

**Oversized Clutch Boost Valve**



**Part No.**  
**104740-01**

**NOTE:** This valve is sold individually, but can be used in three bore locations:  
"B" Stamp: 4-5-6 Clutch Boost Valve  
"F" Stamp: 3-5 Reverse Clutch Boost Valve  
"K" Stamp: 1-2-3-4 Clutch Boost Valve

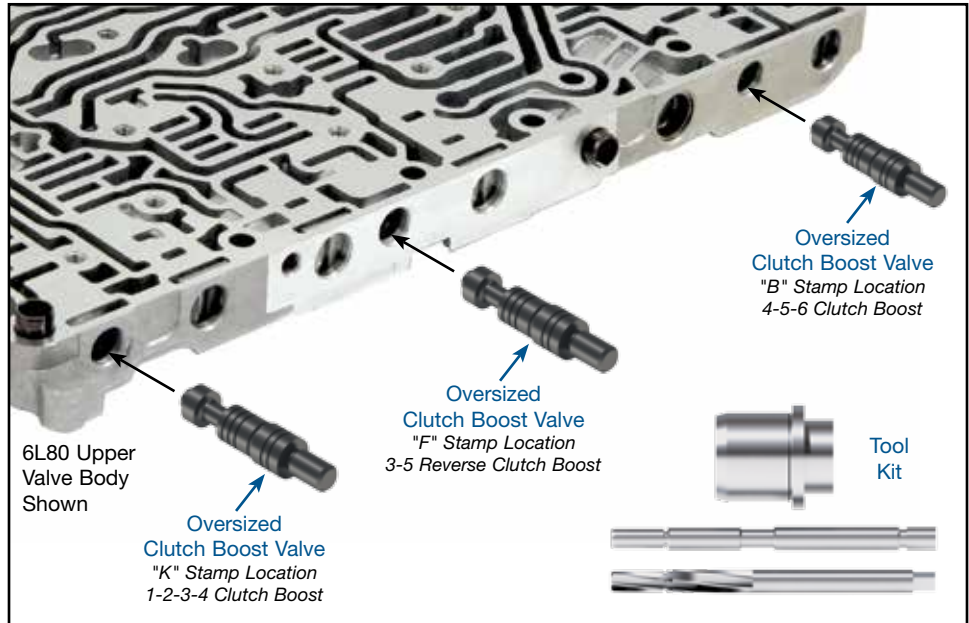
**Tool Kit**



**Part No.**  
**F-104740-TL**

- 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).



**1. Disassembly**

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

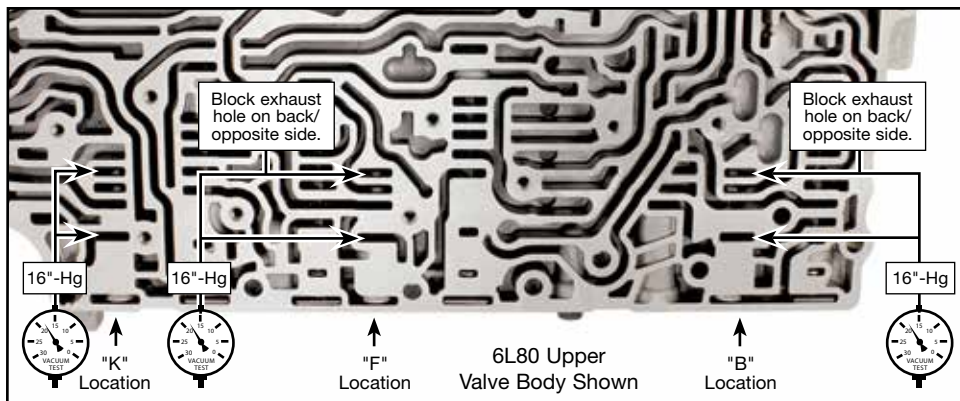
**2. Bore Reaming**

Ream bore (for reaming instructions/reamer care, please visit [www.sonnax.com](http://www.sonnax.com)). Sonnax reaming tool kit **F-104740-TL** and **VB-FIX** are required for this operation.



**NOTE:** Valve body is low-profile and must be secured 1/2" above the **VB-FIX** base plate in order to establish alignment with the bore. Pressure plates stacked under valve body work well for this purpose.

If pressure plates are used, the valve body securing clamp **MUST** be placed directly over the plate stack. Clamping on an unsupported area of the valve body or over the bore to be reamed will cause distortion and result in irreparable damage to valve body.



**3. Installation & Assembly**

- Install Sonnax valve (as shown in main photo) followed by OE spring.
- Install OE retaining clip.

**4. Final Testing**

Vacuum tests at the ports indicated hold a minimum of 16 in-Hg. Valve body casting is stamped with "lettered" locations on the far side of the core. When testing "B" or "F" location, block exhaust hole on back side of core.