

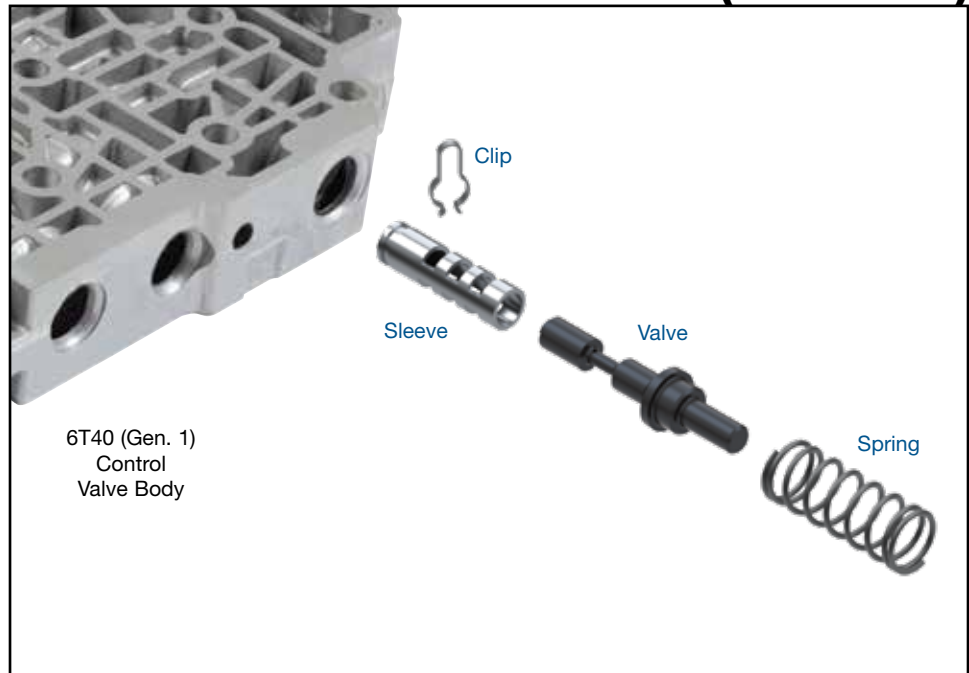
GM 6T30/40/45/50 (Gen. 1 & 2), 6T35/31/41/46/51 (Gen. 3 6T40)

Actuator Feed Limit Valve

Part No.

144740-39K

- Sleeve
- Valve
- Spring
- Clip
- Drill Bit Not Shown
- Plugs (2) 1 Extra, For Separator Plate, Not Shown

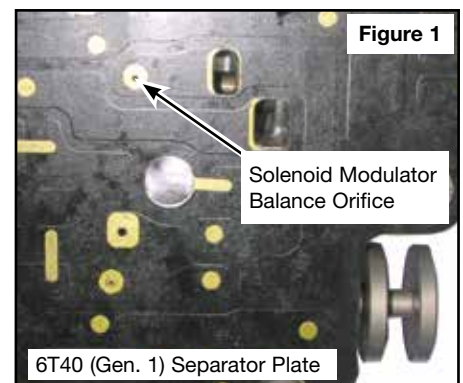


1. Disassembly

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

2. Drill & Plug Separator Plate Balance Orifice at Solenoid Modulator Valve

- a. Using included drill bit, drill solenoid modulator balance orifice to .062" (**Figure 1**).
- b. Insert included .062" aluminum plug into orifice and peen shut.



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 into bore by installing Sonnax clip into sleeve groove at inboard port.
- c. Install Sonnax spring and secure all 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.