

## Oversized Pressure Regulator Valve



**Part No.**  
**92835-29**

**NOTE:** Fits variable line pressure (VLP 40TES, 41AE, 41TES, 42RLE) units only. VLP units can be identified by the presence of the line pressure solenoid and transducer mounted on the valve body. Non-VLP units can be serviced with Sonnax **92835-24**.

## Tool Kit

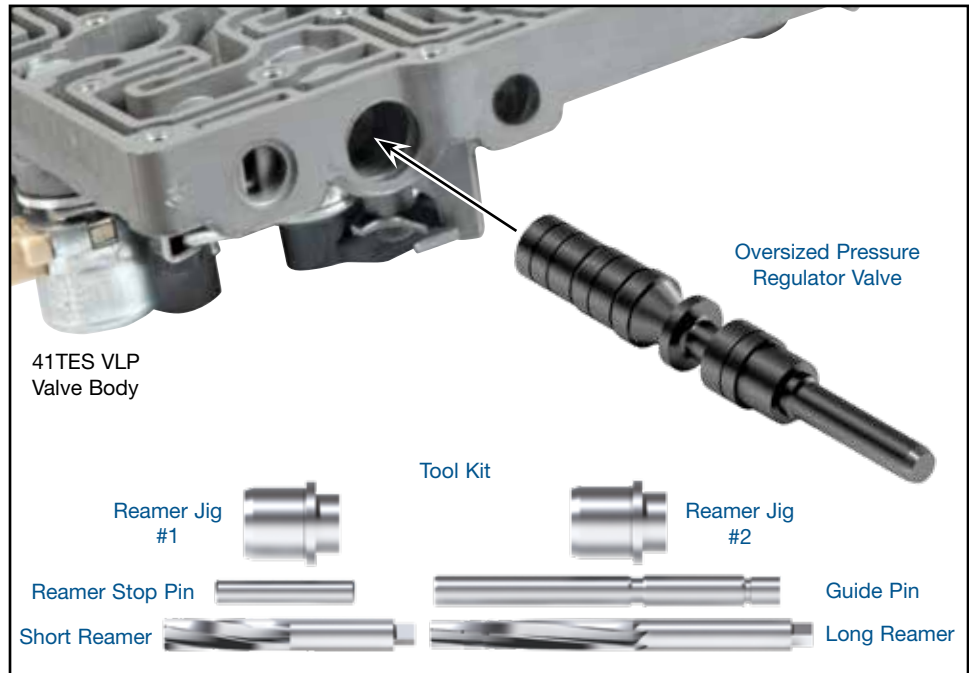


**Part No.**  
**F-92835-TL29**

- Reamers (2)
- Reamer Jigs (2)
- Reamer Stop Pin
- 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](http://www.sonnax.com).

## Chrysler 40TES, 41AE, 41TES, 42RLE, 62TE



### 1. Disassembly

- Remove OE spring retainer and pressure regulator spring and save for reuse.
- Remove and discard OE pressure regulator valve.

### 2. Bore Preparation

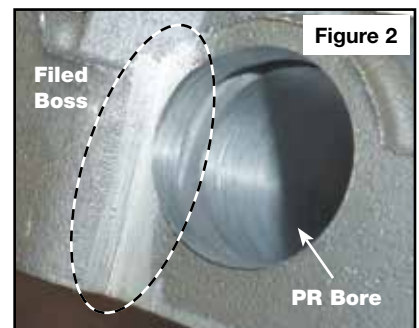
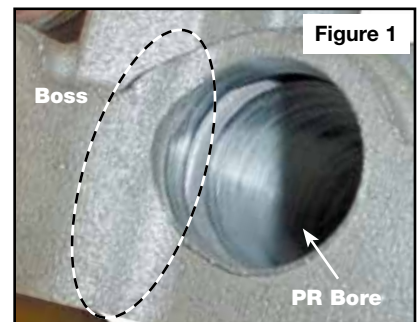
A small amount of material must be removed from the boss protruding near the pressure regulator bore (**Figure 1**).

Removal of material may be done using a 11/16" dia. end mill centered on the pressure regulator bore, or you can file off material using a hand file (**Figure 2**). Enough material must be removed so that the reamer diameter does not contact the boss.

### 3. Bore Reaming

Ream pressure regulator bore (for reaming instructions/reamer care, please visit [www.sonnax.com](http://www.sonnax.com)). Sonnax reaming tool kit **F-92835-TL29** and **VB-FIX** are required for this operation.

- Insert reamer jig #1.
- Use the long guide pin to align valve body bore to reaming fixture. After securing the wing nuts, remove the long guide pin.



### 3. Bore Reaming (continued)

- c. Install reamer stop pin (making sure it is pushed to bottom of the bore) and using the short reamer, ream the spring pocket portion of the bore.



**WARNING:** Do not remove valve body from fixture.

Use low air pressure to clean out debris chips, then remove reamer stop pin.

- d. Insert reamer jig #2.

- e. Using the long reamer, ream the pressure regulator portion of the bore.



**CAUTION:** It is very important NOT to push on the long reamer, especially at the beginning, as this can cause the pilot of the long reamer to cut into the valve body instead of piloting the reamer. If the pilot is allowed to cut into the valve body, the reamer will track off-center and bind.



**NOTE:** It also may be necessary to remove the long reamer and clear the aluminum chips midway through the reaming operation.

### 4. Installation & Assembly

- Ensure all debris has been removed from valve bore and valve body.
- Install Sonnax oversized pressure regulator valve.
- Reinstall OE pressure regulator spring and secure with OE spring retainer.

### 5. Final Testing

Vacuum testing at the port(s) indicated holds the recommended minimum 10, 12, 14, 16 and 18 in-Hg.

