

Oversized Forward Clutch Regulator Valve Kit



Part No.
126740-13K

- Valve
- Spring
- End Plug
- O-Rings (2)

1 Extra

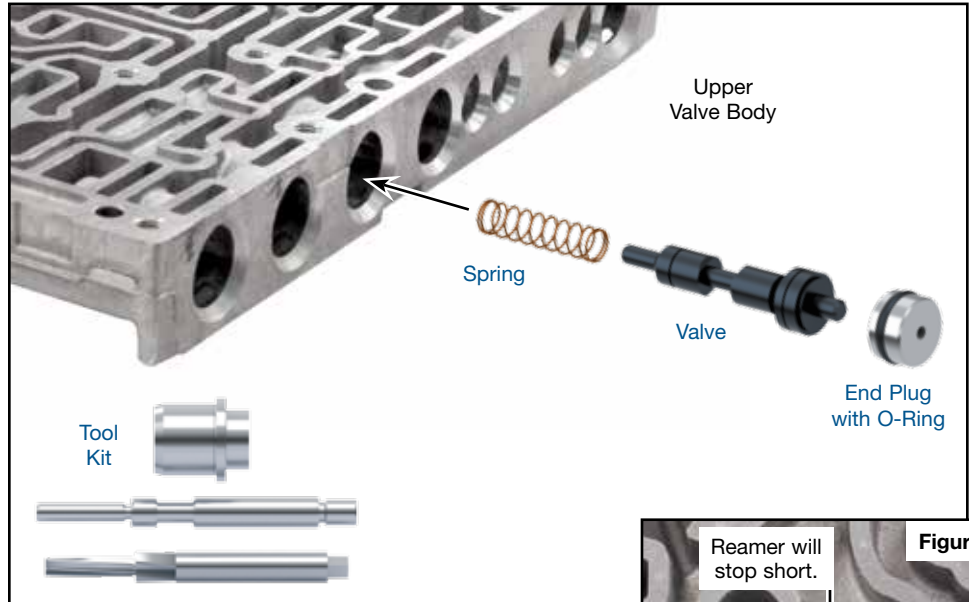
Tool Kit



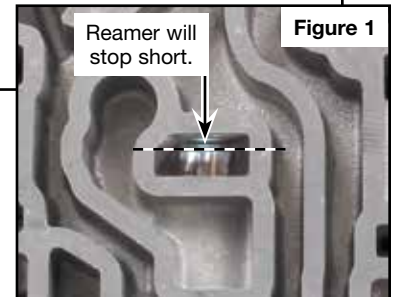
Part No.
F-126740-TL13

- 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 6R140



1. Disassembly

- Remove OE retaining clip, set aside for reuse.
- Remove and discard OE end plug, forward clutch regulator valve and spring.

2. Bore Reaming

Ream forward clutch regulator bore (for reaming instructions/reamer care, please visit www.sonnax.com). Sonnax reaming tool kit **F-126740-TL13** and **VB-FIX** are required for this operation.



NOTE: Reamer tip will stop just short of bore bottom to avoid contacting the casting protrusion; this is normal (**Figure 1**).

3. Installation & Assembly

- Ensure all debris has been removed from valve bore and body.
- Install Sonnax spring, followed by Sonnax valve. Ensure spring seats over the spring stem on the valve.
- Install O-ring onto Sonnax end plug. Roll assembly on clean bench to size O-ring, then lubricate and insert end plug into bore.
- Reinstall OE retaining clip.

4. Final Testing

Vacuum testing at the port(s) indicated holds the recommended minimum 18 in-Hg (**Figure 2**).

