

## Oversized Reverse Modulator Valve Kit

**Part No.**  
**56947J-53K**



- Spring
- Valve
- O-Rings (2) 1 Extra
- End Plug

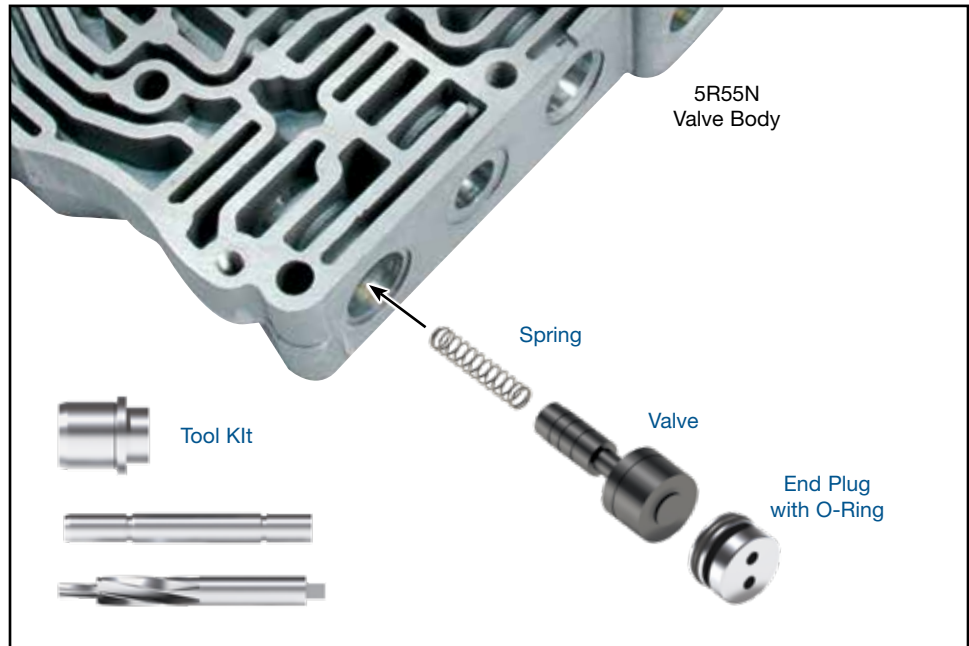
## Tool Kit

**Part No.**  
**F-56947J-TL53**



- 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).



### 1. Disassembly

- Remove and discard OE plug, valve and spring.
- Keep OE retainer for reuse.

### 2. Bore Reaming

Ream reverse modulator bore (for reaming instructions/reamer care, please visit [www.sonnax.com](http://www.sonnax.com)). Sonnax reaming tool kit **F-56947J-TL53** and **VB-FIX** are required for this operation.



**NOTE:** Use a wizzer-wheel or buffing pad to remove any burrs at the end plug area of the bore after reaming. Burrs at this location will damage the O-ring during installation.

### 3. Installation & Assembly

- Be certain all debris has been removed from the valve bore and valve body.
- Place Sonnax spring into Sonnax valve spring pocket and insert into bore spring end first.
- Place Sonnax O-ring into large groove on the Sonnax plug. Roll onto bench to size. Lubricate with lube-stick or assembly gel. Gently press into bore, O-ringed end first.
- Secure with OE retainer.

### 4. Final Testing

Vacuum testing at the ports indicated holds the recommended minimum 18 in-Hg.

