

## Oversized Solenoid Modulating Pressure Blow-Off Valve



**Part No.**  
**99740-03**

- Valves (3)

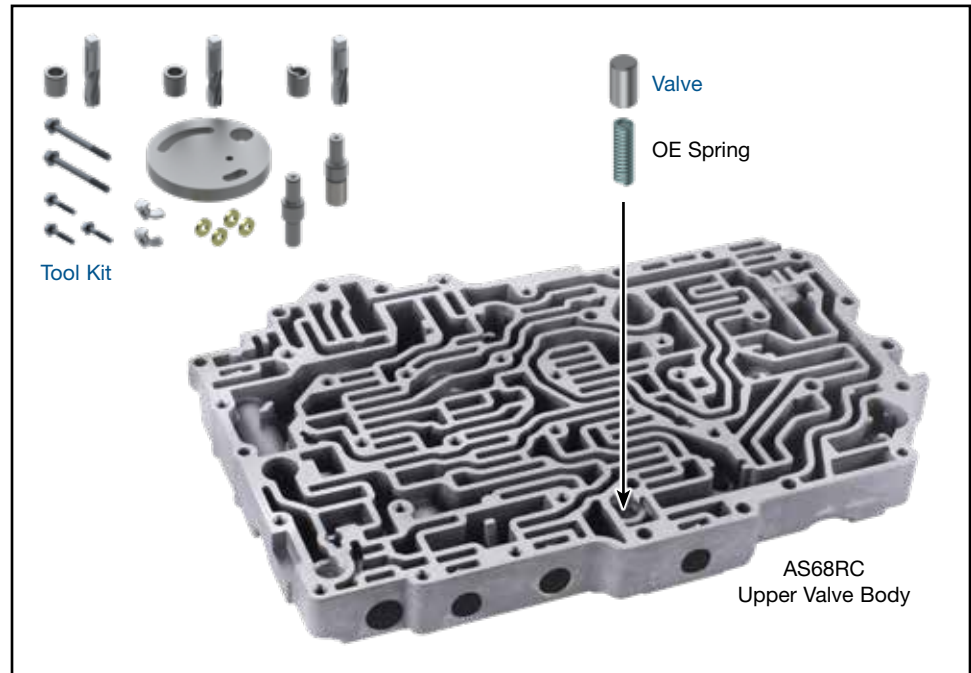
## Tool Kit

**Part No.**  
**99740-TL4**

- Reamers (3)
- Reamer Jigs (3)
- Jig Plate
- Guide Pins (2)
- Bolts, M5 (2)
- Bolt, M6
- Bolts, M5 (2)
- Washers (4)
- Wing Nuts (2)

Short  
Short  
Long

## Aisin Seiki AS68RC



### 1. Disassembly

- Remove and discard OE solenoid modulating pressure blow-off valve.
- Retain OE solenoid modulating pressure blow-off spring for reuse.

### 2. Bore Reaming (Figure 1)

- Place upper valve body casting on bench with OE solenoid modulating pressure blow-off valve bore facing upwards.

**NOTE:** Recommend using two 1" parallel blocks under the two machined flat areas of the valve body for support while reaming.

- Position Sonnax jig plate using one short M5 bolt and one short M6 bolt along with washers to hold it in place where indicated, do not tighten bolts at this time.

- Recommend using an appropriate plate and clamp to secure casting to bench, ensuring not to damage any of the surfaces of the casting. The plate must not contact any of the valve bore protrusion's/boss's.

- Insert Sonnax guide pin **99740-GP3** into the jig plate with small diameter facing up.

- Slide Sonnax guide pin through jig plate and into casting bore.

- Once guide pin and jig plate are aligned with bore to be reamed, securely tighten two bolts. Ensure jig plate is tightly held in place while allowing guide pin to stroke freely in casting bore.

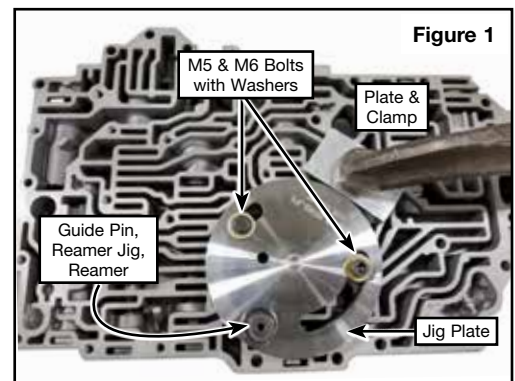


Figure 1

## 2. Bore Reaming (continued)

- g. Remove guide pin and insert Sonnax reamer jig **99740-RJ8**, protrusion facing down, rotate jig until protrusion drops into bore pocket. Soak the bore and reamer with cutting fluid (Mobilmet S-122, Lubegard®Bio-Tap, Tap Magic™, etc). For best results, provide a continuous flow of water-soluble cutting fluid (i.e. Mobilmet S-122) during the reaming process.
- h. Insert Sonnax reamer **99740-RM8** and ream bore with steady, clockwise rotation. Once reaming is complete, spin the reamer a few more times to burnish and improve surface finish (for full reaming instructions/reamer care, please visit [www.sonnax.com](http://www.sonnax.com)).
- i. If necessary, deburr bore entrances slightly to facilitate assembly of Sonnax oversized solenoid modulating pressure blow-off valve.
- j. Thoroughly clean the casting after reaming.

## 3. Installation & Assembly

- a. Be certain all debris has been removed from the valve bore and valve body.
- b. Install OE spring into the Sonnax oversized solenoid modulating pressure blow-off valve.
- c. Install spring/valve assembly into bore, spring side downward.

## 4. Final Testing

Vacuum testing at the port(s) indicated holds the recommended minimum 24 in-Hg (**Figure 2**).

