

Accumulator Control Valve Kit

63741-20K

- 1 Accumulator Control Valve
- 1 Accumulator Control Sleeve
- 1 Spring
- 1 Spring
- 1 End Plug



Silver
Yellow

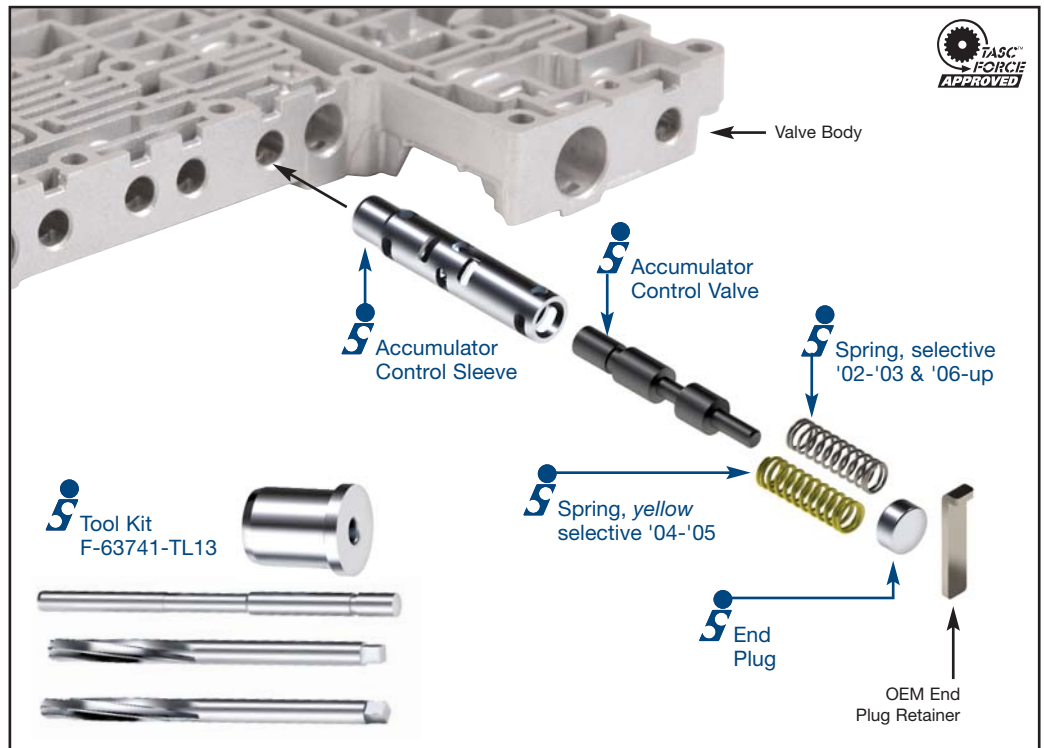
F-63741-TL13

- 2 Reamers *See Important Note
- 1 Guide Pin
- 1 Reamer Jig



Notes: Fits Nissan, Infinity RE5R05A and Kia A5SR1/A5SR2.

Tool kit **F-63741-TL13** can also be used for valve kits **63741-13K** & **63741-17K**.



Note

Sonnax tool kit **F-63741-TL13** and the valve body reaming fixture **VB-FIX** are required to hold, align and ream the accumulator control valve bore.

Disassembly Steps

1. Remove the OEM retainer pin, end plug, spring, valve and sleeve.
2. Keep OEM end plug retainer pin for reuse.
3. Discard the remainder of the OEM valve train.

Important Notes:

1. ***Only one of the reamers from tool kit F-63741-TL13 will be used to ream a single bore!**
 - Use F-63741-RM13 reamer prior to installing kits 63741-13K or 63741-17K.
 - Use F-63741-RM20 reamer prior to installing kit 63741-20K.
2. Clean the bore thoroughly in a solvent tank.
3. 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.

4. The reamers should be turned using a low rpm, high torque air drill regulated to a maximum of 200 rpm.
5. 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.

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 sharpening or replacing averages 50-70 bores.

RE5R05A

PART NUMBERS 63741-20K, F-63741-TL13

Accumulator Control Valve Repair Kit

Reaming Instructions

| | | |
|--|---|--|
| <p>1.</p> <p>Insert the reamer jig.</p> | <p>2.</p> <p>Align the guide pin and valve body.</p> | <p>3.</p> <p>Tighten the clamp. Guide pin must move freely. NO DRAG</p> |
| <p>4.</p> <p>Do not clamp over bore. Leave gap.</p> | <p>5.</p> <p>Tighten wing nuts. Guide pin must move freely. NO DRAG</p> | <p>6.</p> <p>Remove guide pin. Do not loosen Clamp or wing nuts.</p> |
| <p>7.</p> <p>Insert the Reamer.</p> | <p>8.</p> <p>Use a loose fitting reamer socket, a wobble adapter and a regulated air drill. 200 RPM Max.</p> | <p>9.</p> <p>Use a continuous supply of cutting fluid and little or no inward force. 200 RPM Max.</p> |

Installation Steps

1. Be certain all debris has been removed from the valve body & bores.
2. Select the appropriate spring (see chart below).

| OEM Spring | Sonnax Selective Spring | Application |
|---|---|----------------------|
| <ul style="list-style-type: none"> • 9.5 total coils • Left hand wind (<i>anti-clockwise</i>) | <ul style="list-style-type: none"> • Silver (unpainted) Spring | '02 - '03 & '06 - up |
| <ul style="list-style-type: none"> • 8.5 total coils • Right hand wind (<i>clockwise</i>) | <ul style="list-style-type: none"> • Yellow (painted) Spring | '04 - '05 |

3. Install the new Sonnax Accumulator Control valve & sleeve assembly, selective spring and end plug.
4. Install the OEM spring retainer.

Note: In some instances, the combined length of the sleeve and end plug may be slightly long (.010"-.020") for the bore, preventing the insertion of the retainer. To correct this condition carefully flat sand either face of the end plug until the retainer fits into position.

Final Verification Steps

Vacuum test as shown in illustration.

