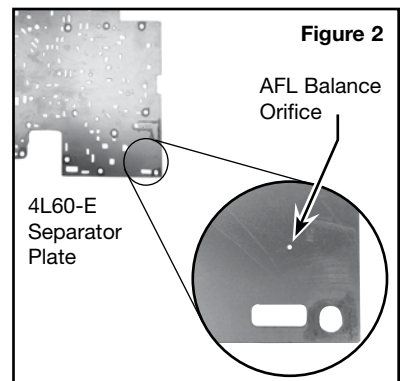
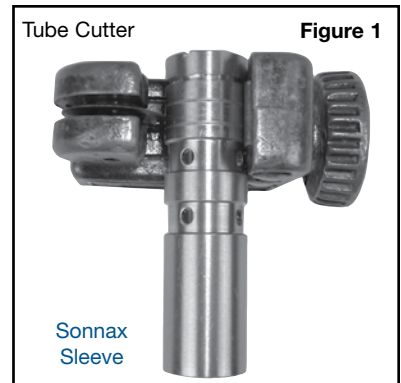
### 3. Installation & Assembly

- Be certain all debris has been removed from the valve bore and valve body.
- Remove Sonnax valve from sleeve and install with retaining clip groove inward.



**NOTE:** Sonnax sleeve must fit the bore with slight resistance. If sleeve slides in easily or rotates in the bore, a tubing cutter can be used to raise a slight ridge around the sleeve lands (**Figure 1**).

- Lightly tap Sonnax sleeve into position (the OE valve inserted backward may be used to drive the sleeve).
- Install Sonnax valve and spring.
- Reinstall OE end plug and end plug clip.



#### 4. Separator Plate Modification

d. The AFL balance orifice must be enlarged to .052" with Sonnax drill bit (Figure 2).

#### 4. Final Testing

Vacuum testing at the port(s) indicated holds the recommended minimum 18 in-Hg (Figure 3).

