

**Oversized 3-5-R
Clutch Regulator
Valve Kit**



Part No.
124740-21K

- Valve
- End Plug

NOTE: Replaces 1.83 ratio OE valve with .335" dia. small spool.

Tool Kit

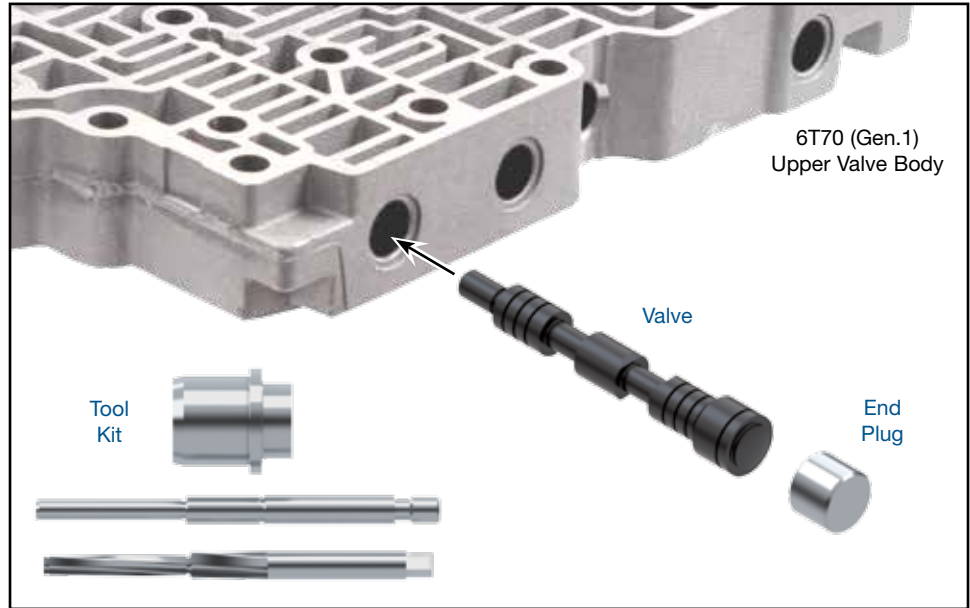


Part No.
F-124740-TL21

- 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.

Ford 6F50, 6F55; GM 6T70 (Gen. 1), 6T75 (Gen. 1)



NOTE: This kit replaces OE valve with .335" dia. small spool only (Figure 1).

1. Disassembly

- Remove OE retainer, end plug, regulator valve and spring.
- Set aside retainer and spring for reuse; discard OE end plug and regulator valve.

2. Bore Reaming

Ream 3-5-R clutch regulator bore (for reaming instructions/reamer care, please visit www.sonnax.com). Sonnax reaming tool kit **F-124740-TL21** and **VB-FIX** are required for this operation.

3. Installation & Assembly

- Be certain all debris has been removed from valve bore and body.
- Install OE spring, followed by Sonnax valve. Ensure spring fits over valve spring guide.
- Install Sonnax end plug.
- Secure with OE retainer.

4. Final Testing

Vacuum testing at the port(s) indicated holds the recommended minimum 20 in-Hg (Figure 2).

