

Feed Limit Low Valve Kit

Part No.

105740-54K

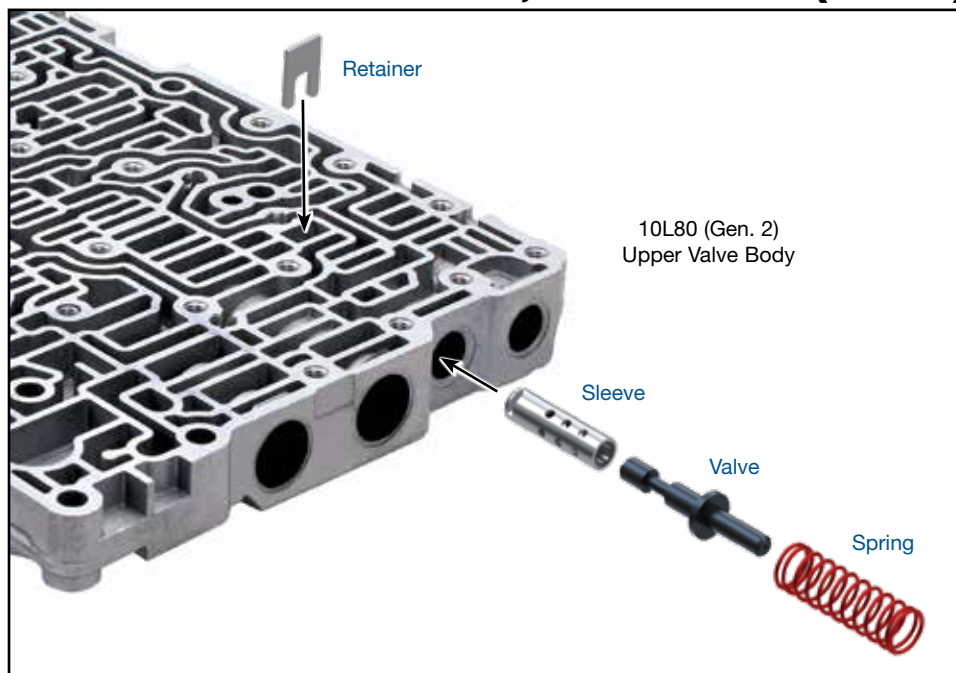
- Valve
- Sleeve
- Spring
- Retainer
- Drill
- Rivet

Not Shown

Not Shown

Patent No. 8,919,381

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

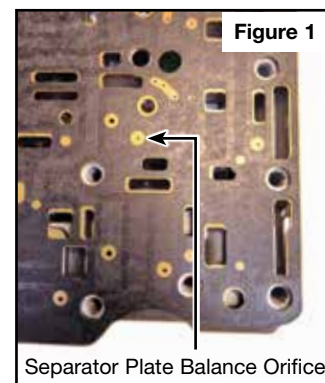


1. Disassembly

- Remove and save OE 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" (**Figure 1**).
- 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.
- 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.

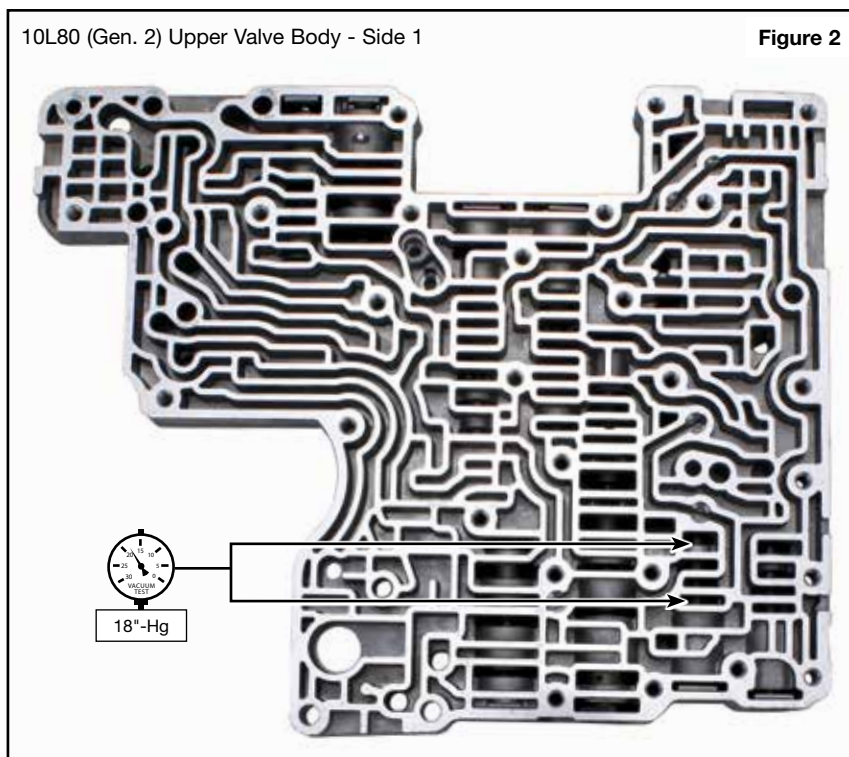
- Install Sonnax spring and reinstall OE retainer.

4. Final Testing

Vacuum testing at the port(s) indicated holds the recommended minimum 18 in-Hg (Figures 2 & 3).

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

Figure 2



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

Figure 3

