

Actuator Feed Limit Valve Kit



Part No.

77754-09K

- Valve
- Sleeve
- Spring
- Retaining Clip

Patent No. 6,634,377

Tool Kit



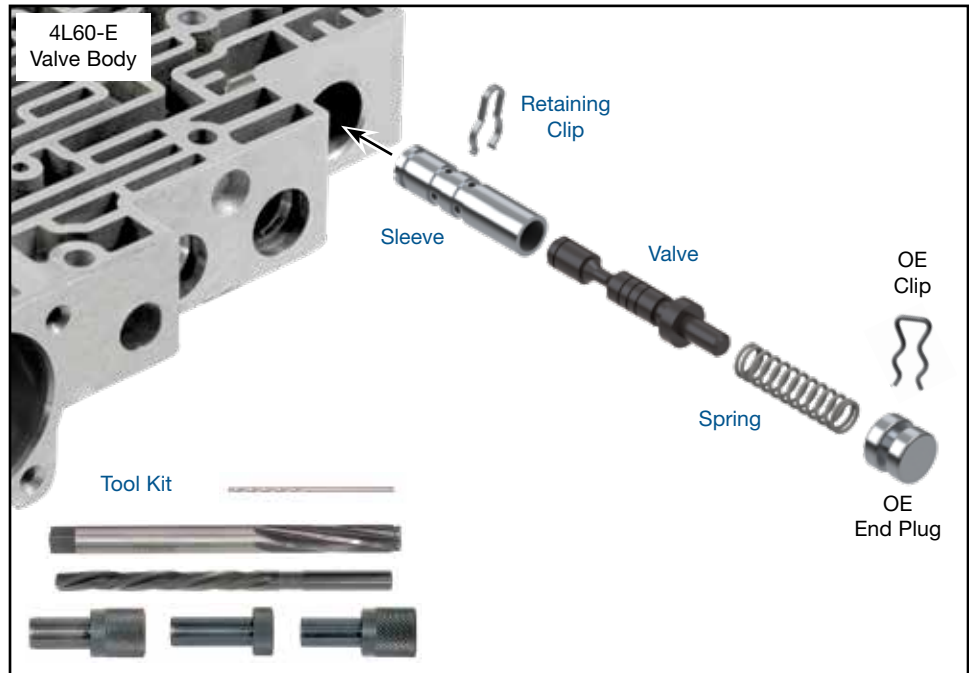
Part No.

77754-TL

- Core Drill 4L80-E only
- Reamer
- Guides (3) 1 4L60-E & 2 4L80-E
- Drill Bit .052"

NOTE: This tool kit works for 4L60-E and 4L80-E AFL valve repairs. More reaming information and instructions can be found online at www.sonnax.com.

GM 4L60-E, 4L65-E, 4L70-E



1. Disassembly

- Remove OE actuator feed limit valve train lineup.
- Keep OE end plug and end plug clip for reuse.
- Discard OE valve and spring all other parts.

2. Bore Reaming

Ream actuator feed limit bore (for reaming instructions/reamer care, please visit www.sonnax.com). Sonnax reaming tool kit 77754-TL is required for this operation.

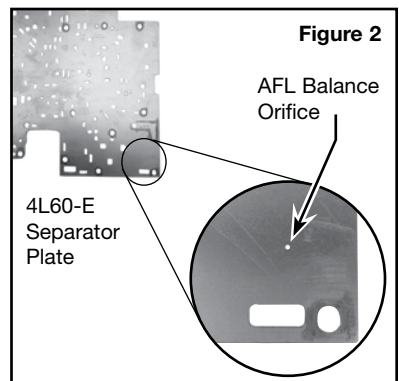
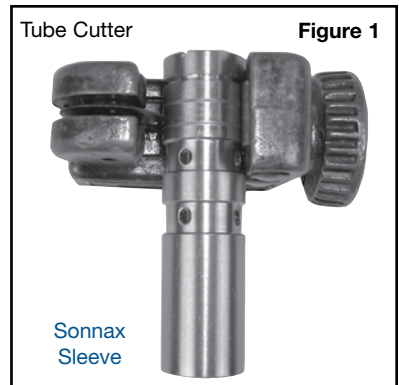
3. Installation & Assembly

- Be certain all debris has been removed from the valve bore and valve body.
- Remove Sonnax valve from sleeve and install with retaining clip groove inward.



NOTE: Sonnax sleeve must fit the bore with slight resistance. If sleeve slides in easily or rotates in the bore, a tubing cutter can be used to raise a slight ridge around the sleeve lands (**Figure 1**).

- Lightly tap Sonnax sleeve into position (the OE valve inserted backward may be used to drive the sleeve).
- Install Sonnax valve and spring.
- Reinstall OE end plug and end plug clip.



4. Separator Plate Modification

d. The AFL balance orifice must be enlarged to .052" with Sonnax drill bit (Figure 2).

4. Final Testing

Vacuum testing at the port(s) indicated holds the recommended minimum 18 in-Hg (Figure 3).

