

## Oversized Low Overrun Valve Kit

**Part No.**  
**77754-62K**



- Plug
- Valve
- Spring

## Tool Kit

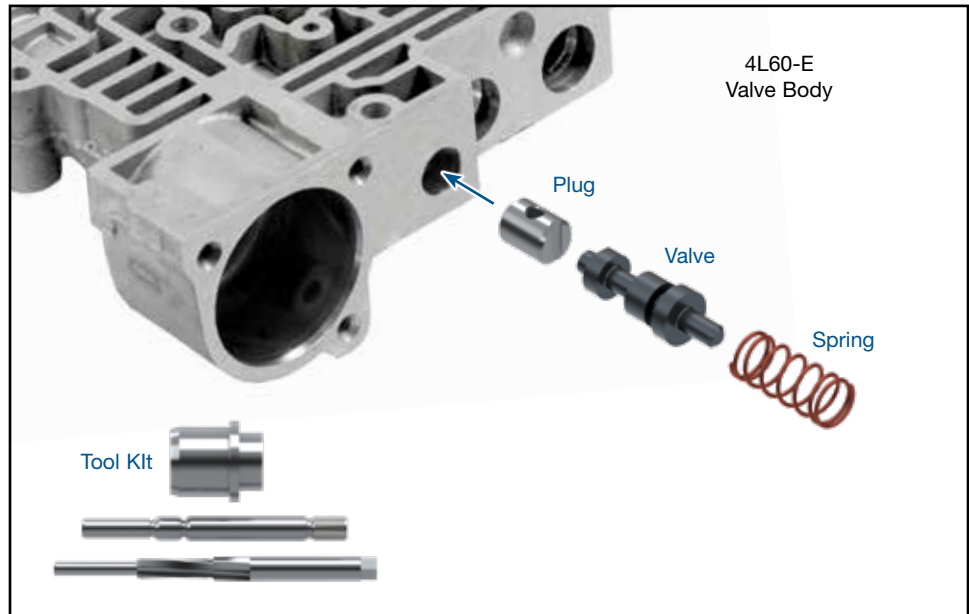
**Part No.**  
**F-77754-TL62**



- Reamer
- Reamer Jig
- Guide Pin

**NOTE:** Sonnax "F-Tool" kits designed to service a specific bore require the VB-FIX, a self-aligning valve body reaming fixture. More information and instructions can be found online at [www.sonnax.com](http://www.sonnax.com).

## GM 4L60-E, 4L65-E, 4L70-E



### 1. Disassembly

- Remove the OE forward accumulator cover and screws, save for reuse. It is recommended that the forward accumulator spring, piston and pin be removed and saved for reuse.
- Remove and discard low overrun valve and spring.
- Remove rolled spring pin and save for reuse. Remove bore plug and discard.
- Remove forward abuse valve and spring, save for reuse.

### 2. Bore Reaming

Ream low overrun bore (for reaming instructions/reamer care, please visit [www.sonnax.com](http://www.sonnax.com)). Sonnax reaming tool kit **F-77754-TL62** and **VB-FIX** are required for this operation.

### 3. Installation & Assembly

- Be certain all debris has been removed from the valve bore and valve body.
- Reinstall OE forward abuse valve and spring.
- Install Sonnax bore plug and retain with the OE rolled spring pin.
- Install Sonnax valve and Sonnax spring.
- If removed, reinstall the OE forward accumulator piston, pin and spring then reinstall OE cover and screws.

### 4. Final Testing

Vacuum testing at the port(s) indicated holds the recommended minimum 14" and 16" in-Hg.

