

### Feed Limit Low Valve Kit

#### Part No.

**105740-54K**

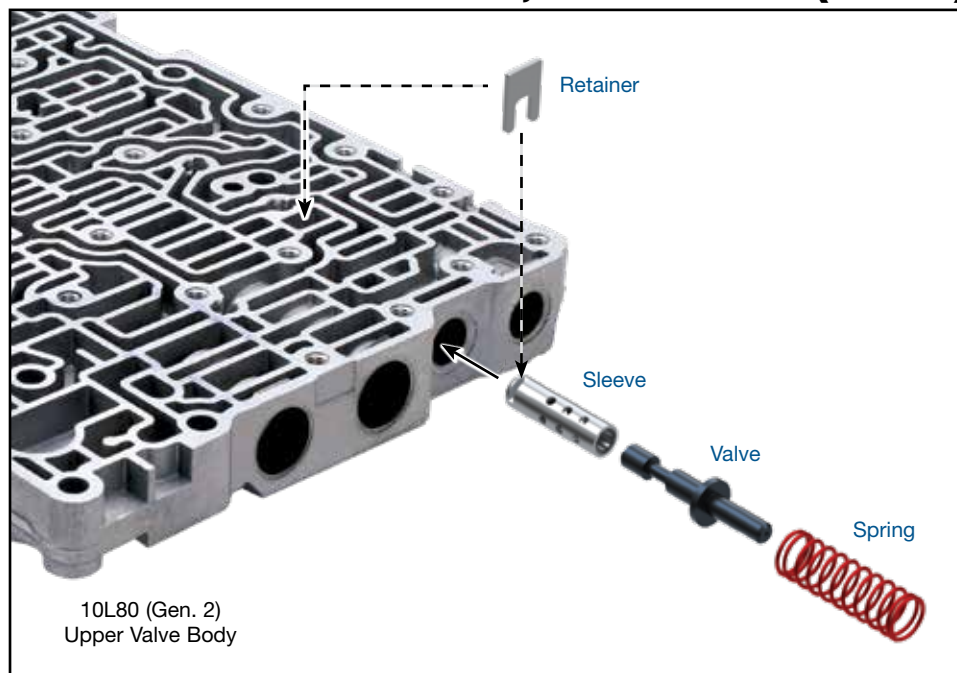
- Valve
- Sleeve
- Spring
- Retainer
- Drill
- Rivet

Not Shown

Not Shown

Patent No. 8,919,381

### GM 10L1000, 10L60/80/90 (Gen. 2)



#### 1. Disassembly

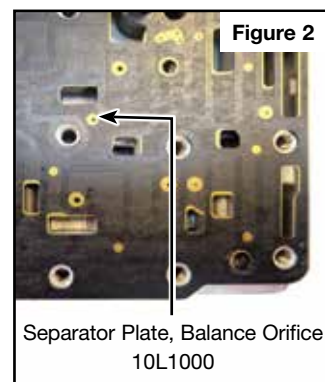
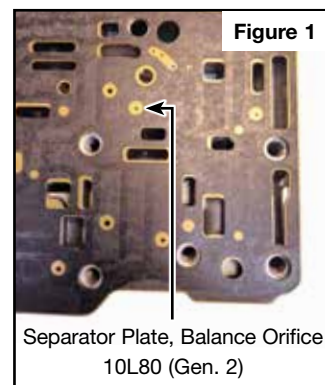
- Remove and save OE spring retainer.
- Remove and discard OE spring and valve.

#### 2. Drill & Plug Separator Plate

- Using included drill bit, drill separator plate balance orifice at feed limit low valve to .063" (**Figures 1 & 2**).
- Insert the rivet into drilled hole and peen on side of the plate. Using wire cutters, snip the stem end of the rivet if/as necessary to provide for a small head once peened in place. Peen the rivet in place on head side of the plate as well.
- After peening on both sides of the plate, ensure plate will still fit flush on mating surface.

#### 3. Installation & Assembly

- Be certain all debris has been removed from the valve bore and valve body.
- Install Sonnax valve/sleeve assembly with grooved end inboard.



### 3. Installation & Assembly (continued)

- c. Secure sleeve by installing Sonnax retainer around sleeve grooves at balance port.



**CAUTION:** Ensure Sonnax retainer is fully seated around the sleeve end in the grooves after installation.

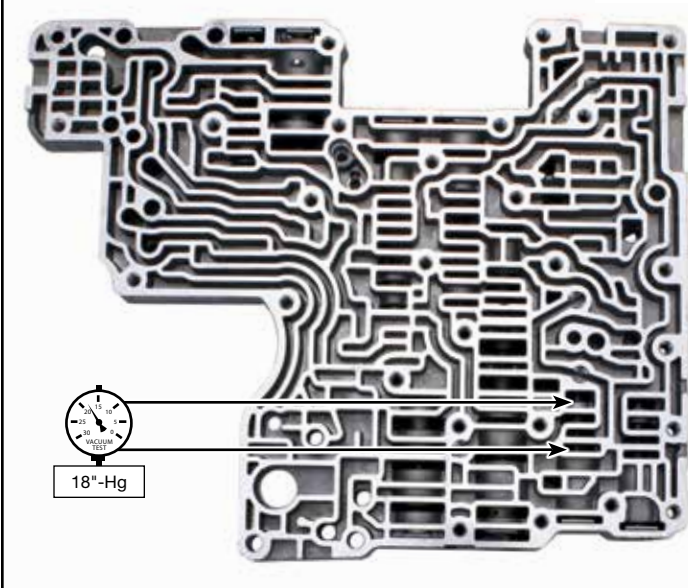
- d. Install Sonnax spring and reinstall OE spring retainer.

### 4. Final Testing

Vacuum testing at the port(s) indicated holds the recommended minimum 18 in-Hg (Figures 3-6).

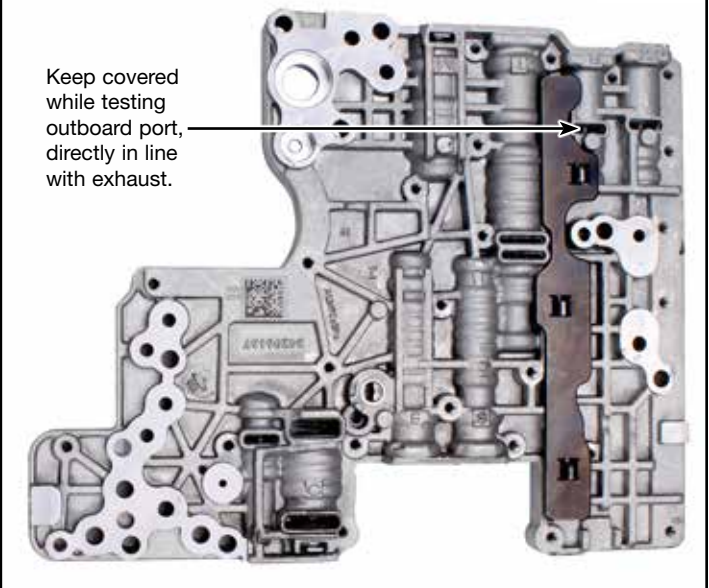
10L80 (Gen. 2) Upper Valve Body - Side 1

Figure 3



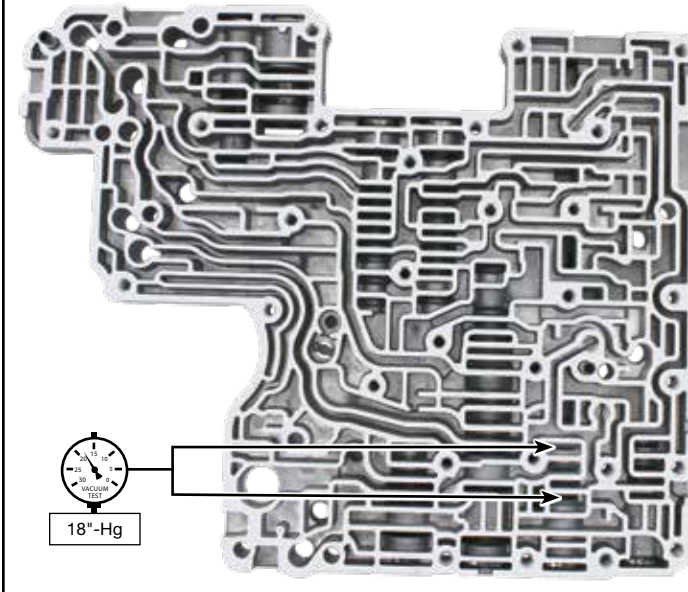
10L80 (Gen. 2) Upper Valve Body - Side 2

Figure 4



10L1000 Upper Valve Body - Side 1

Figure 5



10L1000 Upper Valve Body - Side 2

Figure 6

