

Oversized Pressure Regulator Valve Kit

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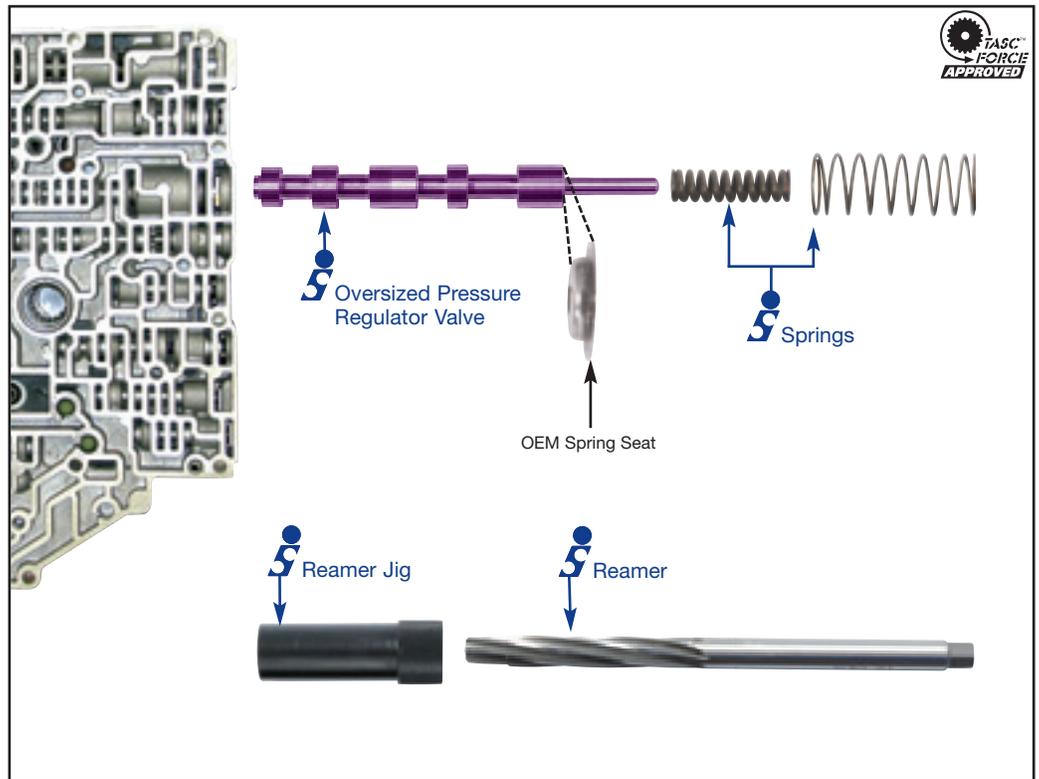
96206-10K

1 Oversized Pressure Regulator Valve
2 Springs



96206-TL2

1 Reamer
1 Reamer Jig



Wet Air Test

Place a small amount of oil into the balance line port. Follow with low air pressure. There should be minimal/no leakage past the valve spool and out the neighboring exhaust port.

Reaming and Installation Instructions

Prep and Set-up

1. Remove all components from the bore. Discard the OEM valve and 2 springs.
2. Clean the bore thoroughly in a solvent tank.
3. Securely clamp the housing to the bench, making sure not to clamp directly over the bore to be reamed.
4. Insert the reamer jig into the bore.
5. 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.
6. Gently insert the reamer through the jig and into the bore until the cutting tip contacts the first bore to be reamed, as shown in the illustration.
7. Select the correct sized socket to fit the square shank of the reamer, and attach it to a wobble/swivel socket drive.

Reaming

1. The reamer should be turned either by hand using a speed handle or by a low rpm, high torque air drill regulated to a maximum of 200 rpm.
2. The reaming action should be clockwise in a smooth and continuous motion, at 60-200 rpm. The reamer should actually pull itself through the bore, so little or no forward force should be applied.
3. Continue reaming until it bottoms in the bore. The approximate reaming time is 5 minutes.

Finish and Clean-up

1. Using low air pressure, blow the chips free before removing the reamer.
2. To remove the reamer, turn clockwise while slowly pulling outward on the reamer.
3. Remove any remaining debris from the bore with low air pressure and clean in a solvent tank.
4. Examine the bore after cleaning for surface finish, debris, and burrs. Flashing and burrs on the exit side of casting bores can be carefully removed with a small piece of Scotchbrite™ on the end of a long wire.
5. Clean the reamer after each use and store in its protective tube.

Cautions and Suggestions

1. Turning the reamer backward will dull it prematurely.
2. Pushing on the reamer will result in poor surface finish and inadequate and sporadic material removal.
3. Never use a crescent wrench, ratchet or pliers to turn the reamer.

Installation

1. Install the OEM spring seat over the stem of the replacement valve, as shown in the illustration.
2. Place the small bumper spring included in the kit over the valve stem.
3. Push this spring/valve/seat assembly into the reamed bore, stem outward.
4. Install the included larger regulating spring into the bore, flush with the spring seat.
5. Inspect boost valve and sleeve for wear. Reinstall OEM boost valve and sleeve or replace with Sonnax parts **96201-01K**, **-08K**, **-12K** or **-13K** into the bore as illustrated. Ensure the bumper spring nestles into the spring pocket on the boost valve, and the regulating spring slides over the sleeve snout.

