Oversized Primary Pressure Regulator Valve Kit
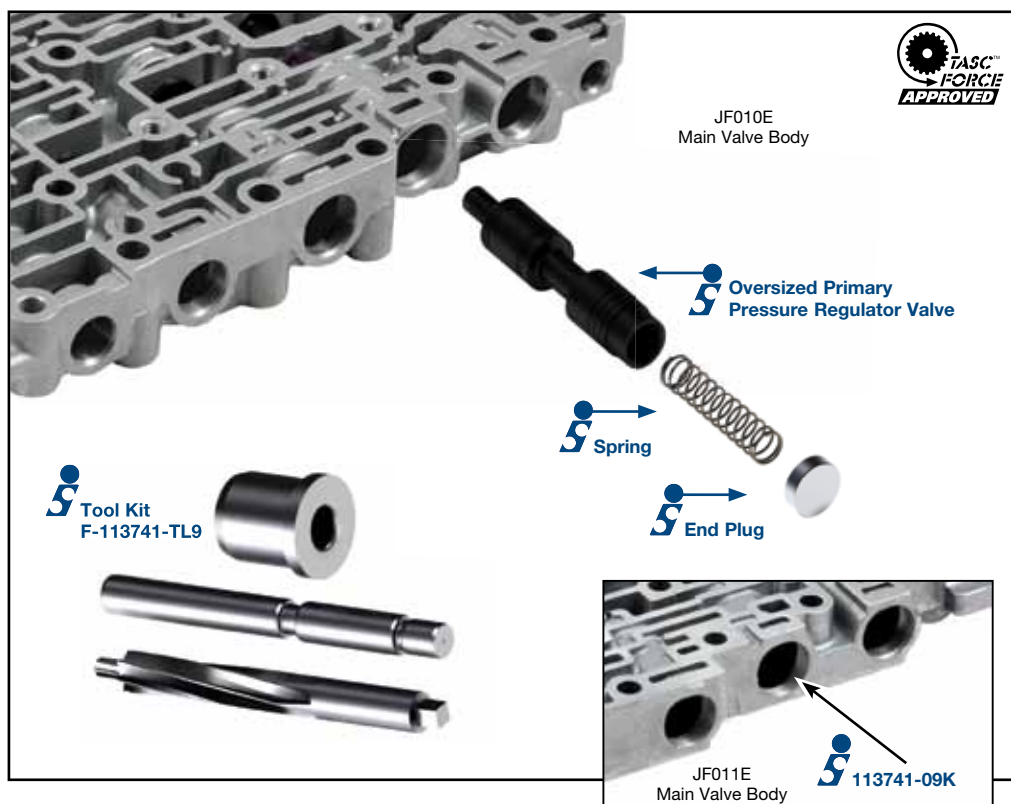
113741-09K

1 Oversized Pressure Regulator Valve
1 Spring
1 End Plug

NOTE: Fits JF010E & JF011E

F-113741-TL9

1 Reamer
1 Reamer Jig
1 Guide Pin

VALVE BODY

FIXTURE REQUIRED

TOOL REQUIRED

JF010E
Main Valve Body

TASC FORCE APPROVED

Oversized Primary Pressure Regulator Valve

Spring

End Plug

Tool Kit F-113741-TL9

JF011E
Main Valve Body

113741-09K

Disassembly

1. Remove and discard the OEM valve, spring and end plug.

2. Keep the OEM retainer for reuse.

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. Mobilment S-122) during the reaming process.

3. The reamers should be turned using a low RPM, high torque air drill 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.
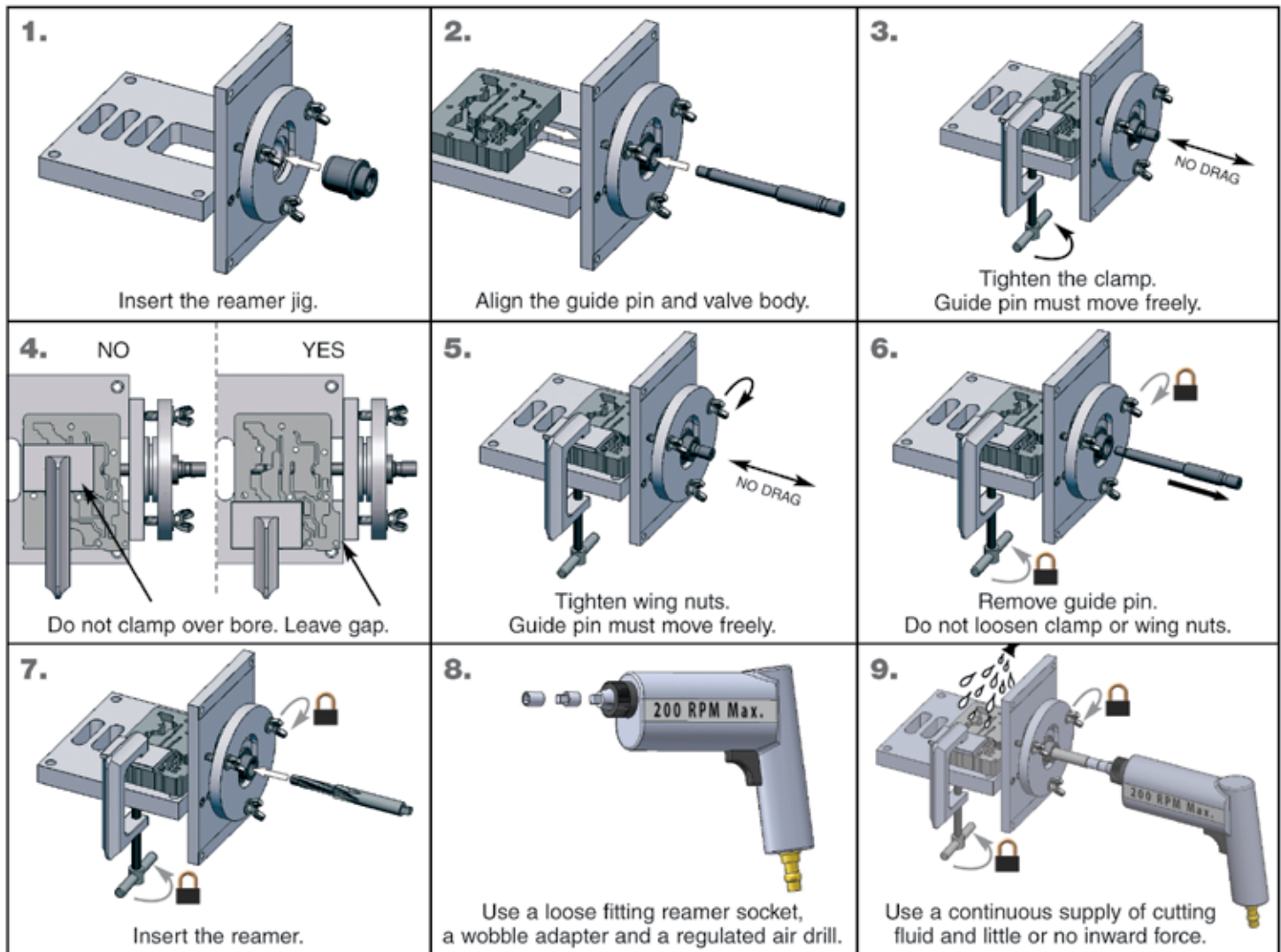
Cautions and Suggestions

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 resharpening or replacing averages 50-70 bores.

Reaming Instructions

1. Insert the reamer jig.

2. Align the guide pin and valve body.

3. Tighten the clamp. Guide pin must move freely.

NO DRAG

4. NO / YES — Do not clamp over bore. Leave gap.

5. Tighten wing nuts. Guide pin must move freely.

NO DRAG

6. Remove guide pin. Do not loosen clamp or wing nuts.

7. Insert the reamer.

8. Use a loose fitting reamer socket, a wobble adapter and a regulated air drill.

200 RPM Max.

9. Use a continuous supply of cutting fluid and little or no inward force.

Installation

1. Remove all debris from the valve bores and body.

2. Install the Sonnax O/S valve.

3. Install the Sonnax spring.

4. Install the Sonnax O/S end plug, with the boss end of plug inboard. Be sure the spring is over the end plug boss.

5. Reinstall the retaining clip.

WET AIR TEST 18" Minimum JF011E Main Valve Body

No Leakage

WET AIR TEST 18" Minimum JF010E Main Valve Body

No Leakage

Final Verification Steps

Perform a vacuum/wet air test. Either port should yield 18" of vacuum or higher.

sonnax
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