

Feed Limit Low Valve Kit

Part No.

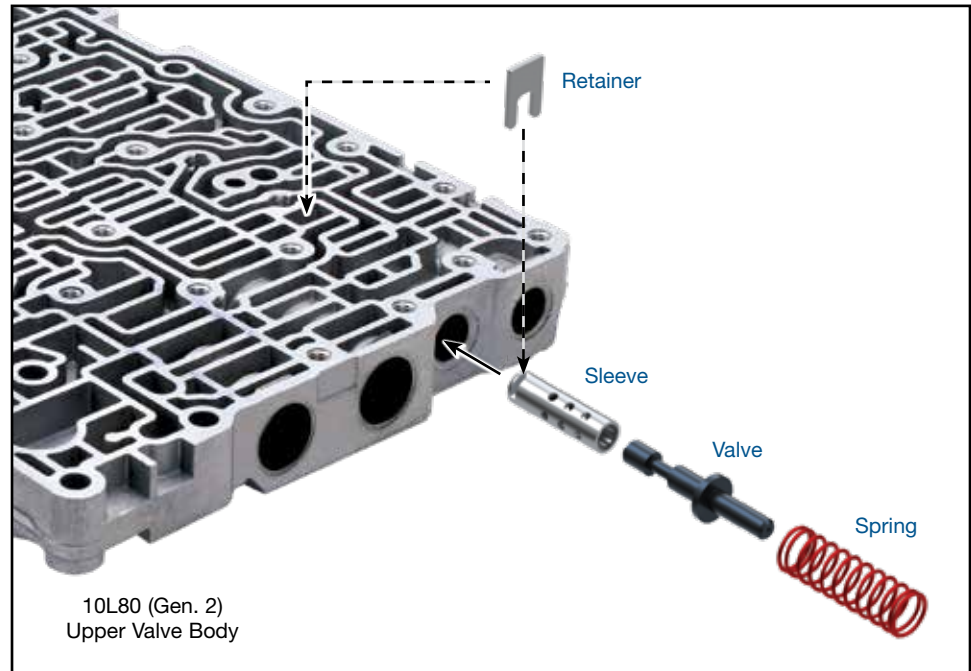
105740-54K

- Valve
- Sleeve
- Spring
- Retainer
- Drill
- Rivet

Not Shown
Not Shown

Patent No. 8,919,381

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



1. Disassembly

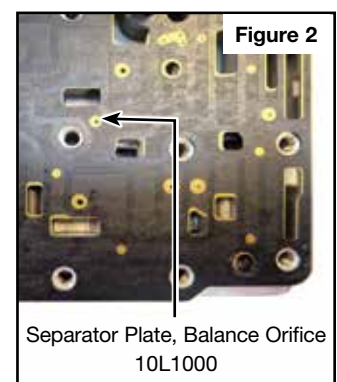
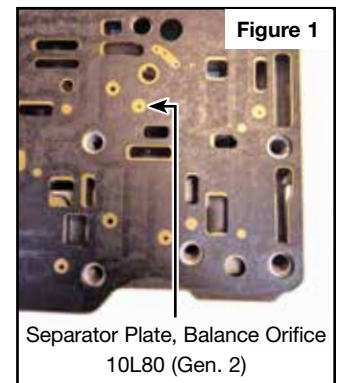
- Remove and save OE spring retainer.
- Remove and discard OE spring and valve.

2. Drill & Plug Separator Plate

- Using included drill bit, drill separator plate balance orifice at feed limit low valve to .063" (**Figures 1 & 2**).
- Insert the 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 the rivet in place on head side of the plate as well.
- After peening on both sides of the plate, ensure plate will still fit flush on mating surface.

3. Installation & Assembly

- Be certain all debris has been removed from the valve bore and valve body.
- Install Sonnax valve/sleeve assembly with grooved end inboard.



3. Installation & Assembly (continued)

c. Secure sleeve by installing Sonnax retainer around sleeve grooves at balance port.



CAUTION: Ensure Sonnax retainer is fully seated around the 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).

