

Oversized Pressure Regulator Valve Kit

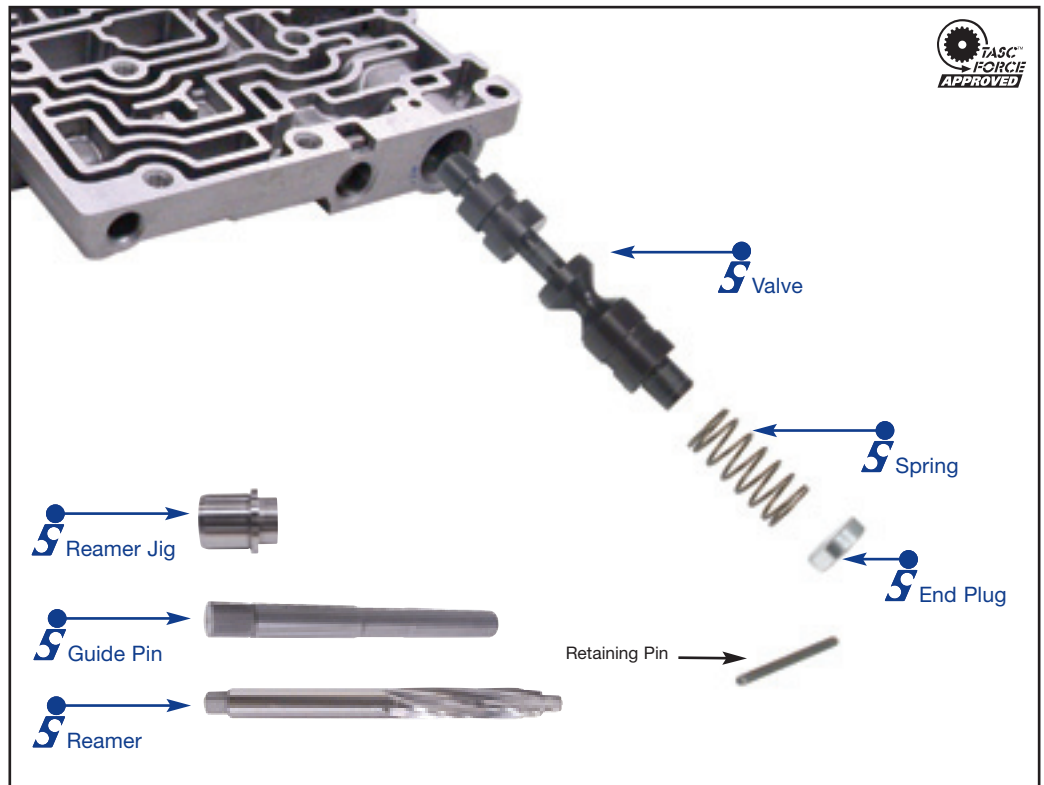
122892-03K

1 Valve
1 Spring
1 End Plug



F-122892-TL3

1 Reamer
1 Reamer Jig
1 Guide Pin



DISASSEMBLY:

Disassemble the valve body and discard the OEM regulator valve, regulator spring and end plug. Save the retaining pin.

REAMING INSTRUCTIONS:

1. Clean the bore thoroughly in a solvent tank.
2. Align the valve body on the fixture according to **VB-FIX** instructions, using jig **F-122892-RJ3** and guide pin **F-122892-GP3**, then ream using **F-122892-RM3**.
3. The reamer should be turned either by hand using a speed handle or by a low rpm, high torque air drill regulated to a maximum of 200 rpm.
4. The reaming action should be clockwise in a smooth and continuous motion, at 60-200 rpm. The reamer should actually pull itself through the bore, so little or no forward force should be applied.
5. Continue reaming until the reamer stop is reached. 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.

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 unreamed as the reamer exits 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 valve, followed by the Sonnax spring and end plug.
3. Install the OEM retaining pin.