

## Solenoid Modulator Valve Kit

### 25741-18K

- Solenoid Modulator Sleeve
- Solenoid Modulator Valve
- Spring
- Oversized End Plug

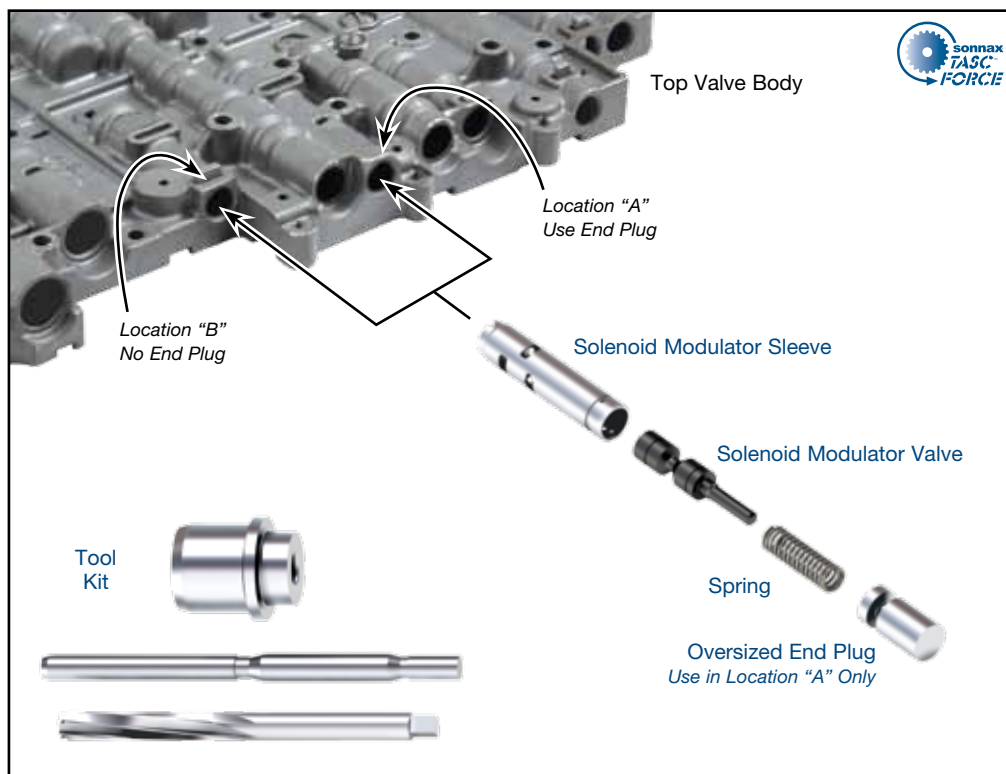
**NOTE:** Also fits VW/Audi 09D.

### Tool Kit

#### F-25741-TL18

- 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 are available at [www.sonnax.com](http://www.sonnax.com).



### 1. Disassembly

- Remove and discard OE valve, spring (in bore "A" and "B") and end plug (in bore "A" only).
- Keep OE retainer for reuse.

### 2. Bore Preparation

- Clean the bore thoroughly in a solvent tank.
- Generously lubricate the bore and reamer with cutting fluid (i.e. Mobilmet S-122, Lubegard Bio-Tap, Tap Magic™, etc.). For best results, provide a continuous flow of water-soluble cutting fluid (i.e. Mobilmet S-122) during the reaming process.
- The reamers should be turned using a low RPM, high-torque air drill regulated to a maximum of 200 RPM.
- Examine the bore after cleaning for surface finish, debris and burrs. Flashing and burrs on the exit side of land and bores must be carefully removed. A small piece of Scotch-Brite™ material attached to a wire and powered with a drill motor is ideal for the task. Scotch-Brite™ is a very abrasive material and all residual must be cleaned to insure particles do not migrate or remain imbedded into the surface. Post cleaning involves several progressive steps with solvent on a lint-free rag.

#### CAUTIONS AND SUGGESTIONS:

- Turning the reamer backward will dull it prematurely.
- Pushing on the reamer will result in poor surface finish and inadequate and sporadic material removal.
- Never use a crescent wrench, ratchet or pliers to turn the reamer.
- A dull reamer will cut a smaller hole. Reamers can be sharpened, but should only be done by a professional tool sharpener. Actual life of a Sonnax reamer before resharpening or replacing averages 50-70 bores.

# AISIN AW TR-60SN

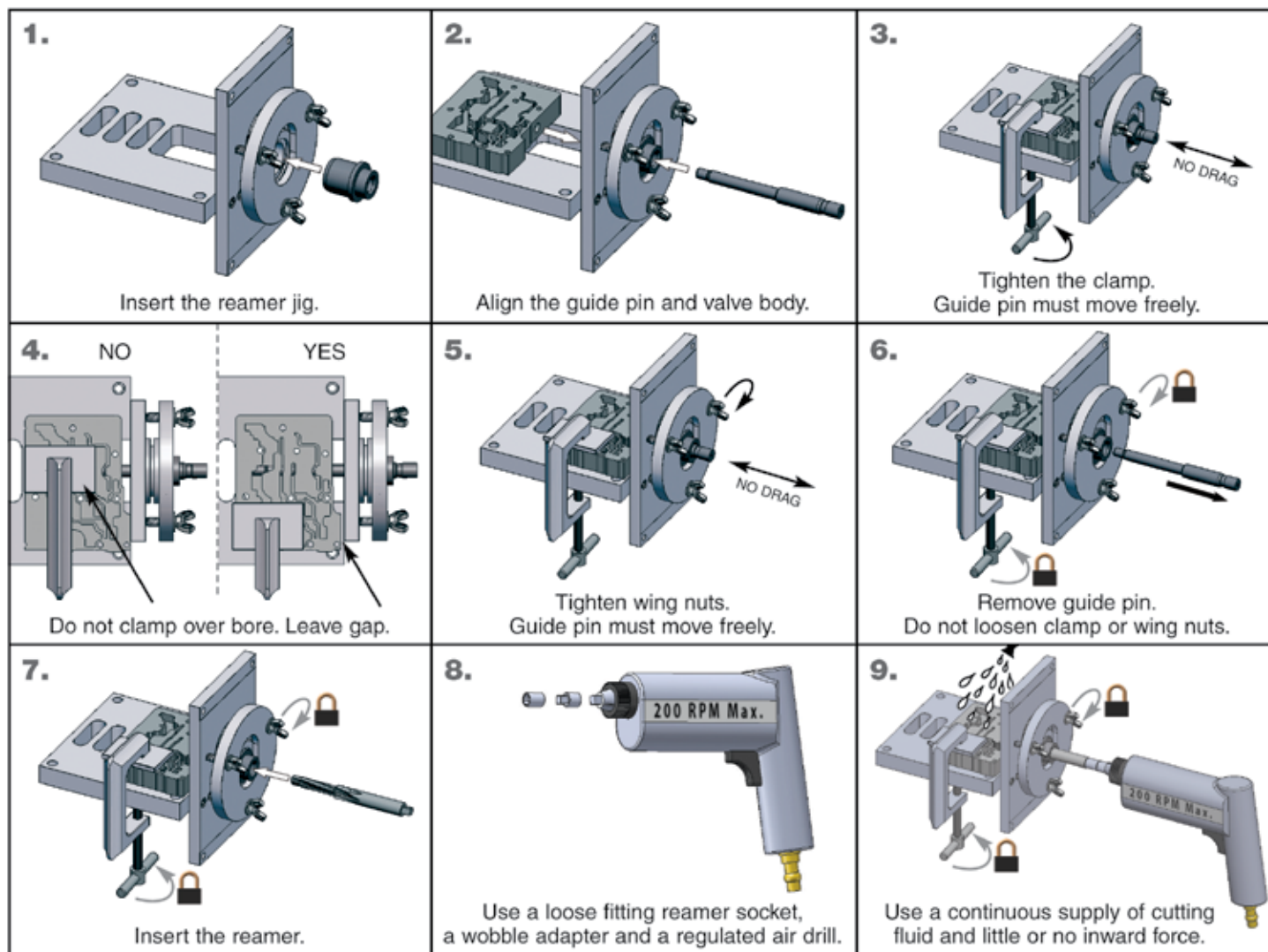
Solenoid Modulator  
Valve Kit

PART NUMBERS 25741-18K, F-25741-TL18

INSTRUCTION DATA SHEET

## 3. Bore Reaming

Use the associated "F-Tool" kit F-25741-TL18 and VB-FIX reaming fixture as illustrated below to ream the bore.



## 4. Installation & Assembly

- Be certain all debris has been removed from the valve bores and valve body.
- Install Sonnax sleeve and valve. Be sure that the notched end of the sleeve is installed into the valve body first. Install the valve with the spool diameter end first, so the spring guide is facing out.
- Install the Sonnax spring.
- Install the Sonnax end plug (in bore "A" only). The retaining clip groove end should be installed first, so that it is closest to the spring.
- Reinstall the OE retaining clip.

## 5. Final Testing

A vacuum test at either port should hold 18" of vacuum or more.

