

**Oversized
Lubrication
Valve Kit**



Part No.
139740-03K

- Valve
- Piston
- Spring

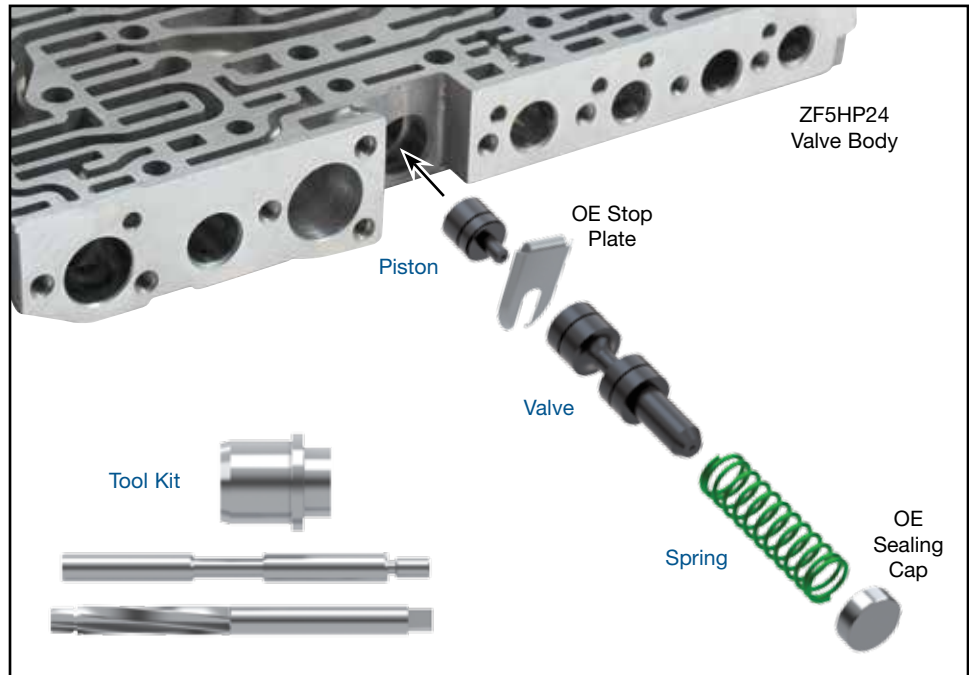
Tool Kit



Part No.
F-139740-TL3

- Reamer
- Reamer Jig
- Guide Pin

NOTE: Sonnax “F-Tool” kits designed to service a specific bore require the VB-FIX, a self-aligning valve body reaming fixture. More information and instructions can be found online at www.sonnax.com.



1. Disassembly

- Remove OE retaining clip and sealing cap; save both for reuse.
- Remove and discard OE spring and valve.
- Take note of installed direction of OE stop plate for reassembly reference, then remove stop plate and set aside for reuse.
- Remove and discard OE piston.

2. Bore Reaming

Ream lubrication valve bore (for reaming instructions/reamer care, please visit www.sonnax.com). Sonnax reaming tool kit **F-139740-TL3** and **VB-FIX** are required for this operation.

3. Installation & Assembly

- Be certain all debris has been removed from valve bore and body.
- Install Sonnax piston, ensuring it bottoms in bore.
- Reinstall OE stop plate, orienting it as noted during disassembly.

ZF5HP24, ZF5HP24A

- Install Sonnax valve with spring stem facing outward.
- Install Sonnax spring, ensuring it seats over valve spring guide.
- Reinstall OE sealing cap and retaining clip.

4. Final Testing

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

