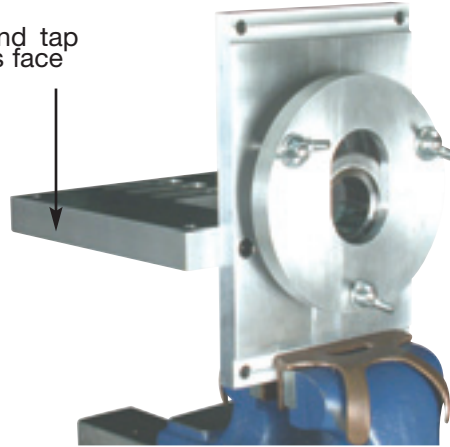


Oversized Manual Valve

VB-FIX Base Plate Modification

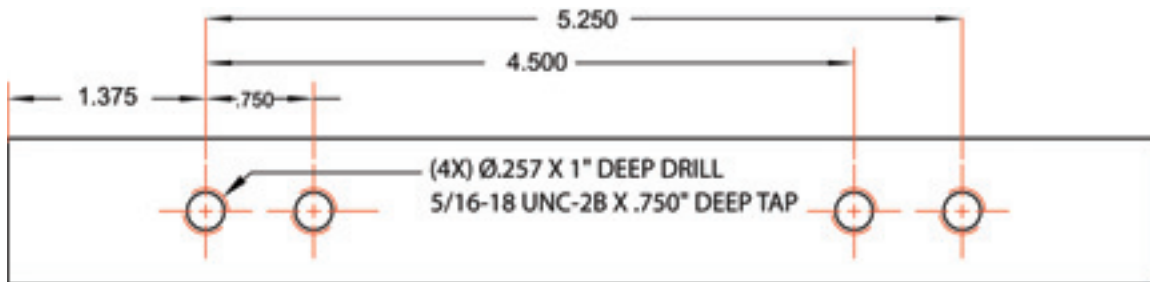
Extreme care must be used in clamping the valve body to the **VB-FIX** as currently designed, to ensure the manual valve bore does not warp. Once clamped in place, the Sonnax guide pin must stroke freely in the bore. To provide better support, the **VB-FIX** base plate can be modified by drilling and tapping four holes, as shown below. This will allow the base plate to be turned 90° and then secured to the clamp mounting plate, allowing more support for the manual valve during reaming.

Drill and tap
on this face



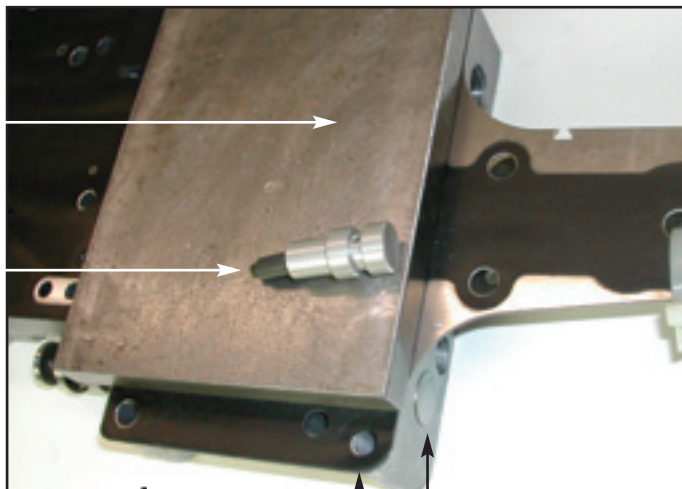
Modification Measurements

Use these dimensions to drill and modify your base plate. Do not use image below as an actual template for modifications.



Vacuum test plate must cover
all other related circuits

Critical! Check L/R modulator
plunger sleeve for wear. Wear
reduces vacuum and equals
line loss in reverse.



Vacuum test here,
replace if 9" or less

Valve should extend .062" from casting
for proper reverse circuit test

VERIFICATION & VACUUM TEST PROCEDURE:

Perform a vacuum test at the location indicated. A vacuum test should reach at least 9" of vacuum.

For information on proper vacuum test procedures go to www.sonnax.com, click on "Technical Information" and go to the Vacuum Testing Guidelines section.