

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

Actuator Feed Limit Valve

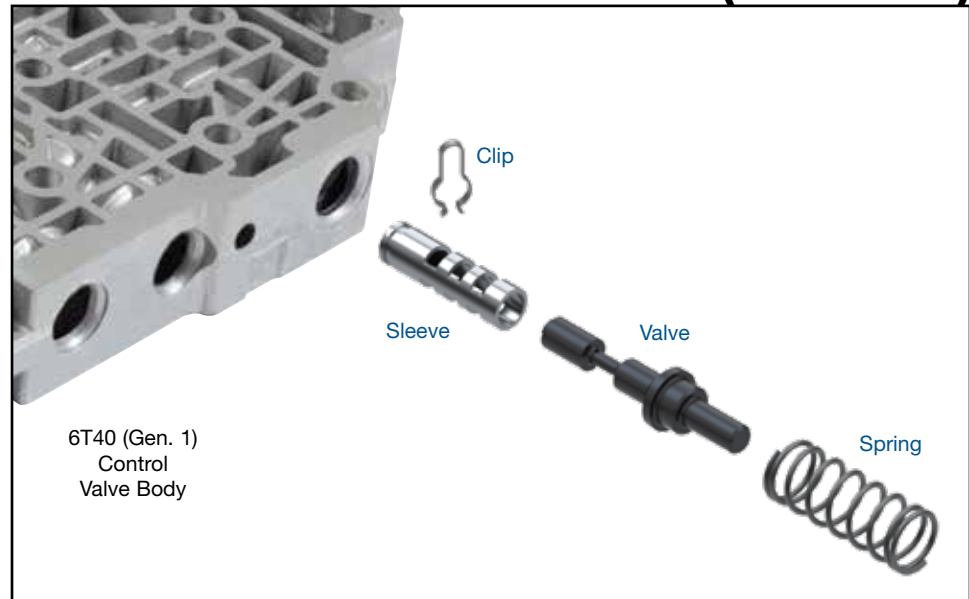
Part No.

144740-39K

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

Patent No. 8,919,381

*NOTE: For separator plate, not shown.

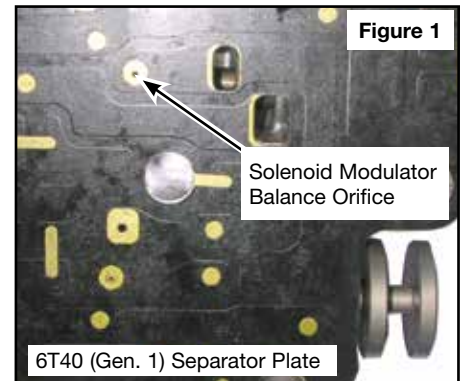


1. Disassembly

- 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. If using straight plug, insert into orifice andpeen 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 into bore 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 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.