

Reverse Lockout Valve Kit



Part No.

55211-11K

- Valve
- Sleeve
- Spring

Tool Kit



Part No.

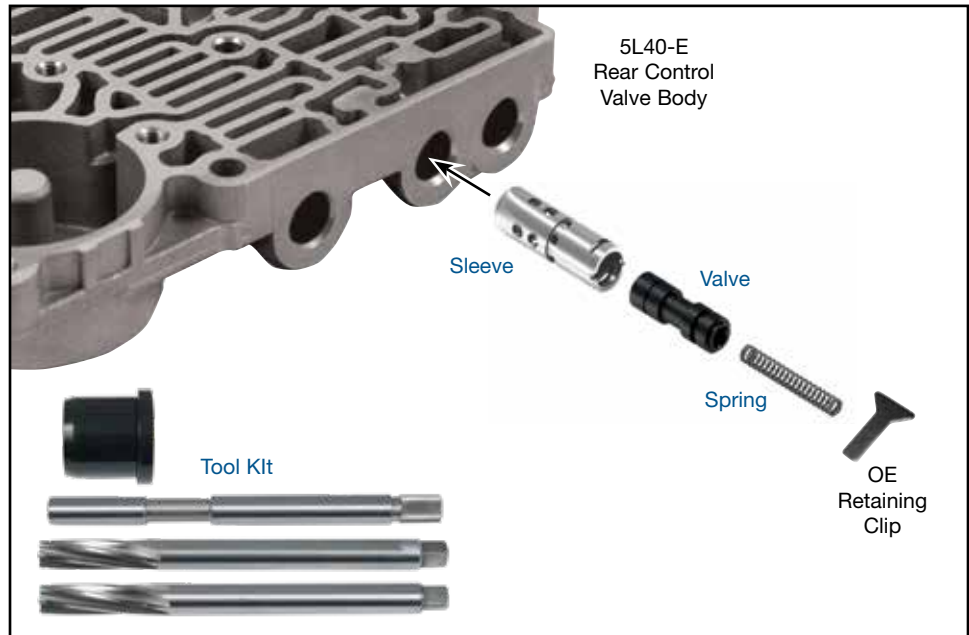
F-55211-TL

- Roughing Reamer
- Finish Reamer
- Reamer Jig
- Guide Pin

NOTE: This tool kit is used for installing both **55211-11K** and **55211-01K**.

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.

GM 5L40-E, 5L50-E



1. Disassembly

- Remove OE retaining clip and keep for reuse.
- Remove OE valve and spring and discard.

2. Bore Reaming

Ream Reverse lockout bore (for reaming instructions/reamer care, please visit www.sonnax.com). Sonnax reaming tool kit **F-55211-TL** and **VB-FIX** are required for this operation.

NOTE: Extra attention should be paid to alignment and securing the valve body to the fixture on this bore. A very smooth action to insert and remove the guide pin after final securing is a must to provide easy, on-center reaming. Do not disturb or loosen the valve body setting or guide setting in any way until the reaming process is complete.

3. Installation & Assembly

- Be certain all debris has been removed from the valve bore and valve body.
- Assemble Sonnax valve and sleeve assembly with the spring pocket in valve and the notched end of sleeve facing outboard.
- Insert Sonnax spring into the valve spring pocket.
- Push Sonnax valve/sleeve/spring assembly into the casting bore, just deep enough to install OE retaining clip into the top of the outboard sleeve slot.
- Compress the spring using a screwdriver blade and finish installing the retainer.

NOTE: The sleeve does NOT bottom in the bore.

4. Final Testing

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

