Instruction
Data Sheet

MERCEDES 722.6

PART NUMBERS **68942-19K, F-68942-TL19**

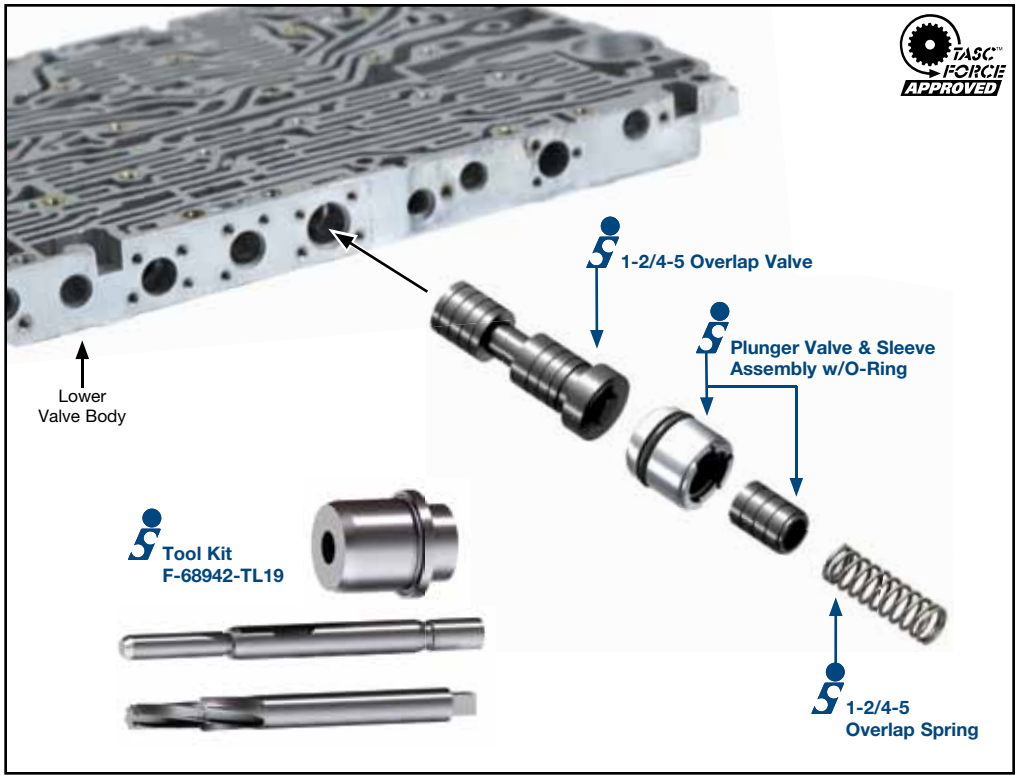
1-2/4-5 Overlap Valve Kit

68942-19K

1 Plunger Valve & Sleeve Assembly
1 Overlap Valve
1 Overlap Spring
1 O-Ring

F-68942-TL19

1 Reamer
1 Reamer Jig
1 Guide Pin



Disassembly Steps

Remove and discard the OEM overlap valve, plunger valve, plunger sleeve and spring.

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 MagicTM, etc.). For best results, provide a continuous flow of water-soluble cutting fluid (i.e. Mobilment S-122) during the reaming process.
3. The reamers should be turner 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 ScotchbriteTM 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 resharpening or replacing averages 50-70 bores.

Reaming instructions

Follow illustrated reaming instructions on the following page.

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1-2/4-5 Overlap Valve Kit

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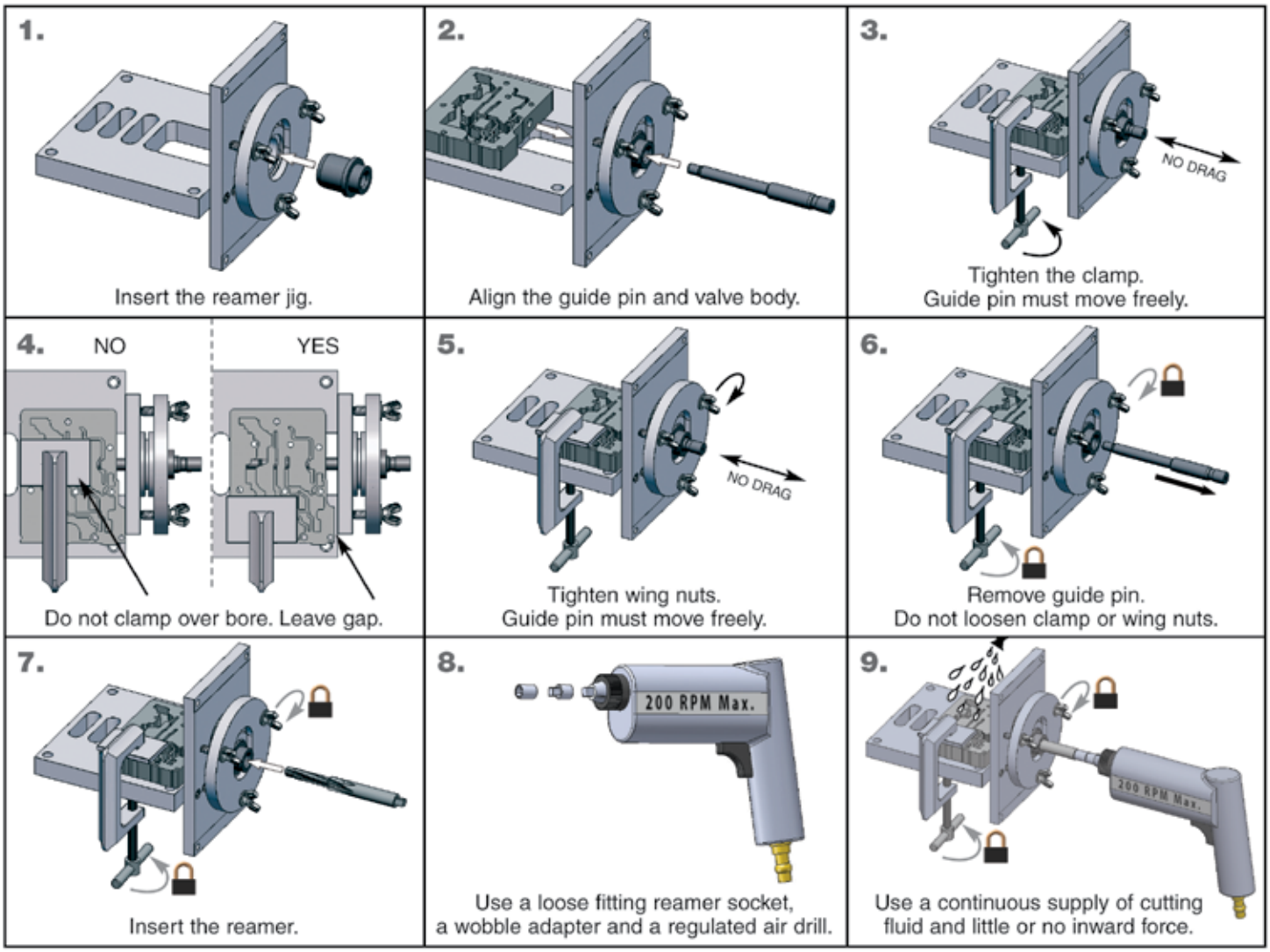
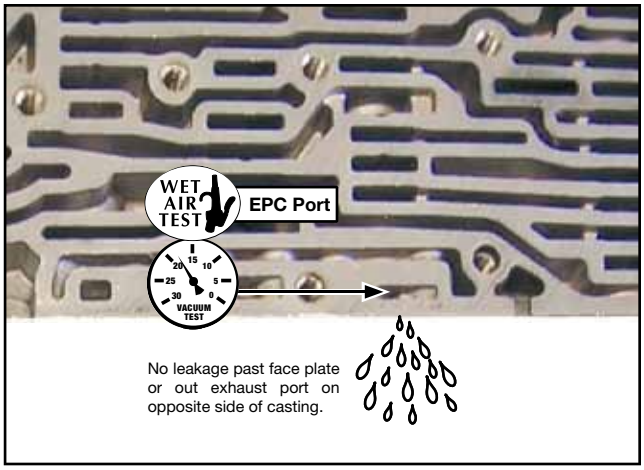
Reaming Instructions



Installation/Assembly Steps

1. Insert oversized overlap into reamed and cleaned bore.
2. Install the o-ring into the sleeve groove and roll on the bench to resize the OD. Lubricate the o-ring and sleeve.
3. Install the spring into the plunger valve pocket. Slide the pluger valve into the sleeve, with the spring facing the grooved end face.
4. Slowly install the sleeve assembly into the valve body bore, taking care not to shear the o-ring. Ensure the end face grooves are outward.



Final Verification Steps

A Wet Air or Vacuum Test in the location shown, results in leakage. A Vacuum Test must hold a minimum of 18". If you cannot effectively perform a WAT or Vacuum test, visually inspect the inboard overlap bore.