

Solenoid Modulator Valve Kit

15741-18K Use in Two Locations

- 1 Solenoid Modulator Valve
 - 1 Solenoid Modulator Sleeve
 - 1 Spring
 - 1 Plug
- Used in Upper VB #2 Only



F-15741-TL18

- 1 Reamer
- 1 Guide Pin
- 1 Reamer Jig

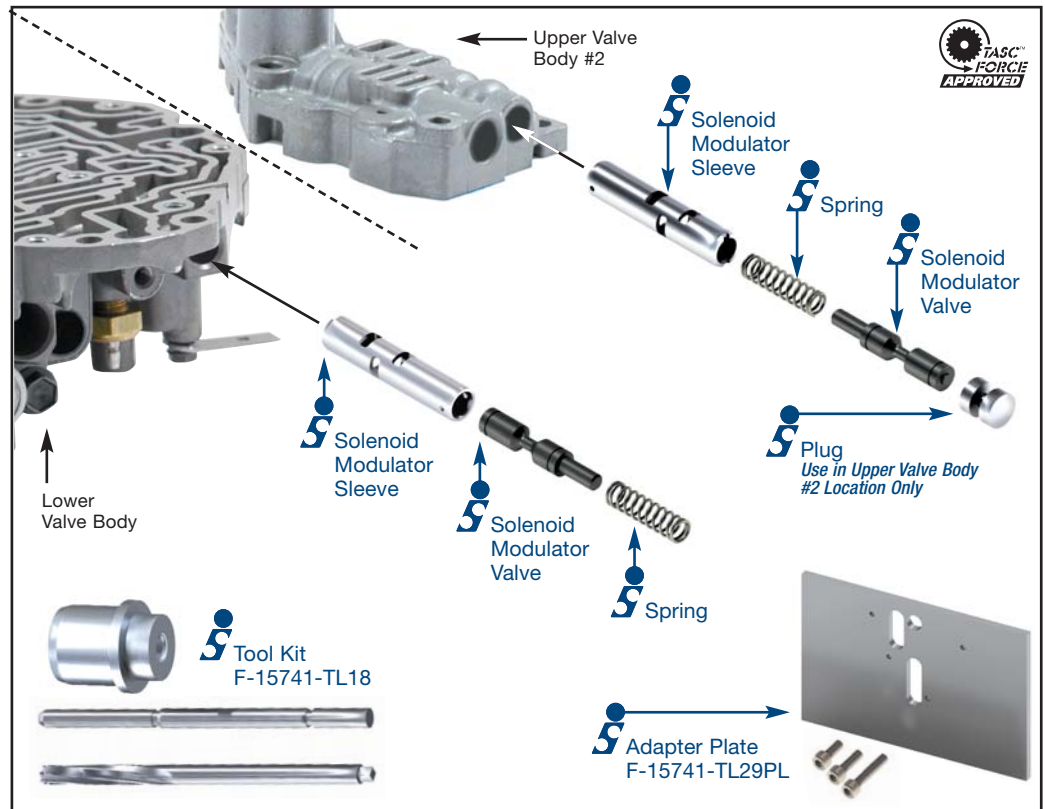


Note: Fits BMW 6F21WA & VW/Audi 09G, 09K, 09M.

F-15741-TL29PL

- 1 Adapter Plate
- 3 Assorted Screws

Note: Mounting plate F-15741-TL29PL is required for reaming Upper Valve Body #2.



Caution

Adapter plate F-15741-TL29PL is required to hold TF-60SN upper valve body #2 section while reaming.

Note: Mounting instructions are included with the Adapter plate F-15741-TL29PL.

Disassembly Steps

Remove and discard the OEM valve, spring and end plug if applicable.

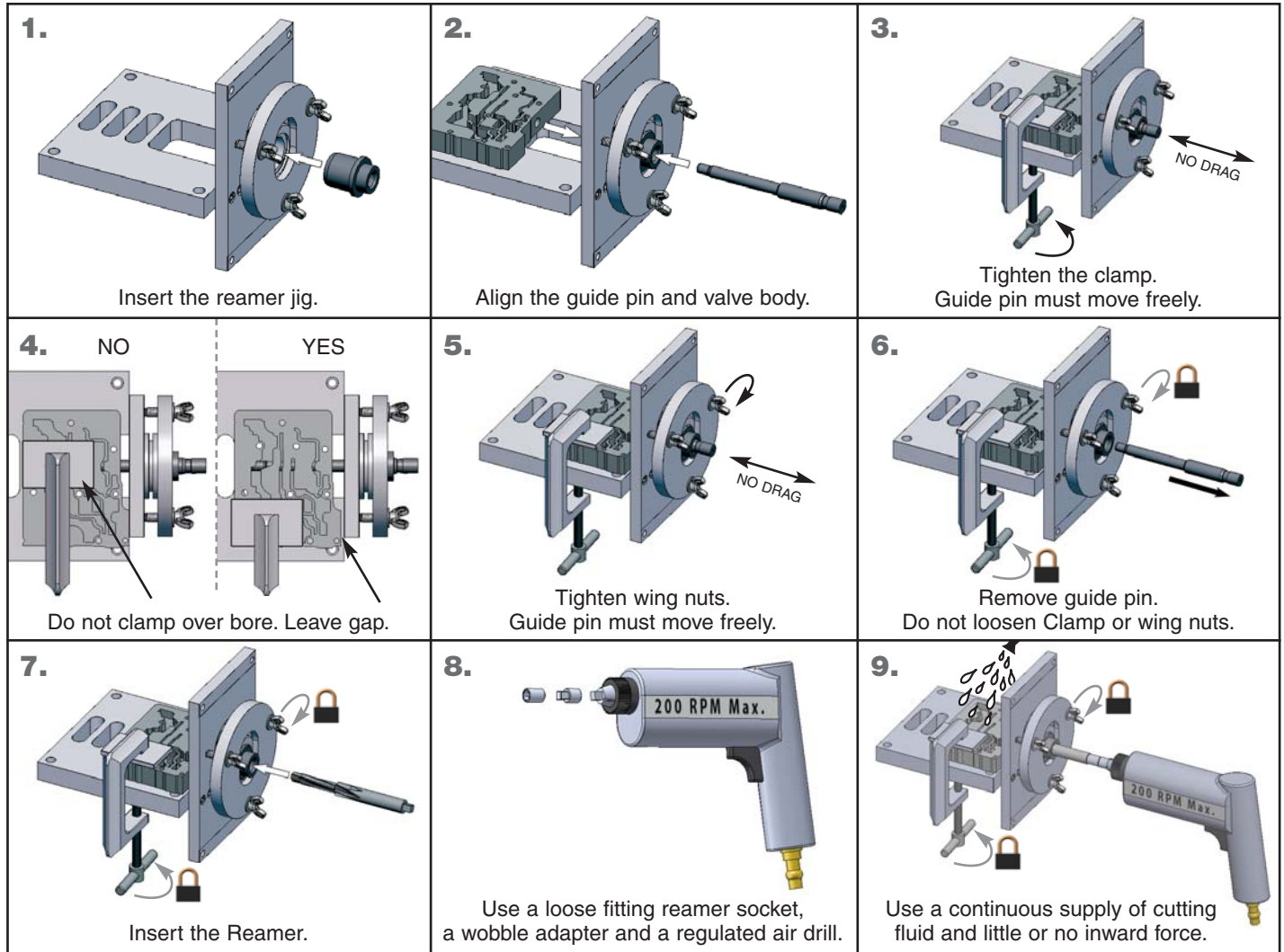
Important Notes:

1. Clean the bore thoroughly in a solvent tank.
2. 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.
3. The reamers should be turned using a low rpm, high torque air drill regulated to a maximum of 200 rpm.
4. Examine the bore after cleaning for surface finish, debris, and burrs. Flashing and burrs on the exit side of lands and bores must be carefully removed. A small piece of Scotchbrite™ material attached to a wire and powered with a drill motor is ideal for the task.

Reaming Instructions

Note: When reaming the Upper Valve Body #2, use of Mounting Plate F-15741-TL29PL is required. Follow the instructions packaged with this Mounting Plate.

Reaming Instructions



Cautions and Suggestions

1. Turning the reamer backward will dull it prematurely.
2. Pushing on the reamer will result in poor surface finish and inadequate and sporadic material removal.
3. Never use a crescent wrench, ratchet or pliers to turn the reamer.
4. 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 reamer before resharpening or replacing averages 50-70 bores.

Installation/Assembly Steps

1. Insert the valve/sleeve assembly and Sonnax spring into the reamed bore as shown in photo.

Important Note: Orientation is different for the Lower valve body and Upper valve body #2 locations!

2. If applicable, insert replacement end plug into bore and secure with OEM retainer.
3. If no OEM end plug was used, disregard the replacement end plug and secure sleeve/valve assembly and spring with OEM retainer.

Note: In some instances, the sleeve may be slightly long (.010"-.020") for the bore, preventing the retainer from securing the parts properly. If this is the case, carefully flat sand the outboard face of the sleeve until the sleeve is of proper length to fit in the bore.