

### Oversized Lubrication Valve Kit



**Part No.**  
**139740-03K**

- Valve
- Piston
- Spring

### Tool Kit

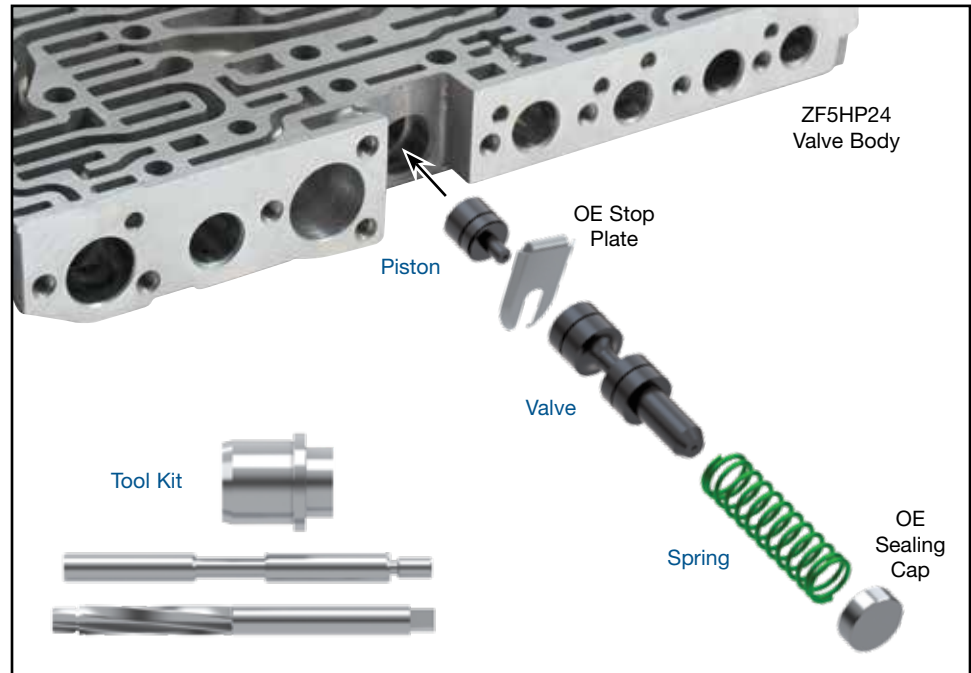


**Part No.**  
**F-139740-TL3**

- 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).

## ZF5HP24, ZF5HP24A



### 1. Disassembly

- Remove OE retaining clip and sealing cap; save both for reuse.
- Remove and discard OE spring and valve.
- Take note of installed direction of OE stop plate for reassembly reference, then remove stop plate and set aside for reuse.
- Remove and discard OE piston.

### 2. Bore Reaming

Ream lubrication valve bore (for reaming instructions/reamer care, please visit [www.sonnax.com](http://www.sonnax.com)). Sonnax reaming tool kit **F-139740-TL3** and **VB-FIX** are required for this operation.

### 3. Installation & Assembly

- Be certain all debris has been removed from valve bore and body.
- Install Sonnax piston, ensuring it bottoms in bore.
- Reinstall OE stop plate, orienting it as noted during disassembly.
- Install Sonnax valve with spring stem facing outward.
- Install Sonnax spring, ensuring it seats over valve spring guide.
- Reinstall OE sealing cap and retaining clip.

### 4. Final Testing

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

