

Main Pressure Regulator & Boost Assembly

39741-01K

- 1 Pressure Regulator Valve
- 1 Pressure Regulator Spring
- 1 Boost Sleeve
- 1 Boost Valve

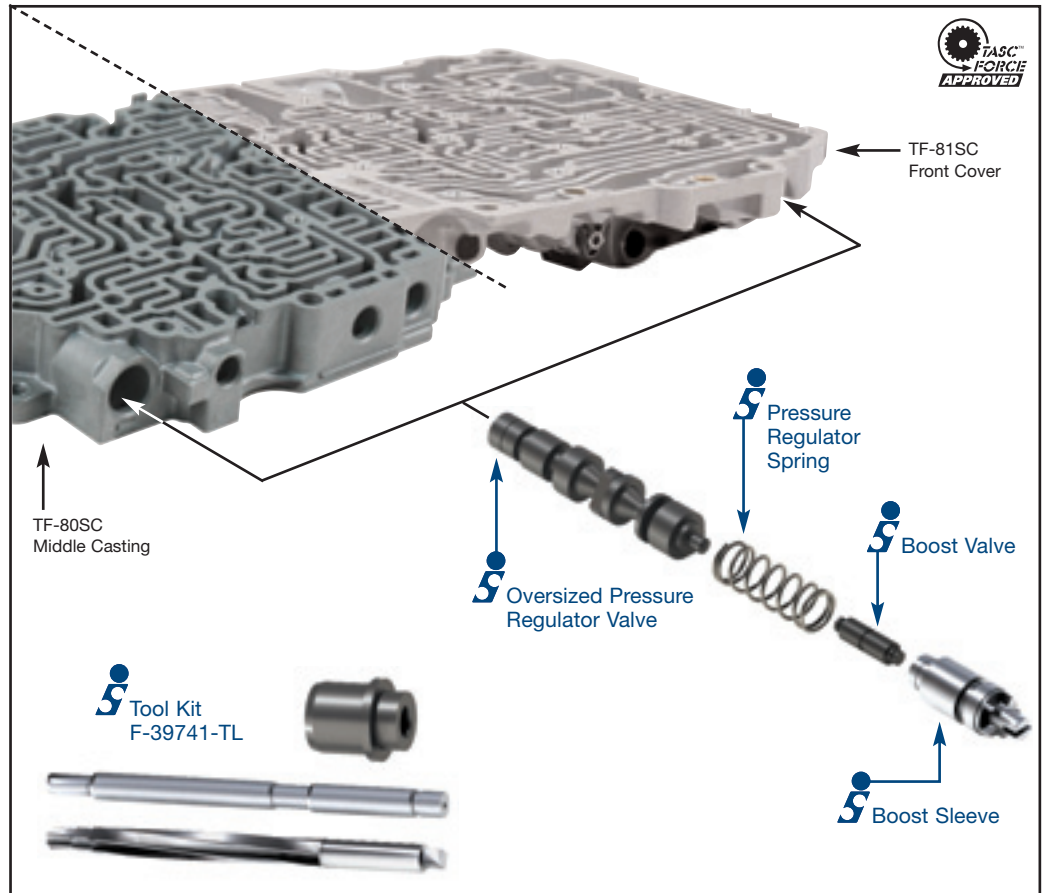


F-39741-TL

- 1 Reamer
- 1 Guide Pin
- 1 Reamer Jig



Note: Fits Volvo (AM6); Opel (AF40); Peugeot (TF80); Saab (AF40/6); Land Rover (TF80); Ford (AF21) & Mazda (AW6A-EL).



Disassembly Steps:

1. Note step location of retainer on OEM sleeve end prior to removal.
2. Remove and discard OEM boost sleeve and valve.
3. Remove and discard OEM pressure regulator spring and valve

Important Notes:

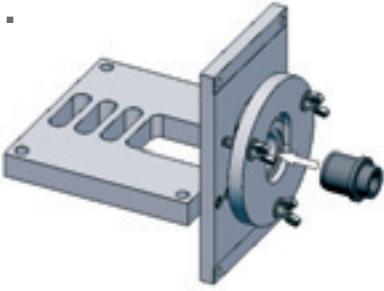
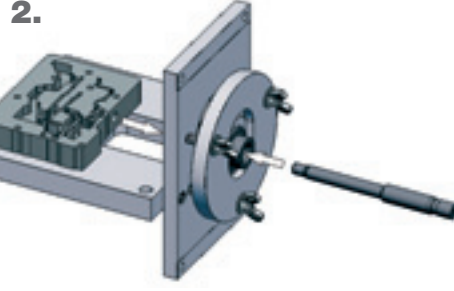
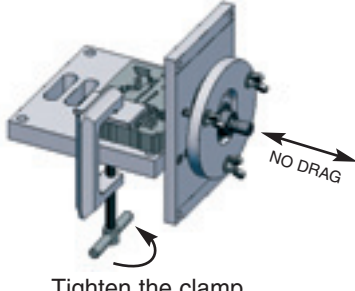
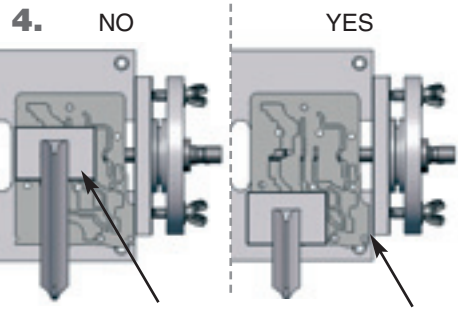
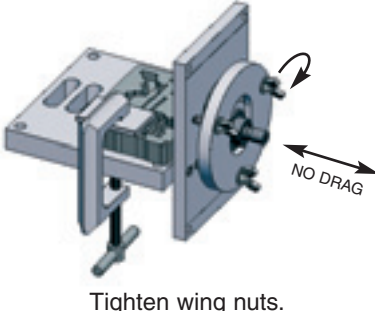
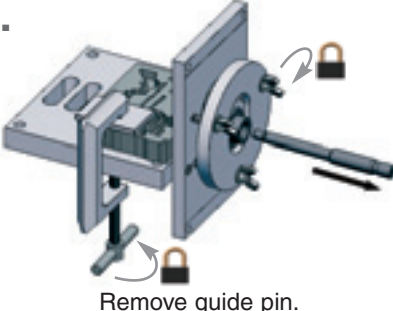
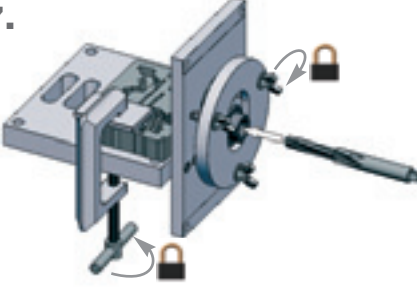

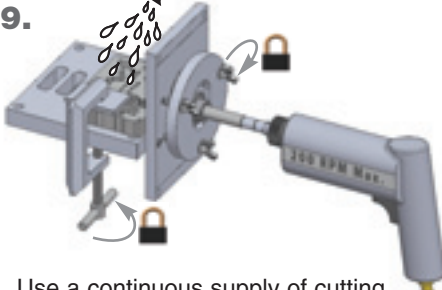
1. Clean the bore thoroughly in a solvent tank.
2. Generously lubricate the bore and reamer with cutting fluid (i.e. Mobilmet S-122, Lubegard Bio-Tap, Tap Magic™, etc). For best results, provide a continuous flow of water-soluble cutting fluid (i.e. Mobilmet S-122) during the reaming process.
3. The 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 lands 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.

TF-80/81SC

PART NUMBERS 39741-01K, F-39741-TL

**Main Pressure
Regulator & Boost Kit**

Reaming Instructions:

<p>1.</p>  <p>Insert the reamer jig.</p>	<p>2.</p>  <p>Align the guide pin and valve body.</p>	<p>3.</p>  <p>Tighten the clamp. Guide pin must move freely. NO DRAG</p>
<p>4.</p>  <p>NO YES Do not clamp over bore. Leave gap.</p>	<p>5.</p>  <p>Tighten wing nuts. Guide pin must move freely. NO DRAG</p>	<p>6.</p>  <p>Remove guide pin. Do not loosen Clamp or wing nuts.</p>
<p>7.</p>  <p>Insert the Reamer.</p>	<p>8.</p>  <p>Use a loose fitting reamer socket, a wobble adapter and a regulated air drill.</p>	<p>9.</p>  <p>Use a continuous supply of cutting fluid and little or no inward force.</p>

Installation Steps:

1. Install the Sonnax Pressure Regulator Valve, then the Sonnax Pressure Regulator Spring, followed by the Sonnax Boost Valve and Sleeve assembly. See main photo for proper line up.
2. Ensure retainer is set at the same step location on the replacement sleeve.

Final Verification:

Wet Air Test (WAT) or Vacuum Test the sleeve assembly while in the bore at the outboard reverse feed port indicated. If performing a WAT, no leakage should occur at the neighboring exhaust port. A vacuum test must hold a minimum of 18".

