

Pressure Regulator Valve Kit

Part No.

104520-15K

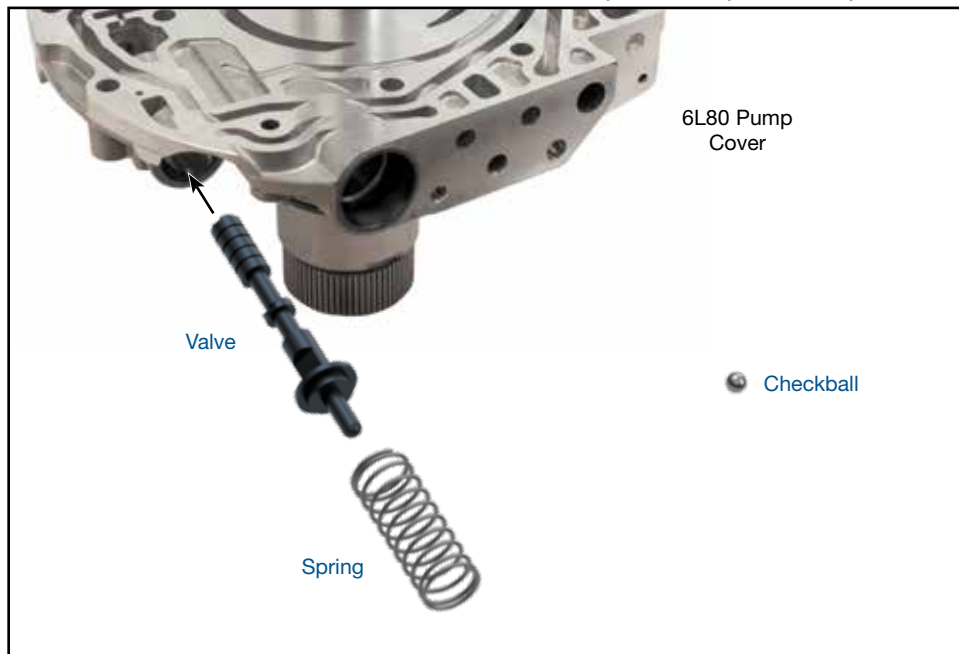
- Valve
- Spring
- Checkball

Also Available

Boost Valve Kit

104520-12K

GM 6L45, 6L50, 6L80, 6L90



NOTE: In GM 6L45, 6L50, 6L80 and 6L90 units the pressure regulator valve and boost assembly are located in the pump cover. Transmission must be removed from the vehicle to access pump and replace the pressure regulator valve.



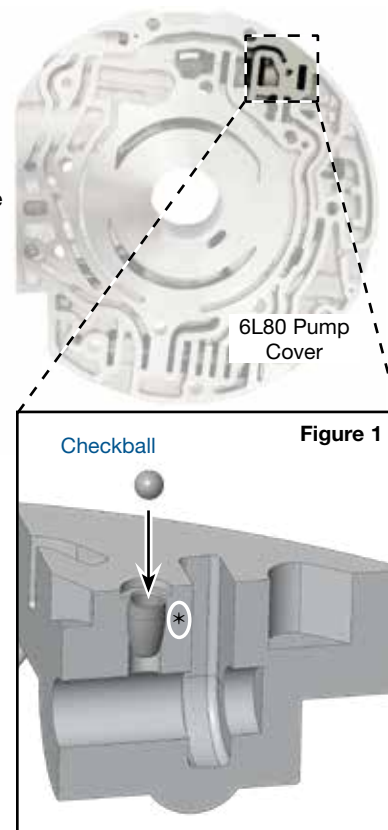
NOTE: If you are rebuilding a pump that has a balance port drilled between the cup plug bore and the balance port shown in **Figure 1** with a circle and asterisk, you will need to take a center punch and peen this port shut.

1. Disassembly

- Remove OE retaining pin, boost assembly and small spring and save for reuse.
- Remove and discard OE pressure regulator valve and large spring.

2. Plug OE Orificed Cup Plug

- Locate OE balance feed orificed cup plug.
- Place Sonnax 1/8" aluminum checkball into OE orificed cup plug. Drive checkball into cup plug with appropriately sized punch. Stake cup plug to prevent checkball displacement (**Figure 1**).
- Clean bore thoroughly, removing all debris and chips.



3. Installation & Assembly

- Install Sonnax pressure regulator valve.
- Install Sonnax matching outer spring.
- Reinstall OE boost valve spring.
- Reinstall OE boost assembly.
- Secure valve train components with OE retaining pin.

4. Final Testing

Vacuum testing at the port(s) indicated holds the recommended minimum 18 in-Hg (**Figure 2**).

