

Adapter Plate Kit



Part No.

F-85755-TL3PL

- Adapter Plate
- Screws (2)
- Washers (2)

NOTE: Use of this adapter plate is strongly recommended to secure upper rear valve body to **VB-FIX** for installation of **85755-03K** or **85755-09K**.

Also Available

Oversized Pressure Modulator Valve Kit **85755-03K**

Tool Kit **F-85755-TL3**

For 85755-03K

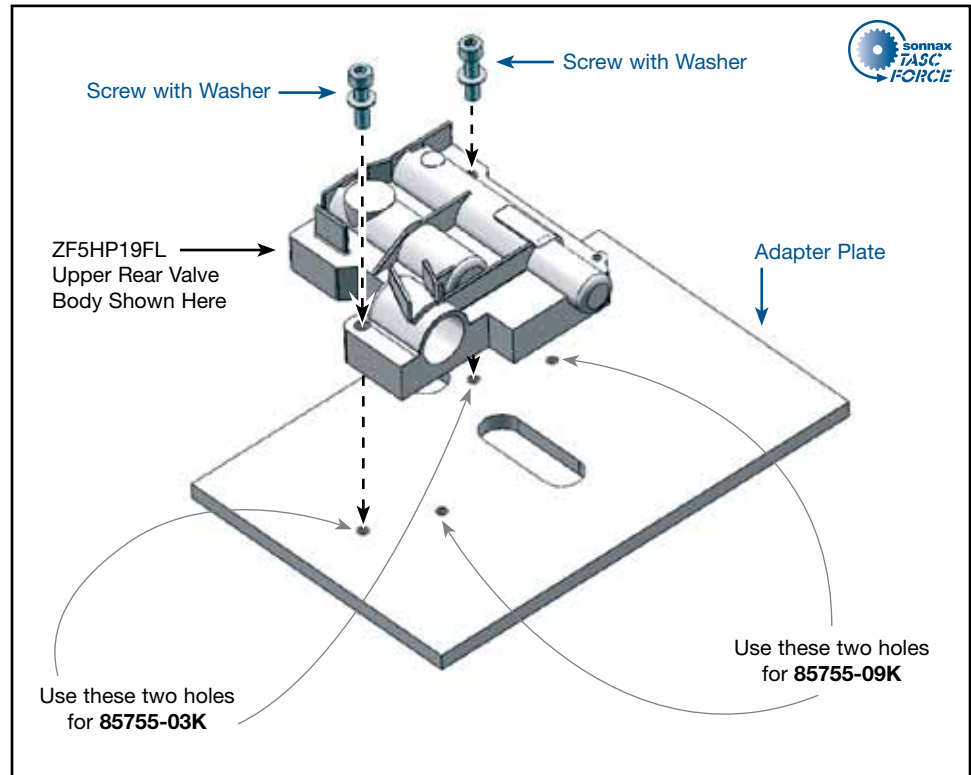
Oversized Pressure Reduction Valve Kit **85755-09K**

Tool Kit **F-85755-TL9**

For 85755-09K

Valve Body Reaming Fixture **VB-FIX**

ZF5HP19, ZF5HP19FL, ZF5HP19FLA



1. Clearly identify the valve bore to be reamed and use the appropriate screw holes for that bore and associated Sonnax kit as shown above.
2. Mount the valve body section to the plate using the two Sonnax washers and screws. Be sure the screws do not protrude beyond flush with the back of the plate. Some trimming of the screw length may be necessary.
 - Be sure the valve body is securely fastened to the plate. Any movement during the reaming process will scrap the valve body.
 - Make sure that the bore to be reamed is over the large hole and slot in the adapter plate.
3. Place the Sonnax adapter plate with the mounted valve body section onto the Sonnax reaming fixture **VB-FIX**. Clamp the Sonnax adapter plate to the **VB-FIX**. Do not clamp on the valve body.
4. Align and secure the valve body and Sonnax adapter plate to the fixture according to the **VB-FIX** instructions, using the guide pin and reamer jig from either Sonnax tool kits **F-85755-TL3** or **F-85755-TL9**.
5. Turn the **VB-FIX** over 180° to access the length of the bore for lubricating and flushing during the reaming operation.
6. Follow the reaming, cleaning and assembly instructions included with Sonnax valve kits **85755-03K** or **85755-09K**.

Oversized Lockup Control Valve Kit

Part No.
47740-30K



- Control Valve
- Plunger Valve
- Plunger Sleeve

Tool Kit

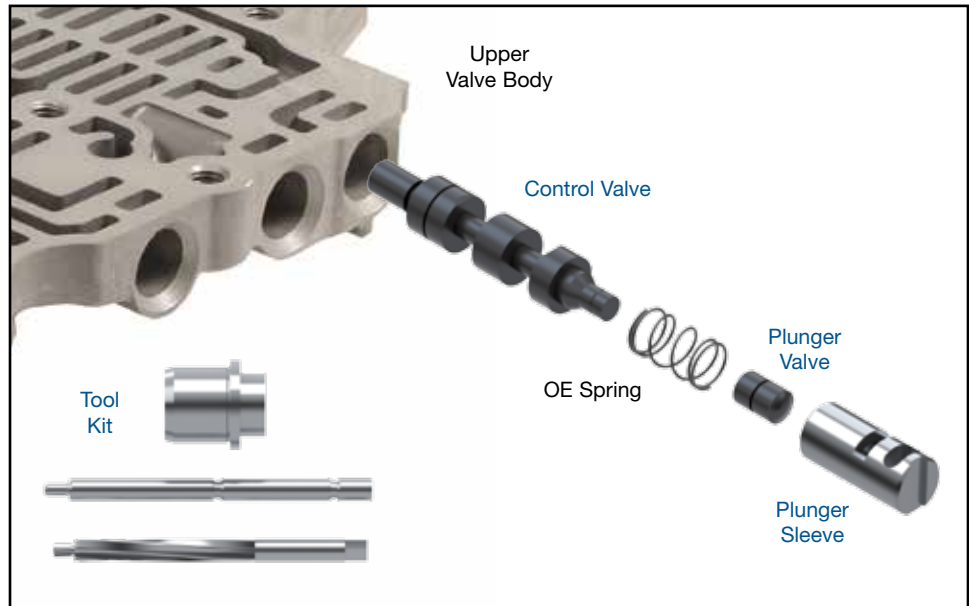
Part No.
F-47740-TL30



- Reamer
- Reamer Jig
- Guide Pin

NOTE: This tool kit can also be used to install oversized lockup control valve kit 47740-31K.

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.



1. Disassembly

- Remove OE retainer and set aside for reuse.
- Remove and discard OE plunger/sleeve assembly and lock-up control valve.
- Remove and save OE spring for reuse.

2. Bore Reaming



NOTE: Valve body is low-profile and must be secured 1/4" above the **VB-FIX** base plate in order to establish alignment with the bore. Sonnax adapter plate kit **F-85755-TL3PL** can be used for this function; pressure plates stacked under the valve body also work well.

If pressure plates are used, the valve body securing clamps **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.

Ream lockup control valve bore (for reaming instructions/reamer care, please visit www.sonnax.com). Sonnax reaming tool kit **F-47740-TL30** 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.
- Install Sonnax lockup control valve with spring stem facing out.
- Install OE spring followed by Sonnax plunger valve/sleeve assembly and OE retainer.

4. Final Testing

A vacuum test at the port indicated holds 18 in-Hg or more.

