

Lube On Demand Valve Kit

Part No.

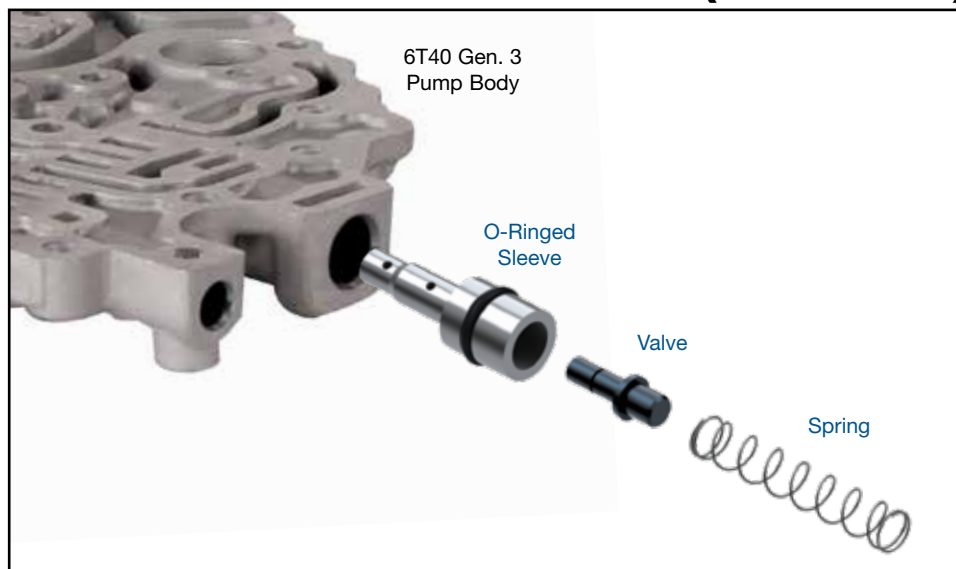
144510-19K

- Valve
- Sleeve
- O-Rings (2) 1 Extra
- Spring
- Drill Bit* .062"
- Plugs* (2) 1 Extra
- Rivets* (2) 1 Extra

***NOTE:** For separator plate, not shown.

Patent Pending

6T31/35/41/46/51 (Gen. 3 6T40)



1. Disassembly

- a. Remove OE retainer and set aside for reuse.
- b. Remove and discard OE valve and spring.

2. Drill & Plug Separator Plate Balance Orifice at Lube Boost Valve

- a. Using Sonnax drill bit, drill lube boost valve balance orifice to .062" (**Figure 1**).
- b. If using straight plug, insert into orifice and peen on both sides of plate.
- c. If using optional small rivet, insert into orifice and 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 plate also.
- d. After peening on both sides of the plate, ensure plate will still fit flush on mating surfaces.

3. Installation & Assembly

- a. Place O-ring on the valve and sleeve assembly.
- b. Coat O-ring with assembly lube or Sonnax Slippery Stick **O-LUBE** and roll on bench to size.
- c. Install the assembly into the bore with the O-ring end toward the outside of the bore.
- d. Install the Sonnax spring.
- e. Secure components with the OE retainer.

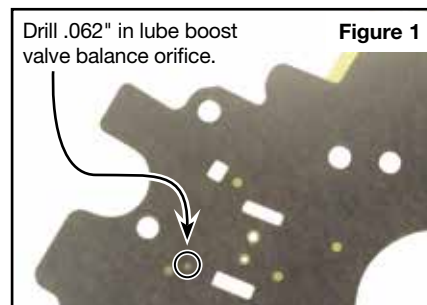


Figure 1

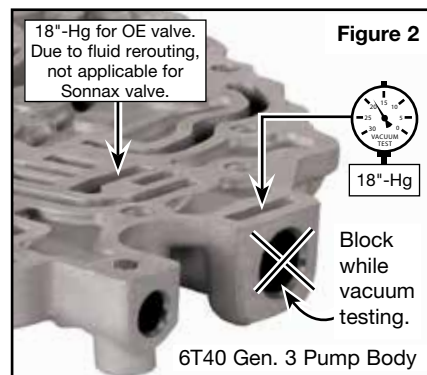


Figure 2

4. Final Testing

Vacuum testing at the port(s) indicated holds the recommended minimum 18 in-Hg (**Figure 2**).