

## Secondary Pressure Regulator Valve Kit

### 25741-11K

- Secondary Pressure Regulator Valve
- Boost Valve & Sleeve Assembly

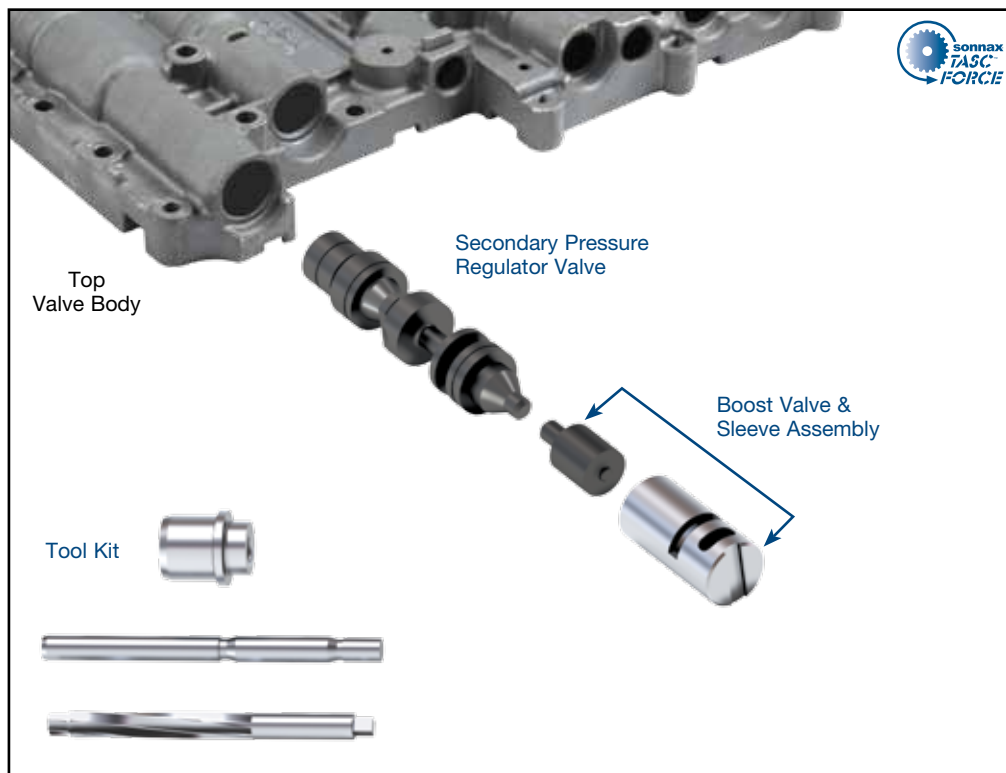
**NOTE:** Also fits VW/Audi 09D.

### Tool Kit

#### F-25741-TL11

- 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 boost valve and sleeve assembly.
- Remove and discard OE secondary pressure regulator valve.
- Keep OE spring and 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.

### 3. Bore Reaming

Use the associated "F-Tool" kit F-25741-TL11 and VB-FIX reaming fixture as illustrated on the next page to ream the bore.

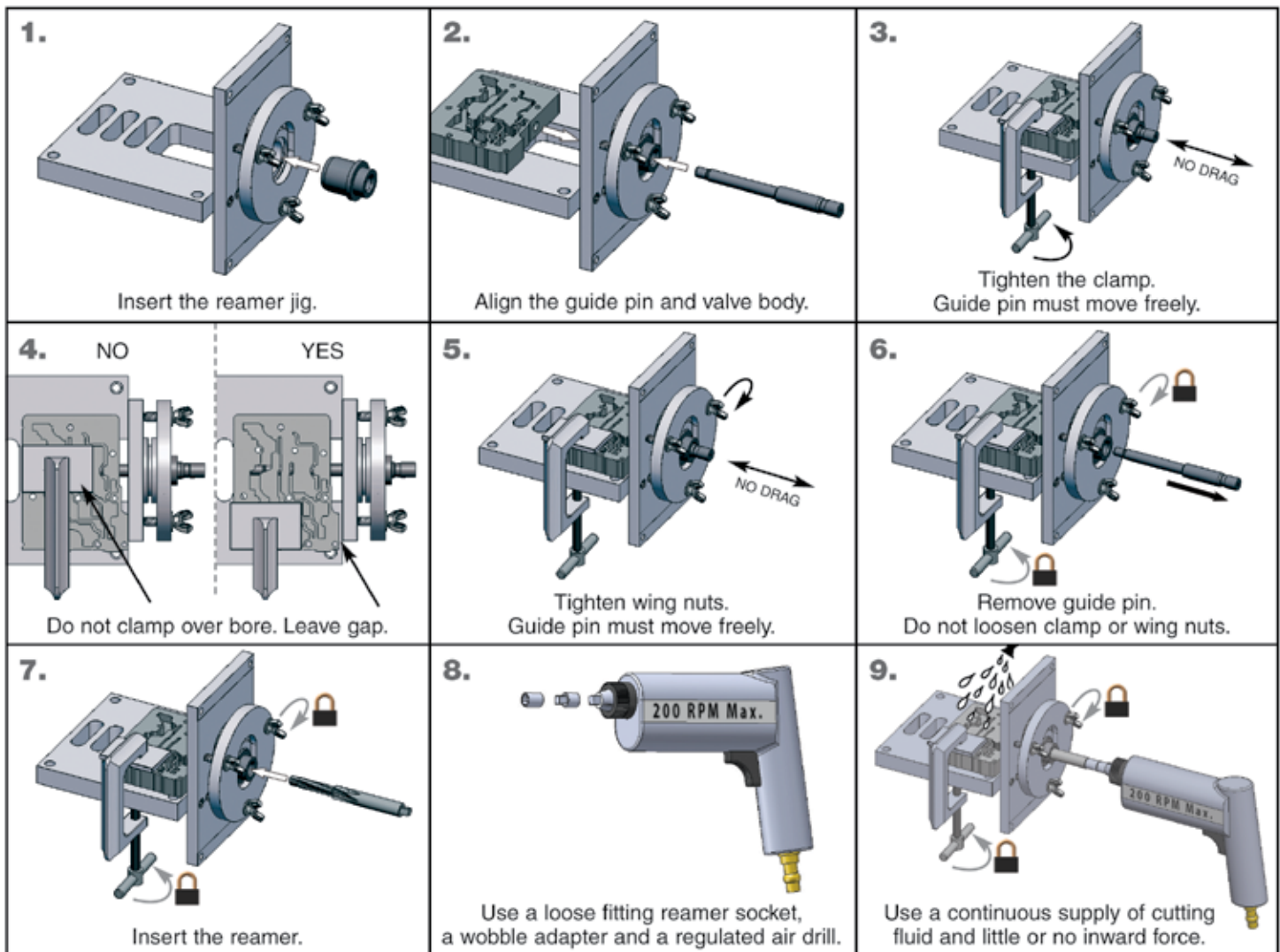
# AISIN AW TR-60SN

PART NUMBERS 25741-11K, F-25741-TL11

INSTRUCTION DATA SHEET

Secondary Pressure  
Regulator Valve Kit

## 3. Bore Reaming (continued)



## 4. Installation & Assembly

- Be certain all debris has been removed from the valve bores and valve body.
- Install the Sonnax pressure regulator valve.
- Re-install OE spring.
- Install the Sonnax boost valve and sleeve assembly.
- Re-install retaining clip.

## 5. Final Testing

Vacuum test fails to yield the indicated 16 or 18 in-hg or greater, depending on the port tested as shown, or if visual wear is detected.

