

## Oversized Pressure Regulator Valve Kit

**Part No.**  
**225740-02K**

- Valve
- O-Rings (2) 1 Extra



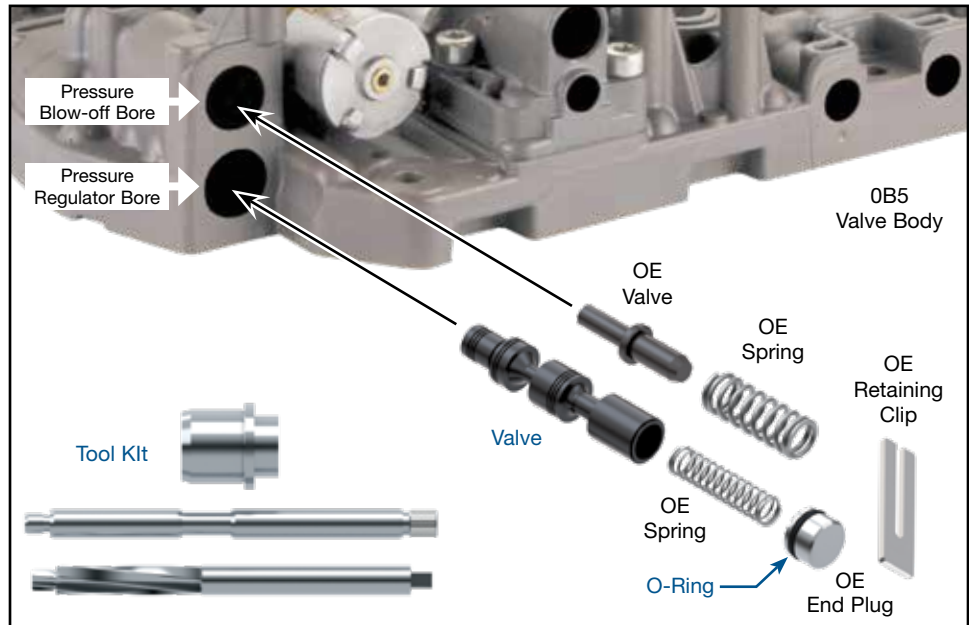
## Tool Kit

**Part No.**  
**F-225740-TL2**

- 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



**NOTE:** Retaining clip for pressure regulator valve train also secures the pressure blow-off valve train. Pressure blow-off valve train must be removed to facilitate reaming of the pressure regulator bore and reinstalled after reaming.

- Remove OE retaining clip, end plug and pressure regulator spring. Set aside for reuse.
- Remove and discard OE pressure regulator valve.
- Remove OE pressure blow-off spring and valve, set aside for reuse.

### 2. Bore Reaming

Ream pressure regulator bore (for reaming instructions/reamer care, please visit [www.sonnax.com](http://www.sonnax.com)). Sonnax reaming tool kit **F-225740-TL2** and **VB-FIX** are required for this operation.

### 3. Installation & Assembly

- Ensure all debris has been removed from valve bore and valve body.
- Reinstall OE pressure blow-off valve and spring.
- Install Sonnax pressure regulator valve.
- Reinstall OE pressure regulator spring, ensuring it seats in the valve spring pocket.
- Remove O-ring from OE end plug and install Sonnax O-ring. Lubricate and roll on clean bench to size O-ring into groove.
- Reinstall OE end plug and secure both valve trains with OE retaining clip.

### 4. Final Testing

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

