

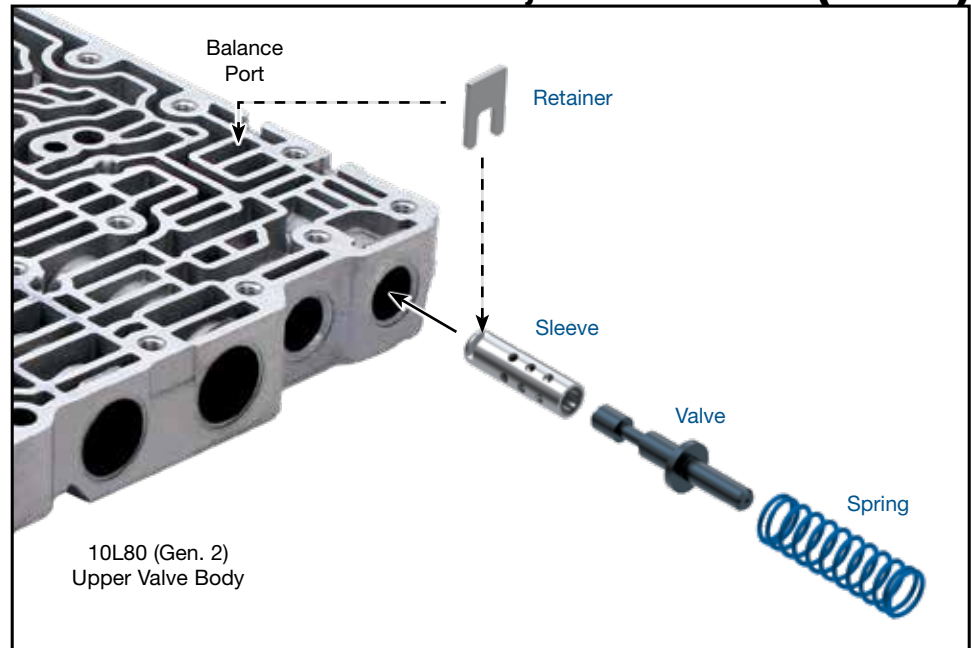
Feed Limit High Valve Kit

Part No.
105740-58K

- Valve
- Sleeve
- Spring
- Retainer
- Drill Bit Not Shown
- Rivet Not Shown

Patent No. 8,919,381

GM 10L1000, 10L60/80/90 (Gen. 2)



1. Disassembly

- a. Remove OE spring retainer and save for reuse.
- b. Remove and discard OE spring and valve.

2. Drill & Plug Separator Plate

- a. Use included drill bit to drill balance orifice at feed limit high valve to .063" (**Figures 1 & 2**).
- b. Insert included rivet into drilled hole and peen on side of the plate. Using wire cutters, snip the stem end of the rivet if/as necessary to provide for a small head once peened in place. Peen rivet in place on head side of the plate as well.
- c. After peening on both sides of the plate, ensure plate will still fit flush on mating surface.

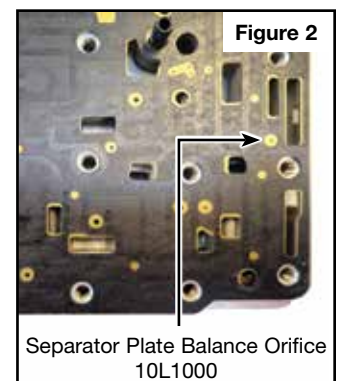
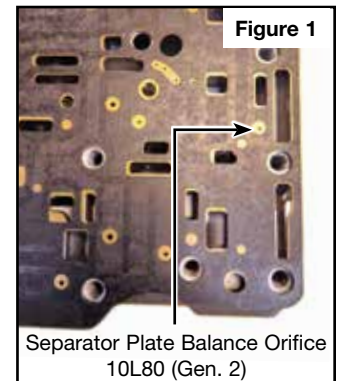
3. Installation & Assembly

- a. Be certain all debris has been removed from the valve bore and valve body.
- b. Install Sonnax valve/sleeve assembly with sleeved end inboard.
- c. Secure sleeve by installing Sonnax retainer around sleeve grooves at balance port.



CAUTION: Ensure Sonnax retainer is fully seated around the Sonnax sleeve end in the grooves after installation.

- d. Install Sonnax spring and reinstall OE spring retainer.

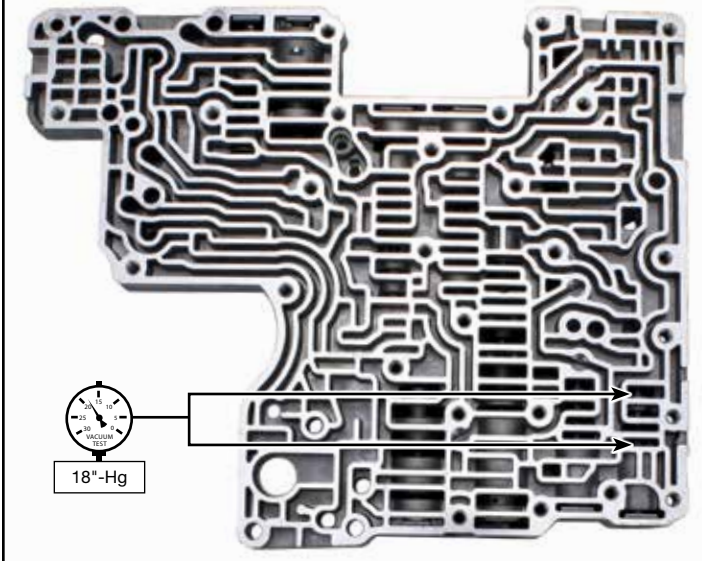


4. Final Testing

Vacuum testing at the port(s) indicated holds the recommended minimum 18 in-Hg (Figures 3 – 6).

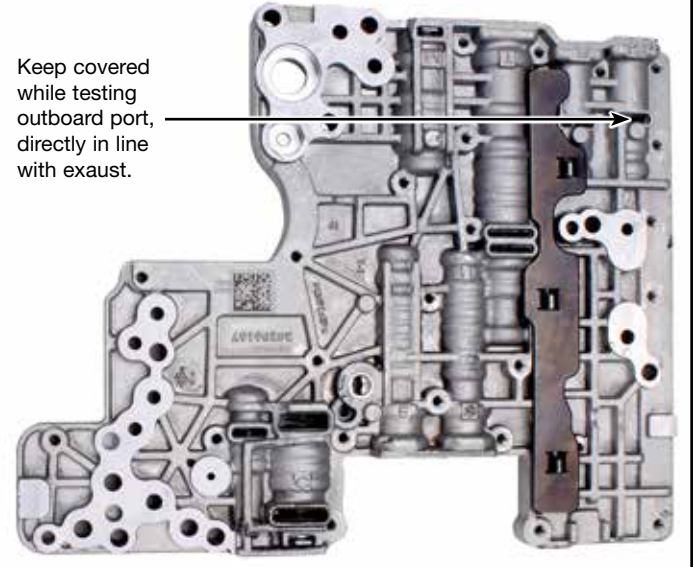
10L80 (Gen. 2) Upper Valve Body - Side 1

Figure 3



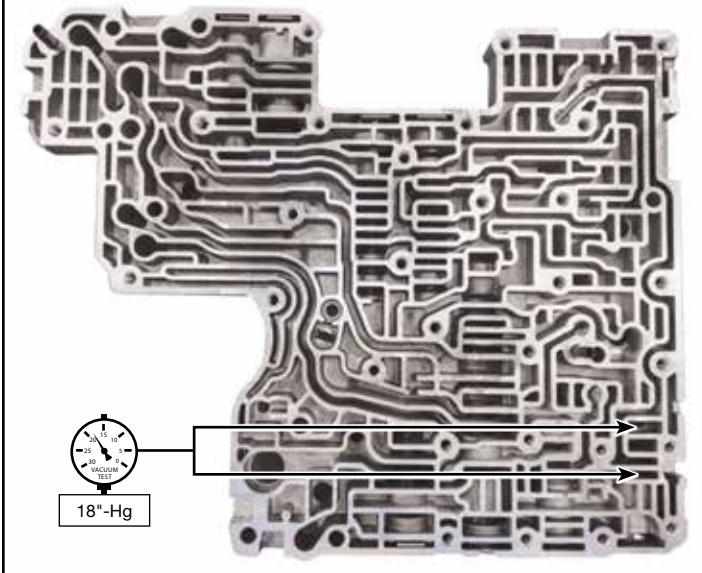
10L80 (Gen. 2) Upper Valve Body - Side 2

Figure 4



10L1000 Upper Valve Body - Side 1

Figure 5



10L1000 Upper Valve Body - Side 2

Figure 6

