

Oversized Linear Solenoid Feed Dampener Valve

Part No.
99740-05K



- Valves (3)

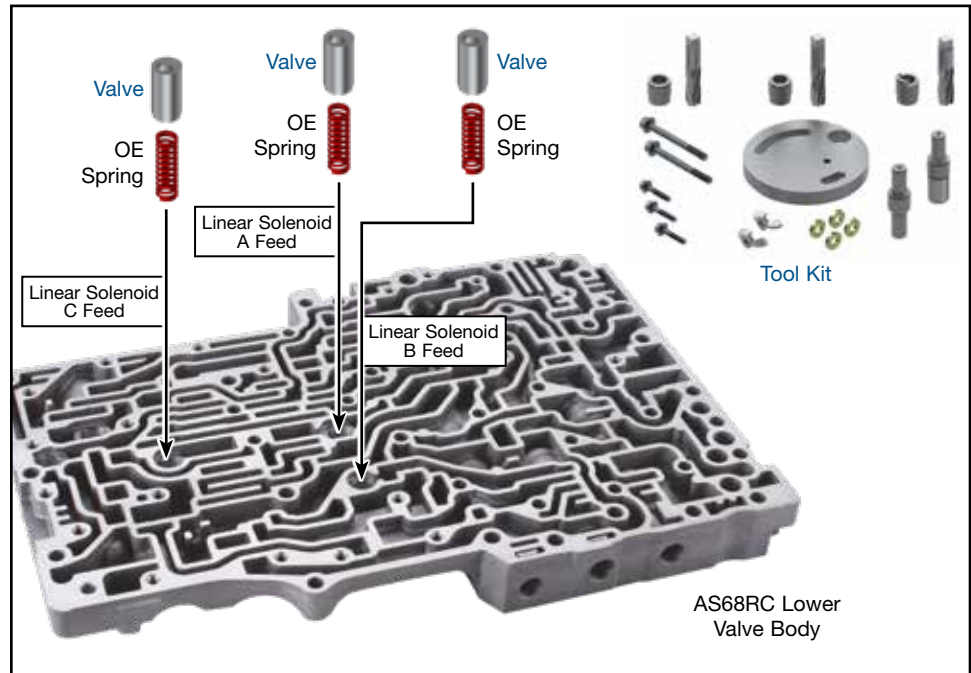
Tool Kit

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



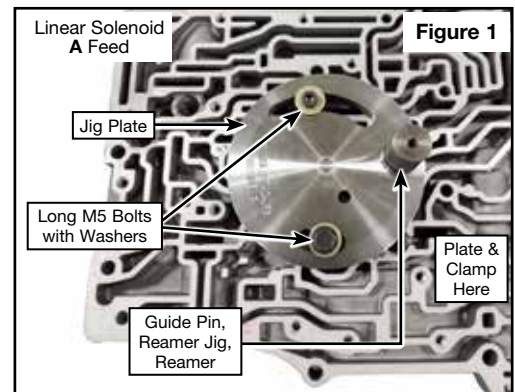
1. Disassembly

- Remove and discard OE linear solenoid feed dampener valves in lower valve body.
- Retain OE linear solenoid feed dampener piston springs for reuse.

2. Bore Reaming

- Place the lower valve body casting on bench with the OE linear solenoid feed dampener bores facing upwards.

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



- Position Sonnax jig plate and use Sonnax long M5 bolts, along with washers and wing nuts to hold it in place where indicated, do not tighten bolts at this time (**Figure 1**).
- 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 dampener bore protrusion's/boss's.
- Insert Sonnax guide pin **99740-GP5** into the jig plate with the large end down.
- 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 bolts. Ensure jig plate is tightly held in place while allowing guide pin to stroke freely in casting bore.

Bore Reaming (continued)

- g. Remove guide pin and insert Sonnax reamer jig 99740-RJ7 into the jig plate with the large end down.
- h. Insert Sonnax reamer 99740-RM7 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).
- i. Repeat steps 2-8 for remaining solenoid B & C feed dampeners, using Sonnax short M5 bolts with washers (Figures 2 & 3).
- j. If necessary, deburr bore entrances slightly to facilitate assembly of the oversized linear solenoid feed dampener.
- k. Thoroughly clean the casting after reaming.

3. Installation & Assembly

- a. Be certain all debris has been removed from the dampener bore and valve body.
- b. Install OE spring into Sonnax oversized solenoid feed dampener valve.
- c. Install the spring/valve assembly into bore, spring side upward.

4. Final Testing

Vacuum testing at the port(s) indicated holds the recommended minimum 24 in-Hg (Figure 4).

