

Actuator Feed Limit Valve Kit

Part No.

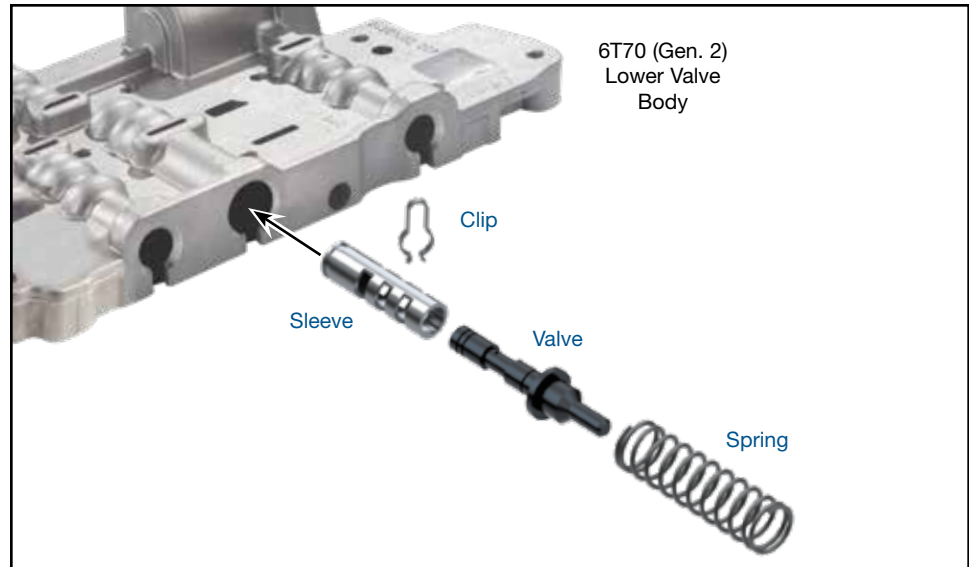
124740-33K

- Sleeve
- Valve
- Spring
- Clip
- Drill Bit* .062"
- Plugs* (2) 1 Extra
- Rivets* (2) 1 Extra

Patent No. 8,919,381

*NOTE: For separator plate, not shown.

GM 6T70/75/80 (Gen. 2)

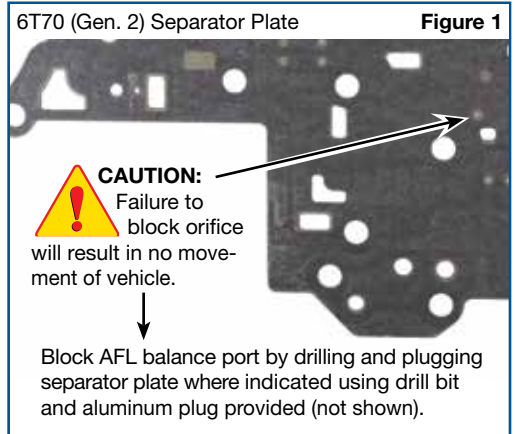


1. Disassembly


- a. Remove OE retainer and save for reuse.
- b. Discard OE spring and valve.

2. Drill & Plug Separator Plate Balance Orifice at Actuator Feed Limit Valve

- a. Using included drill bit, drill AFL balance orifice to .062" (Figure 1).
- b. If using straight plug, insert into orifice and peen on both sides of plate.
- c. If using optional small rivet, insert into orifice and using wire cutters, snip the stem end of the rivet if/as necessary to provide for a small head once peened in place. Peen the rivet in place on head side of plate also.
- d. After peening on both sides of the plate, ensure plate will still fit flush on mating surfaces.



3. Installation & Assembly

- a. Insert Sonnax sleeve/valve assembly into bore. Sleeve should be inserted with end grooves inboard. Valve should be inserted with spring stem outboard.
- b. Secure sleeve by installing Sonnax clip into sleeve groove at inboard port.
 -  **CAUTION:** Ensure supplied retainer clip is fully seated in AFL sleeve groove after installation.
- c. Install Sonnax spring and secure components into the bore with OE retainer.

4. Final Testing

Due to the design changes on the Sonnax sleeve and valve, vacuum testing at the inboard port is not a valid sealing test.