

## Oversized 1-2/4-5 Overlap Control Valve Kit



Part No.

**68942-19K**

- Overlap Control Valve
- Plunger Valve
- Plunger Sleeve
- O-Ring
- Spring

## Tool Kit



Part No.

**F-68942-TL19**

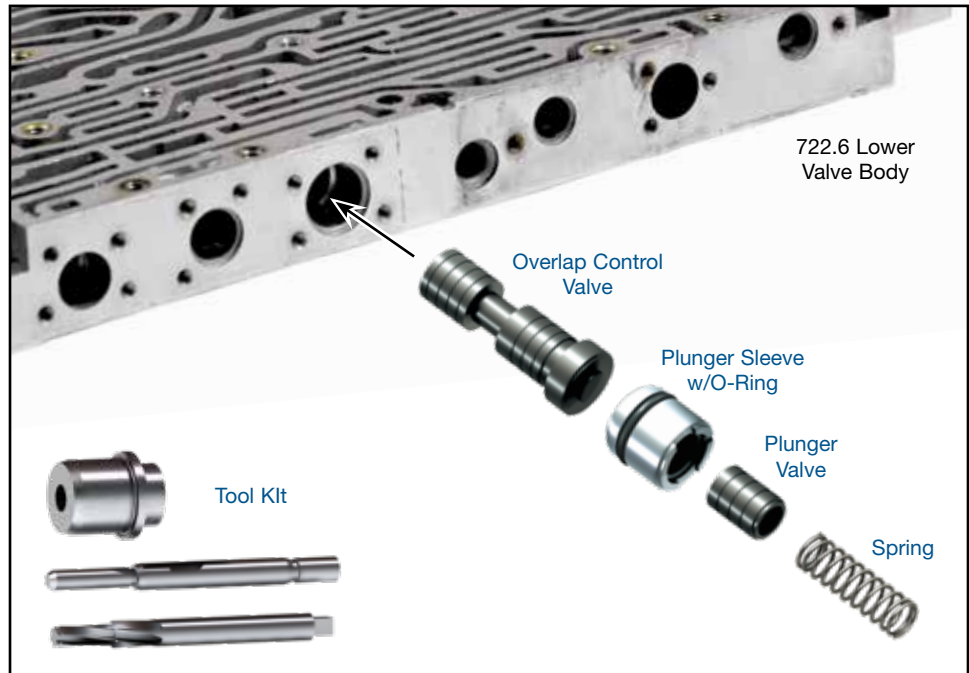
- Reamer
- Reamer Jig
- Guide Pin

**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).



**WARNING:** Required tool kit F-68942-TL19 is no longer in production. Check with your distributor for availability.

## Mercedes 722.6



### 1. Disassembly

- Remove OE screws and end plate and save for reuse.
- Remove and discard OE spring, plunger valve and sleeve, and overlap control valve.

### 2. Bore Reaming

Ream overlap control valve bore (for reaming instructions/reamer care, please visit [www.sonnax.com](http://www.sonnax.com)). Sonnax reaming tool kit **F-68942-TL19** and **VB-FIX** are required for this operation.

### 3. Installation & Assembly

- Ensure all debris has been removed from valve bore and body.
- Install Sonnax oversized overlap control valve into bore, small diameter first.
- Install O-ring into sleeve groove and roll on bench to size. Lubricate sleeve and O-ring.
- Install spring into plunger valve spring pocket. Slide plunger valve into sleeve, with spring facing grooved end face of sleeve.
- Slowly install sleeve assembly into valve body bore, taking care not to shear O-ring. Ensure sleeve end face grooves are outward.
- Reinstall OE end plate and screws.

### 4. Final Testing

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

