

Oversized Pressure Regulator Valve Kit

Part No.
36940-03K



- Valve • Spring
- Spring Sleeve/End Plug

Tool Kits

Part Nos.
F-36940-TL3



- Reamer • Reamer Jig • Guide Pin

F-36940-TL3C

- Carbide Reamer (also sold separately)
- 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.

NOTE: Identify pump generation (**Step 2**) to determine which reaming tool kit is necessary for your application.

Carbide Reamer

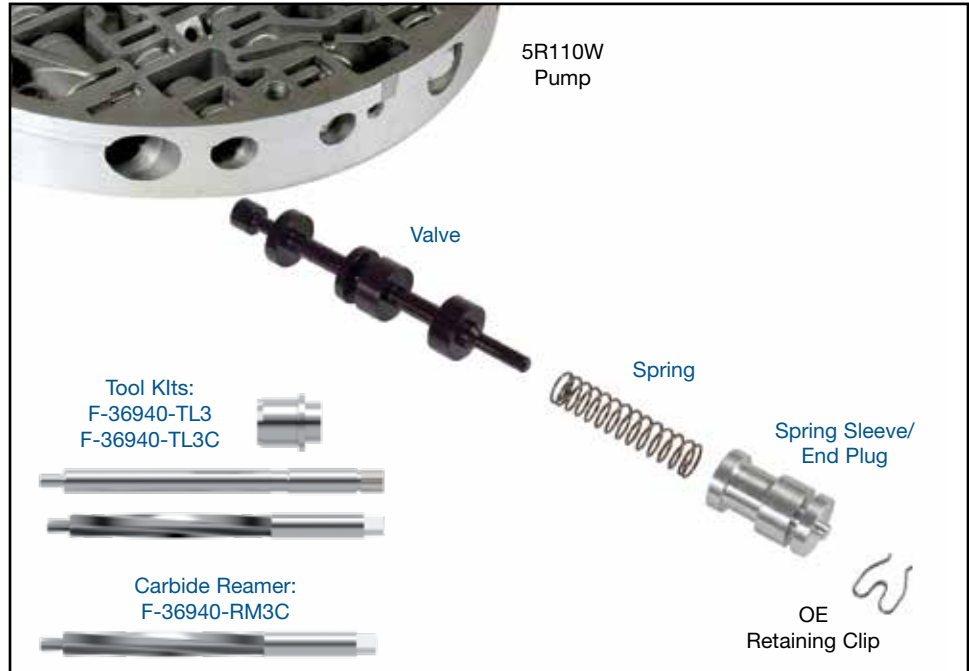
Part No.
F-36940-RM3C



NOTE: Carbide reamer can be ordered separately and used with the Reamer Jig and Guide Pin from a previously purchased **F-36940-TL3** tool kit.

Oversized Pump Base Plate

Part No.
VB-06



1. Disassembly

- Remove OE spring sleeve retaining clip and save for reuse.
- Remove and discard OE spring sleeve, spring and valve.

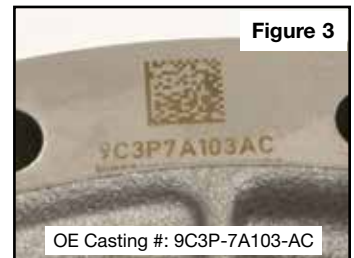
2. Identify Pump Generation

Three pump generations were produced, with varying casting hardness. The Sonnax reaming tool kit used must be matched to the hardness of the pump to extend reamer life and bore finish quality.

- For first generation pumps (OE casting numbers RF3C3P-7B324-AA or AB – **Figure 1**), use **F-36940-TL3** or **F-36940-TL3C** and **VB-FIX**.
- For second and third generation pumps (OE casting numbers RF5C3P-7B324-AA or AB or AC, and 9C3P-7A103-AC and pumps with Al11Si3Cu material callout – **Figures 2 & 3**), use carbide reamer kit **F-36940-TL3C** and **VB-FIX**.



NOTE: Carbide tool kit **F-36940-TL3C** can be used with all pumps regardless of pump generation.



3. Reaming

Ream pressure regulator bore (for reaming instructions/reamer care, please visit www.sonnax.com). Refer to step 2 (page 1) for proper reamer selection.



NOTE: A specially-designed oversized base plate **VB-06** must be mounted to the **VB-FIX** to accommodate the 5R110W pump body.

4. Installation & Assembly

- Thoroughly clean valve bore and pump body of all dirt and debris.
- Install Sonnax valve.
- Install Sonnax spring, ensuring it seats over valve stem.
- Install Sonnax spring sleeve/end plug and secure with OE retaining clip.

5. Final Testing

Vacuum testing at the port(s) indicated holds the recommended minimum 16 and 18 in-Hg.

