

Oversized Pressure Regulator Valve Kit

Part No.
144510-03K

- Valve
- Spring
- End Plug



Tool Kit

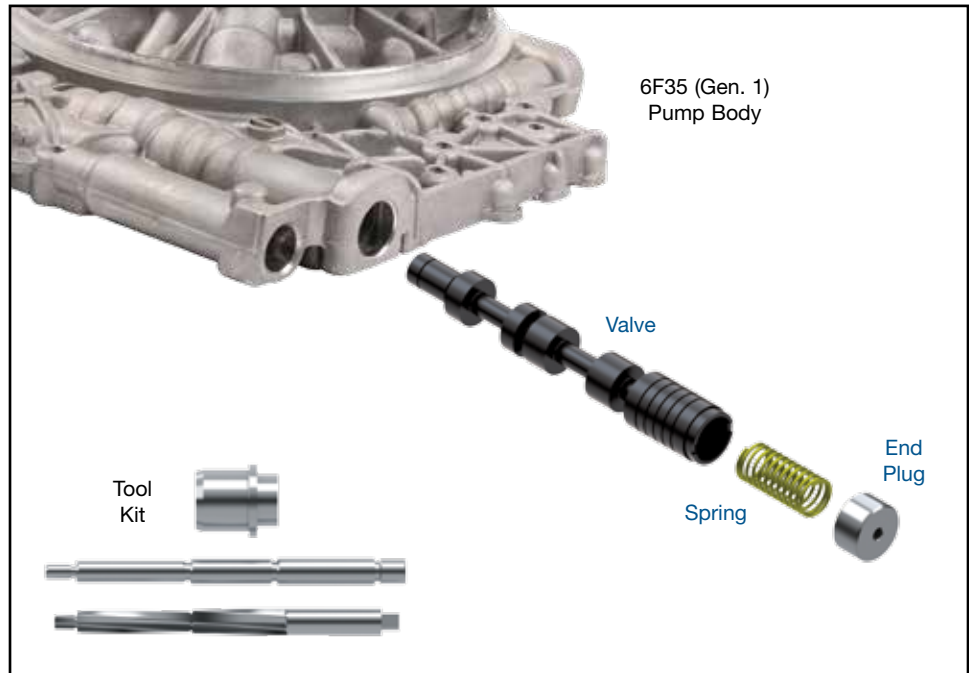
Part No.
F-144510-TL3C

- Reamer
- Reamer Jig
- Guide Pin



Carbide

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.



1. Disassembly

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

- Insert Sonnax spring into spring pocket of Sonnax valve. Install valve/spring assembly with spring facing outward.
- Install Sonnax end plug and secure with OE retaining clip.

2. Bore Reaming



NOTE: Pump body is low-profile and must be secured 3/8" above the VB-FIX base plate in order to establish alignment with the bore. Pressure plates stacked under pump body work well for this purpose.

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

Ream pressure regulator bore (for reaming instructions/reamer care, please visit www.sonnax.com). Sonnax reaming tool kit F-144510-TL3C and VB-FIX are required for this operation.

3. Installation & Assembly

- Be certain all debris has been removed from valve bore and pump body.

4. Final Testing

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

