

Oversized Regulating Valve Pressure Control Valve Kit (Early & Late)

68942-17K

- 1 Valve
- 1 Spring
- 2 Plugs



.062"

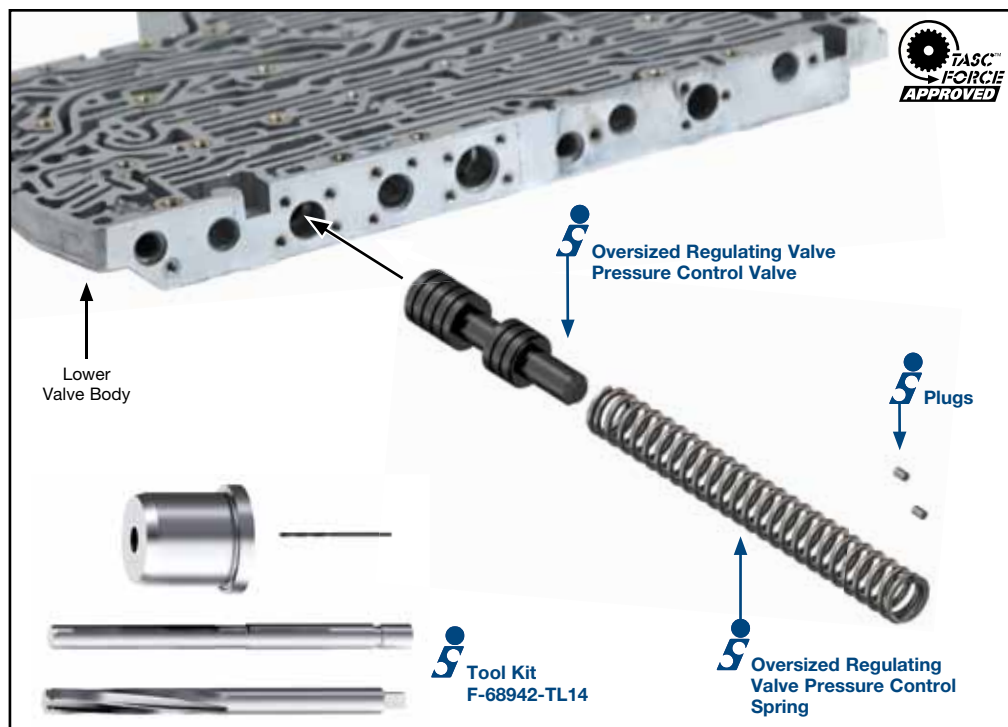
F-68942-TL14

- 1 Reamer
- 1 Guide Pin
- 1 Reamer Jig
- 1 Drill Bit



.0625"

Note: Tool kit **F-68942-TL14** can also be used for Lubricating Pressure Control Valve **68942-14K**.



Notes:

Tool kit **F-68942-TL14** is for use with Sonnax **VB-FIX**.

Disassembly Steps

1. Remove OEM retainer plate.
2. Remove and discard OEM valves and spring(s).

Important Notes

1. Clean the bore thoroughly in a solvent tank.
2. Generously lubricate the bore and reamer with cutting fluid (i.e. Mobilmet S-122, Lubegard Bio-Tap, Tap Magic™, etc.). For best results, provide a continuous flow of water-soluble cutting fluid (i.e. Mobilmet S-122) during the reaming process.
3. The reamers should be turned using a low rpm, high torque air drills regulated to a maximum of 200 rpm.
4. Examine the bore after cleaning for surface finish, debris, and burrs. Flashing and burrs on the exit side of land and bores must be carefully removed. A small piece of Scotchbrite™ material attached to a wire and powered with a drill motor is ideal for the task.

Cautions and Suggestions

1. Turning the reamer backward will dull it prematurely.
2. Pushing on the reamer will result in poor surface finish and inadequate and sporadic material removal.

3. Never use a crescent wrench, ratchet or pliers to turn the reamer.
4. A dull reamer will cut a smaller hole. Reamers can be sharpened, but should only be done by a professional tool sharpener. Actual life of a reamer before re sharpening or replacing averages 50-70 bores..

Note: We recommend you review the Sonnax Reaming DVD for reaming procedures.

Reaming

Follow illustrated reaming instructions on the following page.

Finish & Clean-up

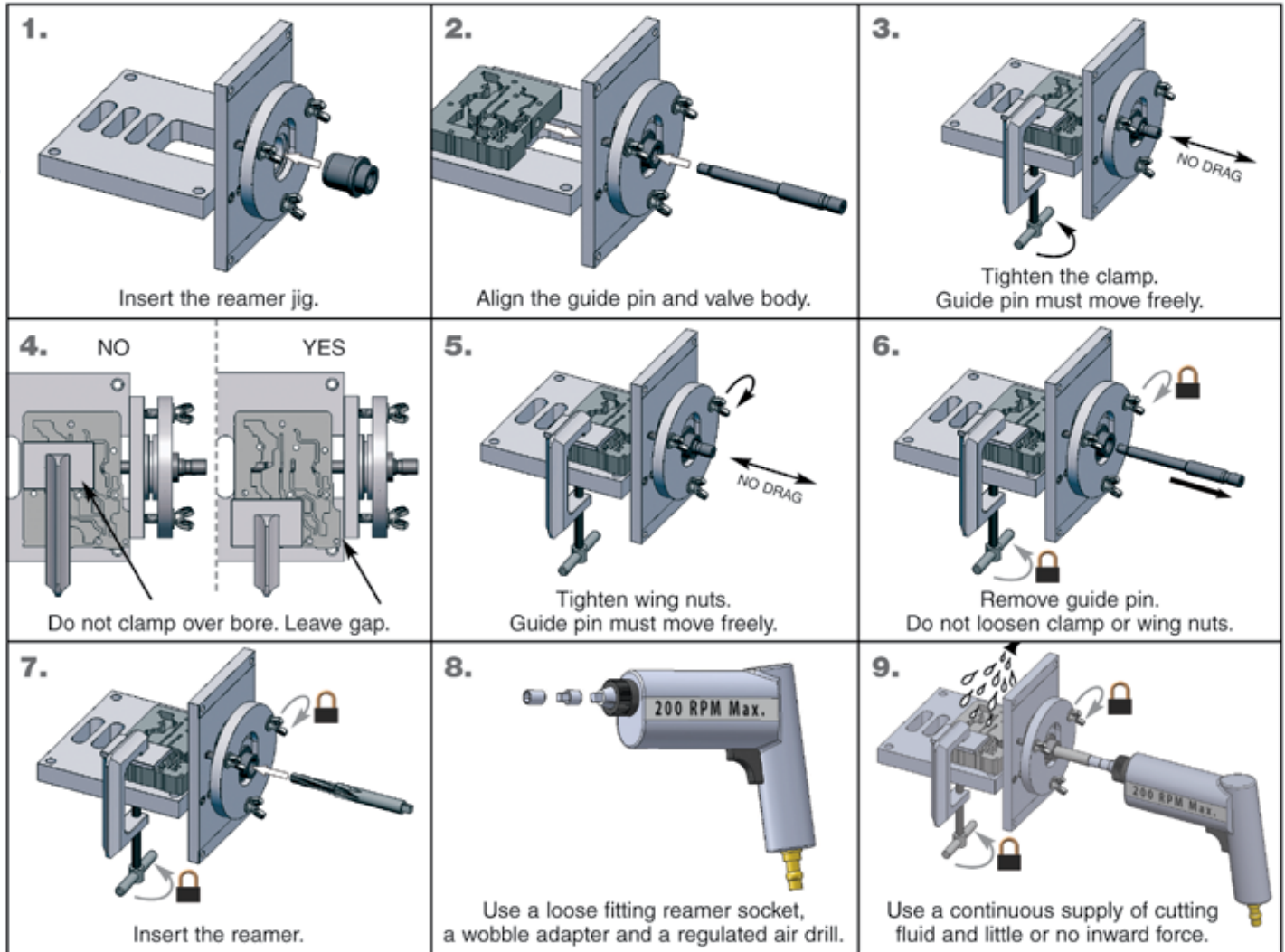
1. Using low air pressure, blow chips free before removing the reamer.
2. To remove the reamer, turn clockwise while slowly pulling outward on the reamer.
3. Remove any remaining debris from the bore with low air pressure and clean in a solvent tank.
4. Examine the bore after cleaning for surface finish, debris and burrs. Flashing and burrs on the exit side of the casting bores can be carefully removed with a piece of Scotchbrite® on the end of a long wire.
5. Clean the reamer after each use and store in its protective tube.

MERCEDES 722.6

**Oversized Regulating Valve
Pressure Control Valve Kit**
(Early & Late)

PART NUMBERS 68942-17K, F-68942-TL14K

Reaming Instructions



Installation/Assembly Be certain all debris has been removed from the valve bore and valve body.

EARLY Application:

1. Using the 1/16" drill (included), drill through indicated hole in separator plate (see Figure 1).
2. Then countersink both sides of the hole just drilled with either a 1/8" or 3/16" drill (not included).
3. Install aluminum plug. Peen shut on both sides to close off hole.
4. Install Sonnax valve and spring.
5. Install OEM retainer plate.
6. The TCM must be reprogrammed after the valve body is repaired to address the revised calibration.

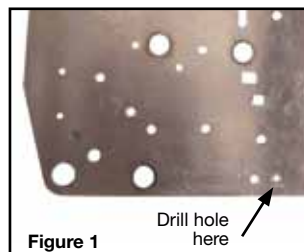


Figure 1

LATE Application:

1. Install the new Sonnax valve and spring.
2. Install OEM retainer plate.

Final Verification

1. Vacuum testing at port should yield 18" of vacuum or higher.

