

Oversized Lubrication Valve Kit



Part No.
85755-07K

- Oversized Lubrication Valve
- Oversized Plunger Valve

NOTE: Also fits VW/Audi 01V applications.

IMPORTANT: OE valve spool diameters must match dimensions noted in illustration. This kit cannot be used to repair valve bodies with valves of other sizes.

Tool Kit

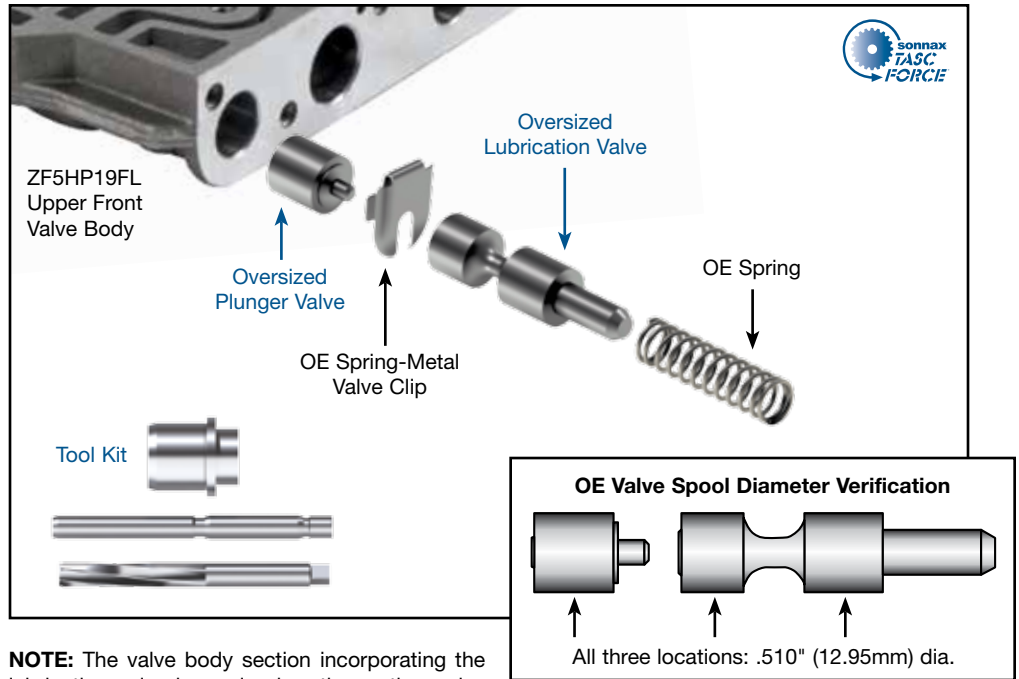


Part No.
F-85755-TL7

- 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.

ZF5HP19, ZF5HP19FL, ZF5HP19FLA



NOTE: The valve body section incorporating the lubrication valve bore also has three other valve bores. Removal of the end plate will release the valve trains in all four bores. Sonnax recommends removing all valve trains to thoroughly clean valve body after completing the lubrication bore reaming process. Do not mix up, discard or lose components from the valve trains. Return the valve train components from the other three bores to their original bores, in the order they were found.

1. Disassembly

- Loosen the fasteners and remove the end plate from the valve body section.
- Extract the OE lubrication valve and spring from the bore.
- Pull the OE spring-metal clip from the worm-track cavity.
- Extract the OE plunger valve from the bore.
- Measure the OE spool diameters before proceeding. This kit can only be used if sizes match above illustration.
- Keep the OE spring, spring-metal clip and end plate with screws for re-use. Discard both OE valves in the lubrication valve bore.

2. Bore Preparation

- Clean the bore thoroughly in a solvent tank.
- Generously lubricate the bore and reamer with cutting fluid (i.e. 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.
- The reamers should be turned using a low RPM, high-torque air drill regulated to a maximum of 200 RPM.
- Examine the bore after cleaning for surface finish, debris and burrs. Flashing and burrs on the exit side of land and in bores must be carefully removed. A small piece of Scotch-Brite™ material attached to a wire and powered with a drill motor is ideal for the task. Scotch-Brite™ is a very abrasive material and all residual debris must be cleaned to ensure particles do not migrate or remain imbedded into the surface. Post cleaning involves several progressive steps with solvent on a lint-free rag.

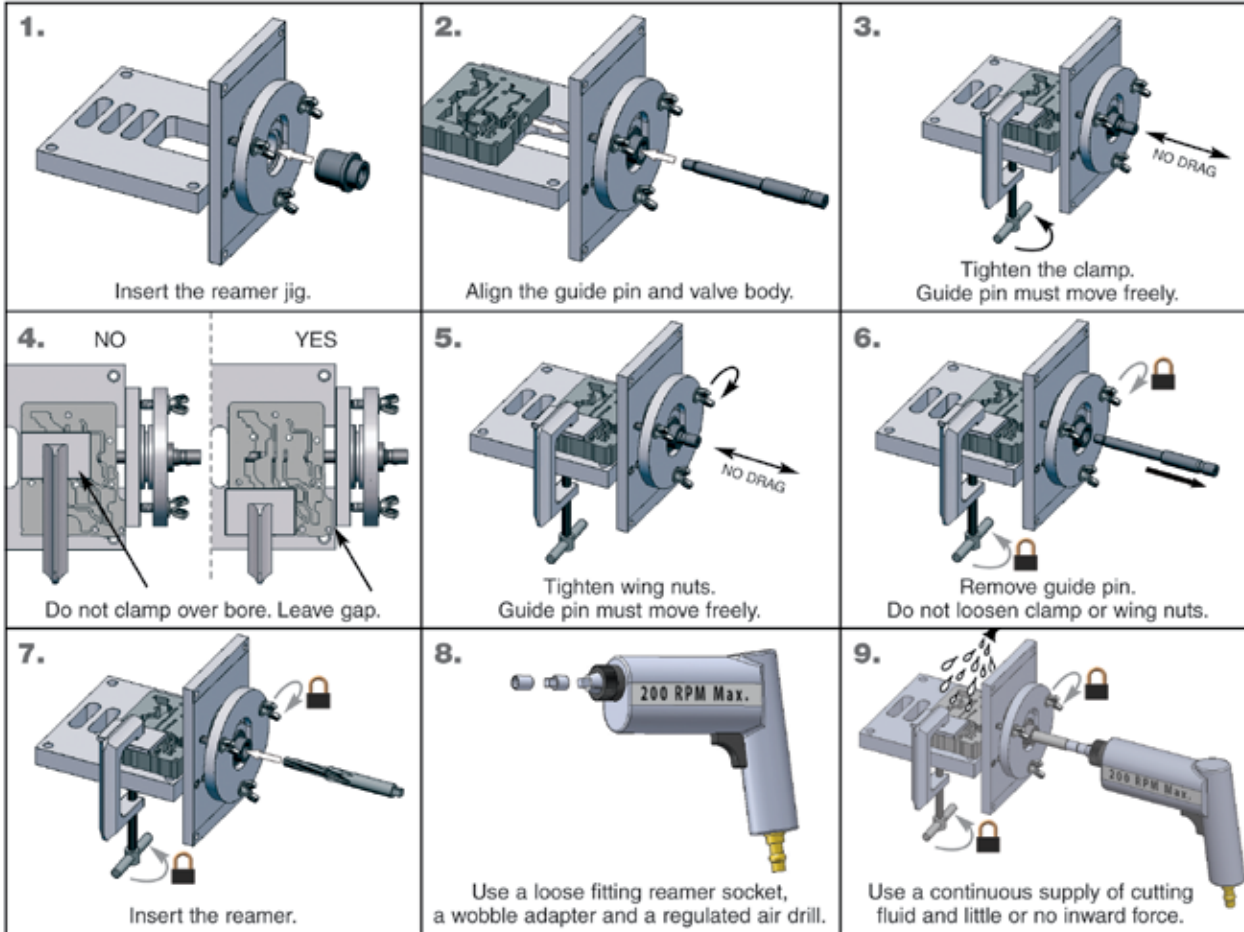
CAUTIONS AND SUGGESTIONS:

- Turning the reamer backward will dull it prematurely.
- Pushing on the reamer will result in poor surface finish and inadequate and sporadic material removal.
- A dull reamer will cut a smaller hole. Reamers can be sharpened, but should only be done by a professional tool sharpener. Actual life of a Sonnax reamer before resharpening or replacing averages 50-70 bores.

- Never use a crescent wrench, ratchet or pliers to turn the reamer.

3. Bore Reaming

Use the associated “F-Tool” F-85755-TL7 kit and VB-FIX reaming fixture as illustrated below to ream the bore.



4. Installation & Assembly

- Insert the Sonnax oversized plunger valve, oriented as shown in the main photo, and push it to the bottom of the bore.
- Orient the OE spring-metal clip as shown in the main photo and insert it into the indicated “worm-track” cavity (**Figure 1**). Be sure the Sonnax oversized plunger valve is inboard of the clip and the small diameter stem on this valve can pass freely through the opening in the clip.
- Orient the Sonnax oversized lubrication valve as shown in main photo and insert it into the bore.
- Insert the OE spring for the lubrication valve.
- Check that the OE valve trains in the three neighboring bores are correctly installed. Then install the OE end plate for the valve body section and retain with the OE screws.

5. Final Testing

Vacuum tests at the ports indicated hold the recommended minimum of in-Hg.

