

Oversized Pressure Regulator Valve Kit

Part No.
144510-12K

- Valve
- Spring
- End Plug



Tool Kit

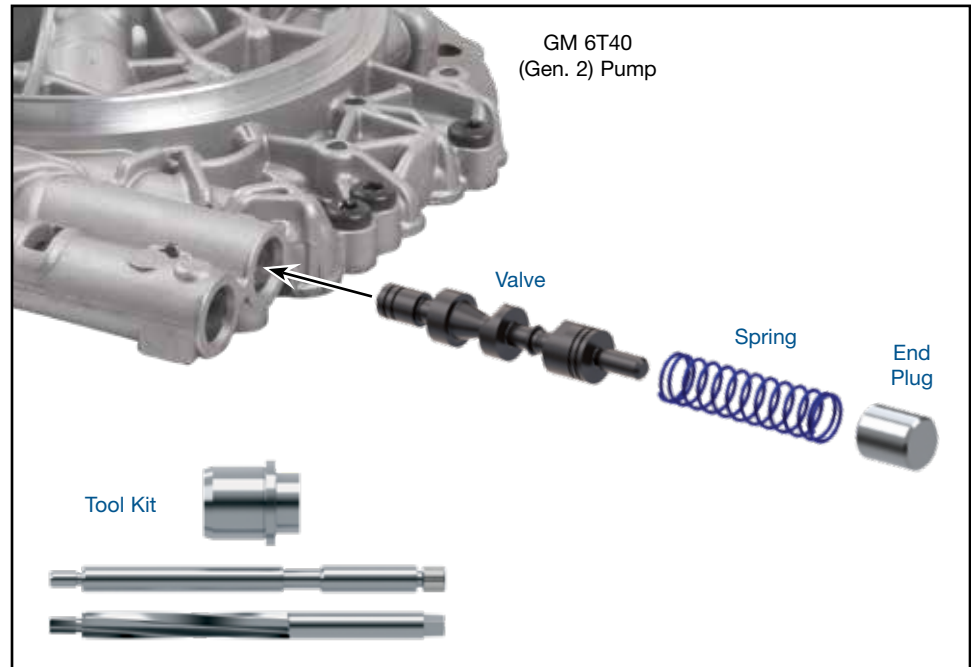
Part No.
F-144510-TL12C

- 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.

GM 6T30/40/45/50 (Gen.2)



1. Disassembly

- Remove OE retaining pin and save for reuse.
- Remove and discard OE end plug, spring, and pressure regulator valve.

2. Bore Reaming

Ream pressure regulator bore (for reaming instructions/reamer care, please visit www.sonnax.com). Sonnax reaming tool kit **F-144510-TL12C** and **VB-FIX** are required for this operation.



NOTE: Pump body has a raised boss above the machined surface. To clear this boss and establish alignment with the bore, the machined surface must be spaced 1/2” or more from **VB-FIX** base plate. Pressure plates or a machined spacer stacked under pump body work well for this purpose.

If pressure plates are used, the pump body securing clamp **MUST** be placed directly over the plate stack. Clamping on an unsupported area of the pump body or over the bore to be reamed will cause distortion and result in irreparable damage to pump body.

3. Installation & Assembly

- Be certain all debris has been removed from valve bore and pump body.
- Install Sonnax oversized pressure regulator valve, spring and end plug.
- Secure with OE retaining pin.

4. Final Testing

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

