

Oversized Pressure Regulator Valve Kit

Part No.
168740-06K



- Valve
- Spring
- End Plug
- O-Rings (2) 1 Extra

Tool Kit

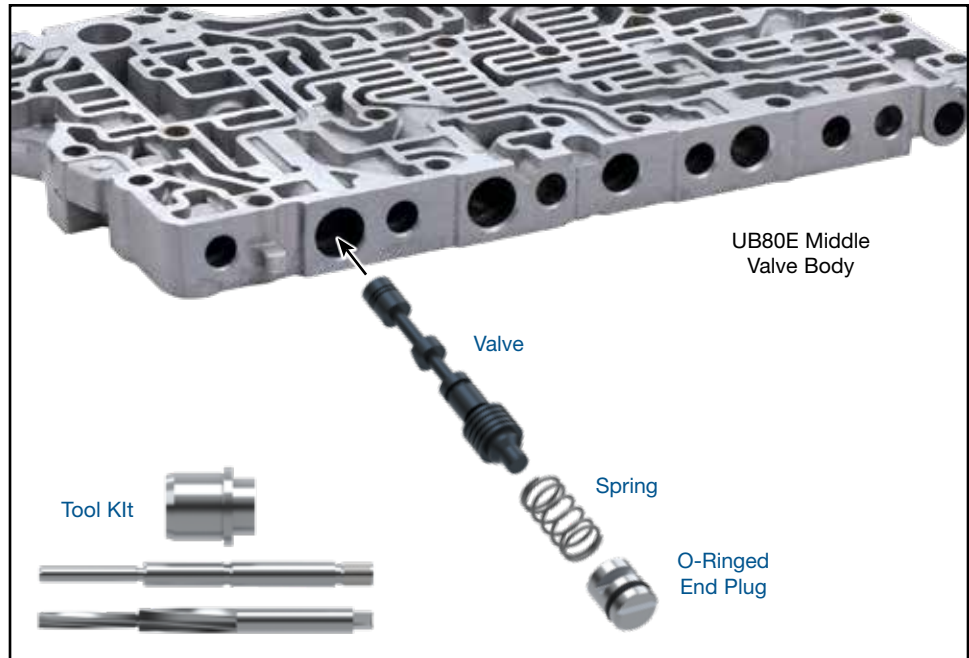
Part No.
F-168740-TL6



- 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.

Toyota/Lexus UA80E, UA80F, UB80E, UB80F



1. Disassembly

- Remove OE retaining clip and save for reuse.
- Remove OE end plug, spring and valve and discard.

2. Preparation

This valve body is a low profile design and requires a spacer above the **VB-FIX** base plate in order to establish alignment with the bore. A 1/8"-1/2" thick metal plate large enough for adequate casting support should be used under the valve body before clamping in place.

3. Bore Reaming

Ream pressure regulator valve bore (for reaming instructions/reamer care, please visit www.sonnax.com). Sonnax reaming tool kit **F-168740-TL6** and **VB-FIX** are required for this operation.

4. Installation & Assembly

- Be certain all debris has been removed from the valve bore and valve body.
- Install Sonnax oversized valve and spring.
- Install Sonnax O-ring into shallow groove of Sonnax end plug. Lubricate O-ringed end plug with Sonnax Slippery Stick **O-LUBE**. Roll on bench to size the O-ring into the groove.
- Carefully insert Sonnax O-ringed end plug into the bore just far enough to reinstall the OE retaining clip.
- Reinstall OE retaining clip.

5. Final Testing

Vacuum testing at the port(s) indicated holds the recommended minimum 18 in-Hg (Figure 1).

