

## Feed Limit Low Valve Kit

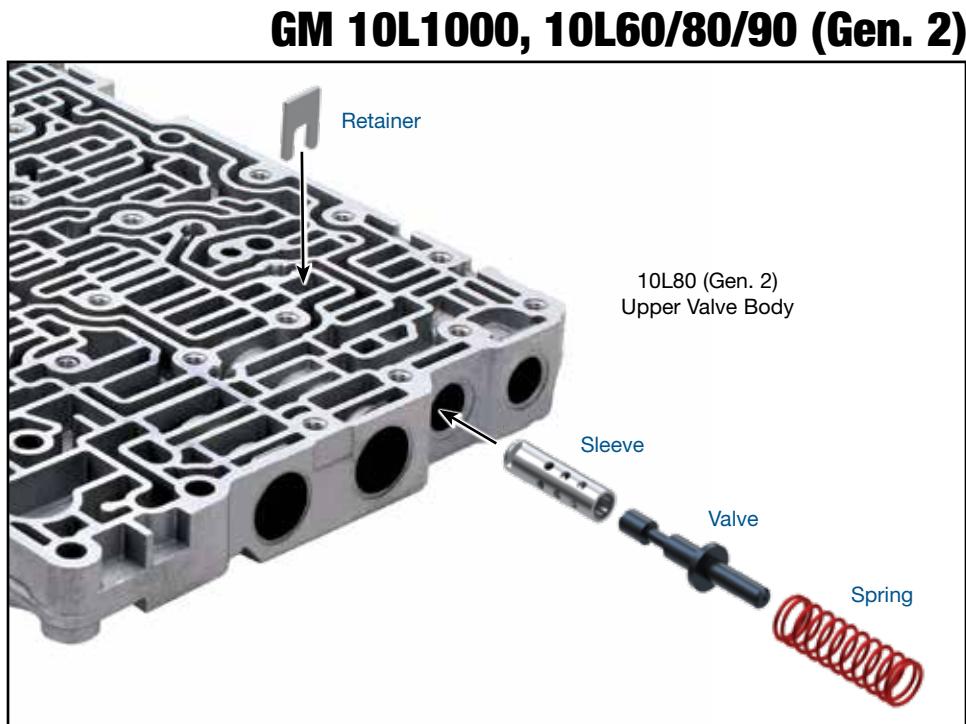
### Part No.

**105740-54K**

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

Not Shown  
Not Shown

Patent No. 8,919,381

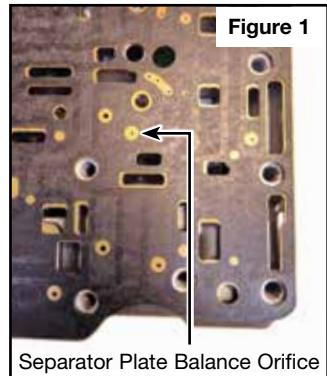


### 1. Disassembly

- 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.

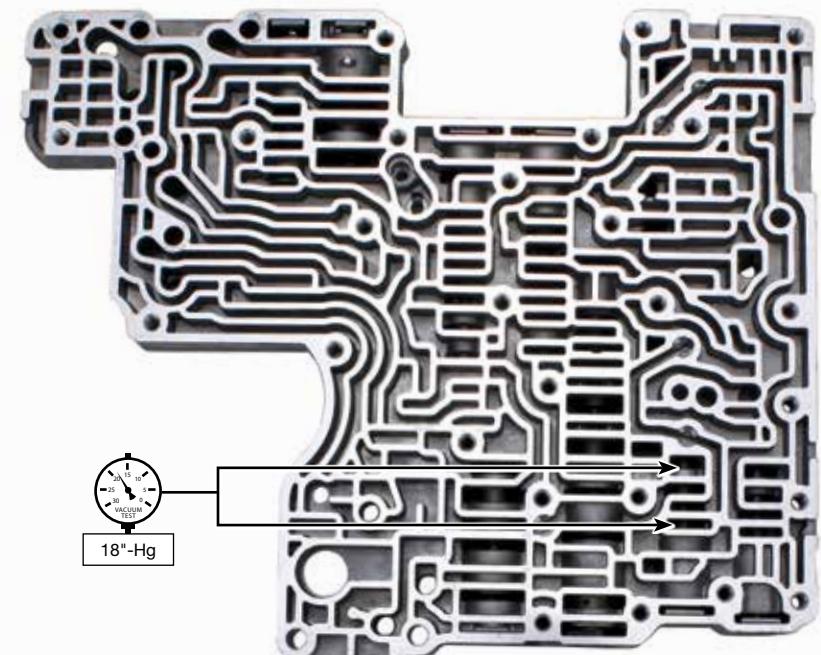
- Install Sonnax spring and reinstall OE retainer.

#### 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

