

Lubricating Pressure Control Valve

68942-14K

- 1 Valve
- 1 Spring



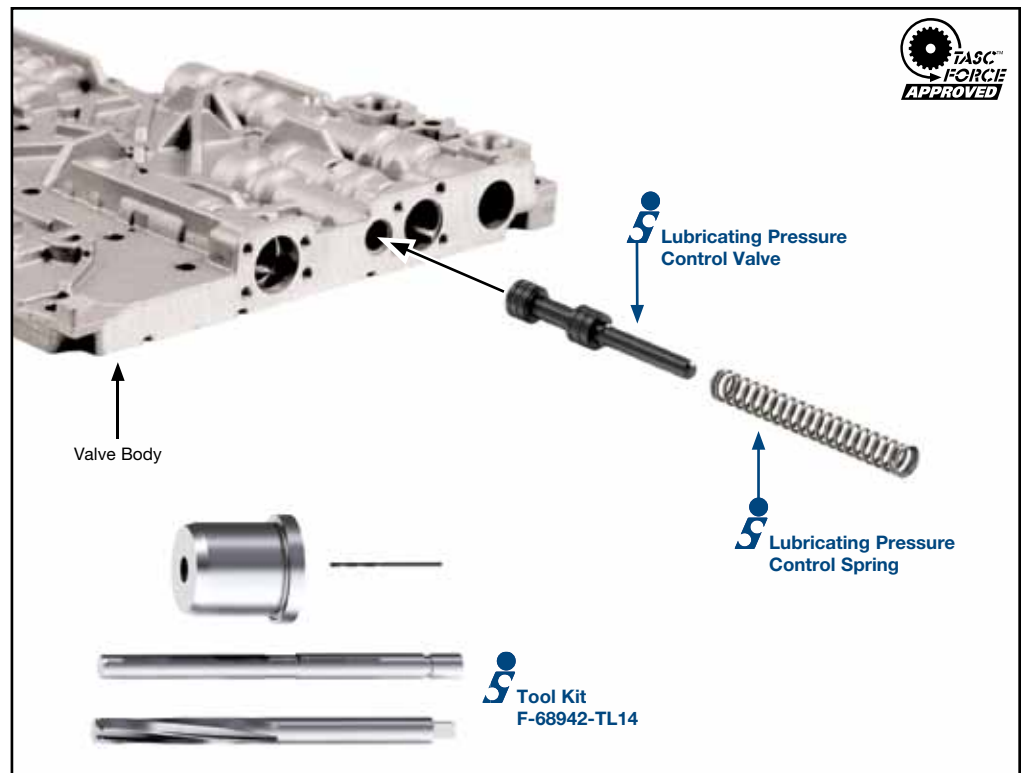
F-68942-TL14

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



.0625"

Note: Tool kit **F-68942-TL14** can also be used for Oversized Regulating Valve Pressure Control Valve Kit **68942-17K**. (*Drill bit is only used in the **68942-17K** installation).



Notes:

1. Tool kit **F-68942-TL14** is for use with Sonnax **VB-FIX**.
2. The drill bit* will **NOT** be used during this installation (drill bit for use with **68942-17K** installation only).

Disassembly Steps

1. Remove OEM retainer plate.
2. Remove and discard OEM valve and spring.

Prep & Set-up

1. Remove all components from the bore.
2. Clean the bore thoroughly in a solvent tank.
3. Align the valve body on the fixture according to the **VB-FIX** instructions.

Important Note: Once alignment is complete, do not loosen wing nuts or unclamp valve body fixture until entire reaming process is completed.

4. We strongly recommend a continuous flow of reaming fluid to remove chips, improve bore finish and extend reamer life. Two water soluble reaming fluids are Mobilmet S122 and Lubegard 80903. Lubegard Bio-Tap is another alternative.

5. Gently insert the reamer through the jig and into the bore until the cutting tip contacts the first bore to be reamed.
6. Select the correct sized socket to fit the square shank of the reamer and attach it to a swivel socket drive.

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. The leading cutting edge will hold material if inward force and turning speed are incorrect. If a burr occurs, remove it by drawing a tool along the edge of the flute from the rear of the tool toward the tip.
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 sharpening or replacing averages 50-70 bores.

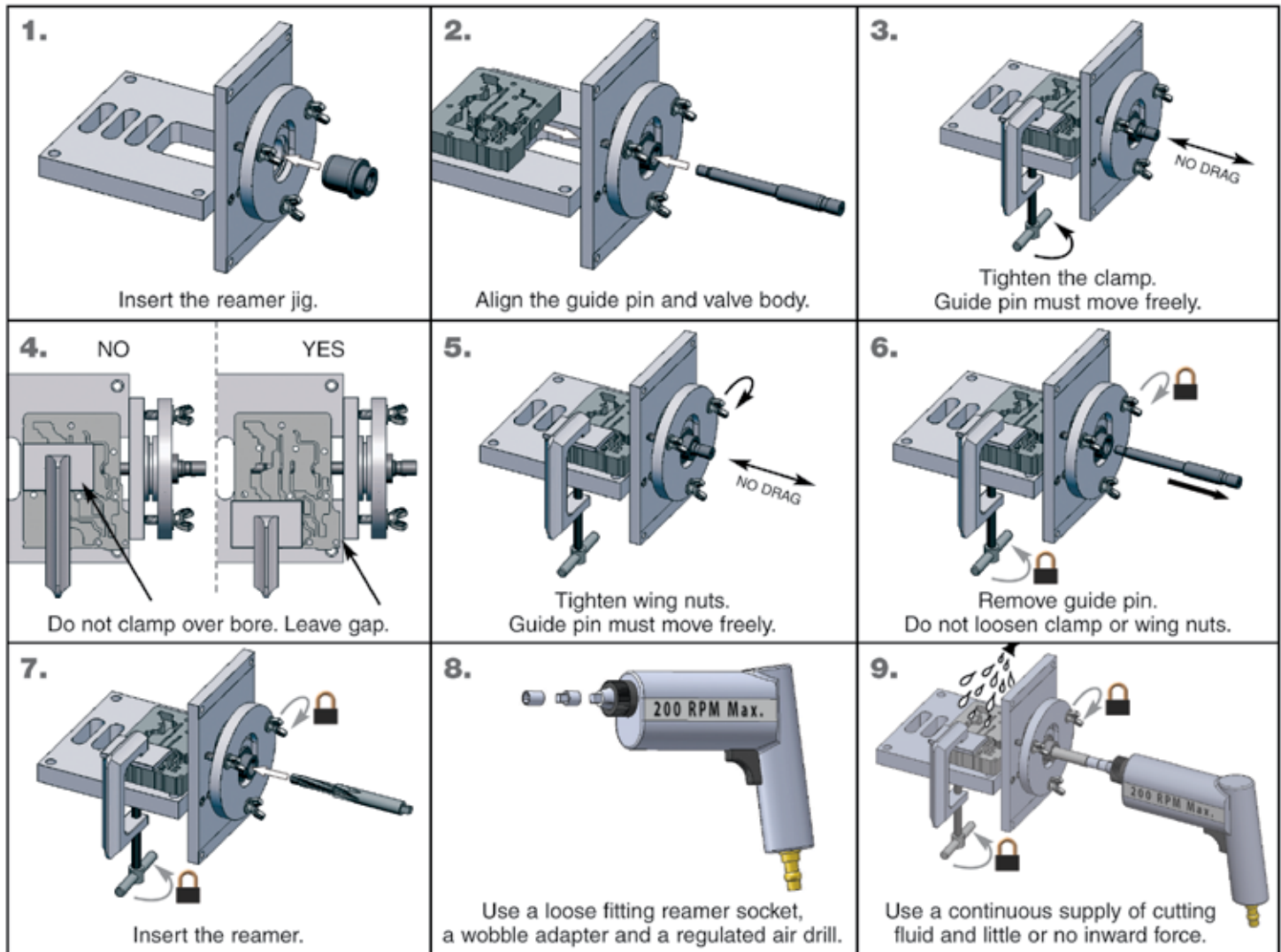
Note: We recommend you review the Sonnax Reaming DVD for reaming procedures.

MERCEDES 722.6

Lubricating Pressure Control Valve

PART NUMBERS 68942-14K, F-68942-TL14

Reaming Instructions



Finish & Clean-up

1. Using low air pressure, blow the 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.

Installation/Assembly

1. Be certain all debris has been removed from the valve bores and valve body.

2. Install the new Sonnax lubricating pressure control valve and spring.
3. Install OEM spring retainer plate.

Final Verification

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

