

## Outer Pressure Regulator Sleeve

### 68942-06

1 Outer Pressure  
Regulator Sleeve

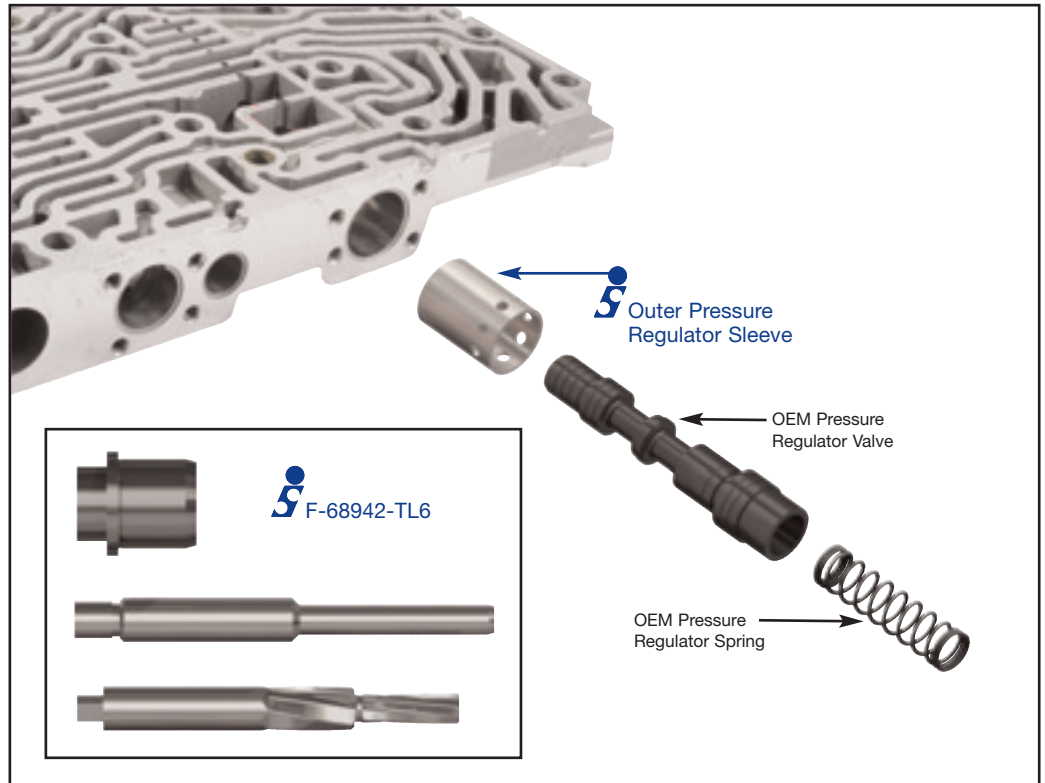


### F-68942-TL6

1 Guide Pin  
1 Reamer Jig  
1 Reamer



**Note:** This sleeve will fit Chrysler 300 & 300C, '05-'07; Chrysler Aspen, '07; Chrysler Crossfire, '04-'07; Dodge Charger SRT, '06-'07; Dodge Magnum R/T, SXT, SRT-8, '05-'07; Dodge Nitro, '07; Dodge Sprinter Van, Diesel 2500-3500, '04-'07; Jeep Commander, '06-'07; and Jeep Grand Cherokee, Laredo and SRT-8, '05-'07.



### Disassembly:

Disassemble the valve body.

### Reaming Instructions:

1. Clean the bore thoroughly in a solvent tank.
2. Align valve body on fixture according to **VB-FIX** instructions using jig **F-68942-RJ** and guide pin **F-68942-GP**, then ream using **F-68942-RM**.
3. With the reamer carefully and securely positioned, use a speed handle to ream the bore. The reaming action should be clockwise in a smooth and continuous motion, at approximately 1 to 1½ revolutions per second.
4. The reamer should pull itself through the bore, so little or no forward pressure should be applied to the reamer or speed handle.
5. Continue reaming until the reamer bottoms in the bore. Spin the reamer 5-10 more times after bore bottoming to allow for excess material removal and better surface finish.
6. Using low air pressure, blow the chips free before removing the reamer.
7. To remove the reamer, turn clockwise while slowly pulling outward on the reamer.

\*This sleeve was developed in conjunction with Mio Cundl of DB Automobile (Germany).

# MERCEDES 722.6, 1996-UP

PART NUMBERS 68942-06, F-68942-TL6

## Outer Pressure Regulator Sleeve

### Cautions:

1. Never turn the reamer backward
2. Pushing on the reamer will result in poor surface finish, inadequate and sporadic material removal, and material being left un-reamed as the reamer exists the bore.
3. Blow free any chips from the reamer after each use.
4. Never use a crescent wrench, t-handle or ratchet to turn the reamer.

### Installation

1. Thoroughly clean the valve body.
2. Install the Sonnax sleeve. The sleeve should be gently pushed into the newly reamed bore flush with the outer surface.
3. Reinstall the OEM pressure regulator valve.
4. Reinstall the OEM pressure regulator spring.
5. Install the retaining plate.