

Oversized Pressure Regulator Valve Kit

Part No.

84754-46K

- Valve
- Outer Springs (3) Selective

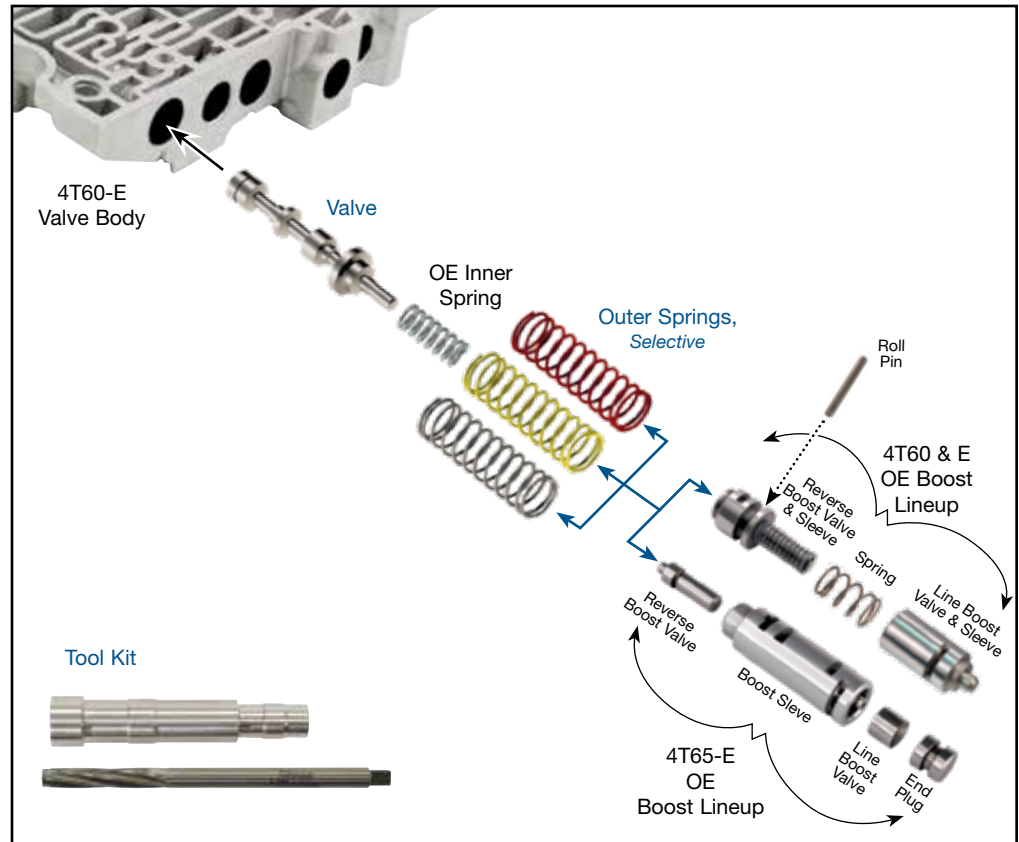
Tool Kit

Part No.

84754-TL46

- Reamer
- Jig

GM 4T60, 4T60-E, 4T65-E



1. Disassembly

- Remove OE retainer from boost sleeve (4T60 & E) or end plug (4T65-E); set retainer aside for reuse.
- 4T65-E:** Remove OE end plug, boost valve and sleeve assembly; set aside for reuse, then skip to step "d".
4T60 & E: Remove OE line boost valve and sleeve assembly; set aside for reuse.
- 4T60 & E:** Remove OE roll pin and Reverse boost valve and sleeve assembly; set aside for reuse.
- Remove OE outer pressure regulator spring; note color of OE spring and refer to chart for correct Sonnax replacement spring. After verifying color, discard OE spring.
- Remove OE inner pressure regulator spring; set aside for reuse.
- Remove and discard OE pressure regulator valve.

2. Bore Preparation

- Saturate reamer jig, valve body bore and reamer with cutting fluid.
- Insert Sonnax reamer jig fully into bore. Pass Sonnax reamer through jig until reamer contacts first land to be reamed.

2. Bore Preparation (continued)

- Using a low-rpm, high-torque drill, turn reamer clockwise at 60 to 200 rpm to ream bore.
- Using low air pressure (35 psi) and with the reamer still in the bore, blow the chips out of the bore.
- While turning the reamer clockwise, remove it from the bore. Clean the remaining chips from the bore.
- Thoroughly clean the valve body. Flush all reaming debris from the bore.

3. Installation & Assembly

- Consult table (Figure 1) to select appropriate Sonnax pressure regulator spring for application.
- Install Sonnax oversized pressure regulator valve.
- Reinstall OE inner pressure regulator spring.
- Install appropriate Sonnax outer pressure regulator spring, selected in step "a".



NOTE: If excess wear is discovered in OE boost assemblies, check with your distributor for Sonnax replacement boost valve kits.

- 4T65-E:** Reinstall OE boost valve/sleeve assembly. Reinstall OE end plug, then skip to step "g".
- 4T60 & E:** Reinstall OE Reverse boost assembly; secure with OE roll pin.
- 4T60 & E:** Reinstall OE line boost spring, followed by boost assembly.
- Reinstall OE retainer.

4. Final Testing

Vacuum testing at the port(s) indicated holds the recommended minimum 18 in-Hg (Figures 2 & 3).

Sonnax Outer Spring Selection

Figure 1

Application	OE Spring Removed	Sonnax Outer Spring
4T65-E	White, Silver or Green	Unpainted Spring
4T60-E	Green/Yellow	Yellow Spring
4T60-E	Blue or White	Red Spring
4T60 (TH440-T4)	Green/Yellow	Yellow Spring

