

Lockup Clutch Control Valve Kit

25741-29K

- Plunger Valve
- Plunger Sleeve
- Plunger Spring
- Lockup Clutch Control Valve
- Lockup Clutch Control Sleeve



NOTE: Also fits VW/Audi 09D.

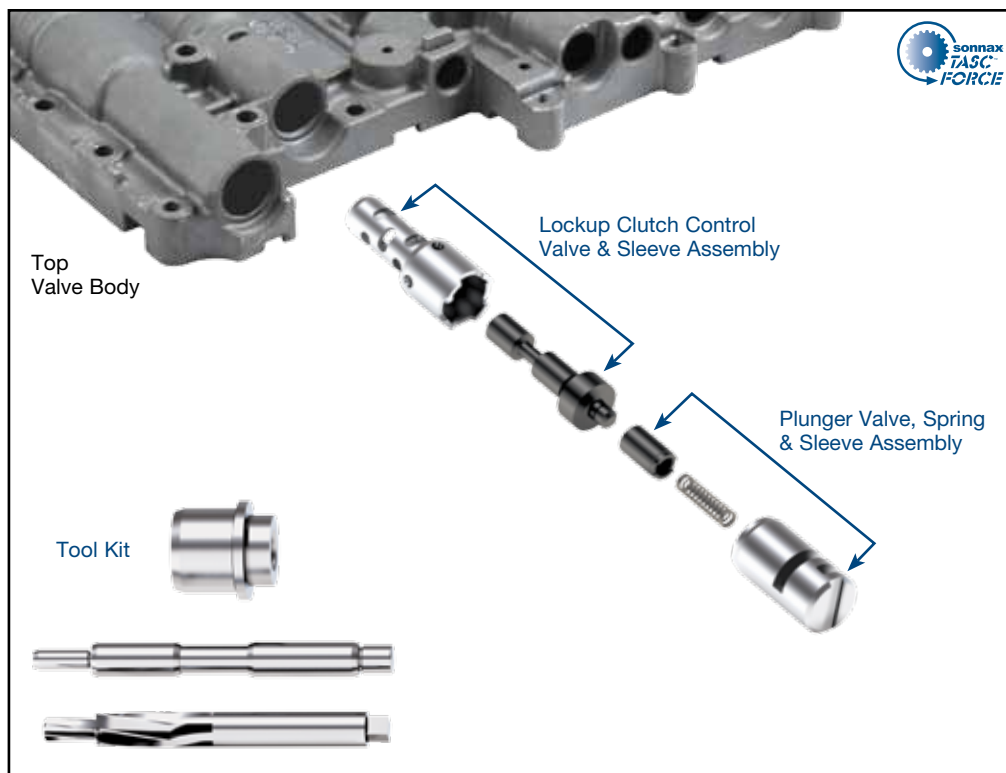
Tool Kit

F-25741-TL29

- 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.



1. Disassembly

- Remove OE retainer and save for reuse.
- Remove and discard the OE plunger sleeve, valve and spring assembly, and the lockup valve.

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. Mobilment 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 sharpening or replacing averages 50-70 bores.

AISIN AW TR-60SN

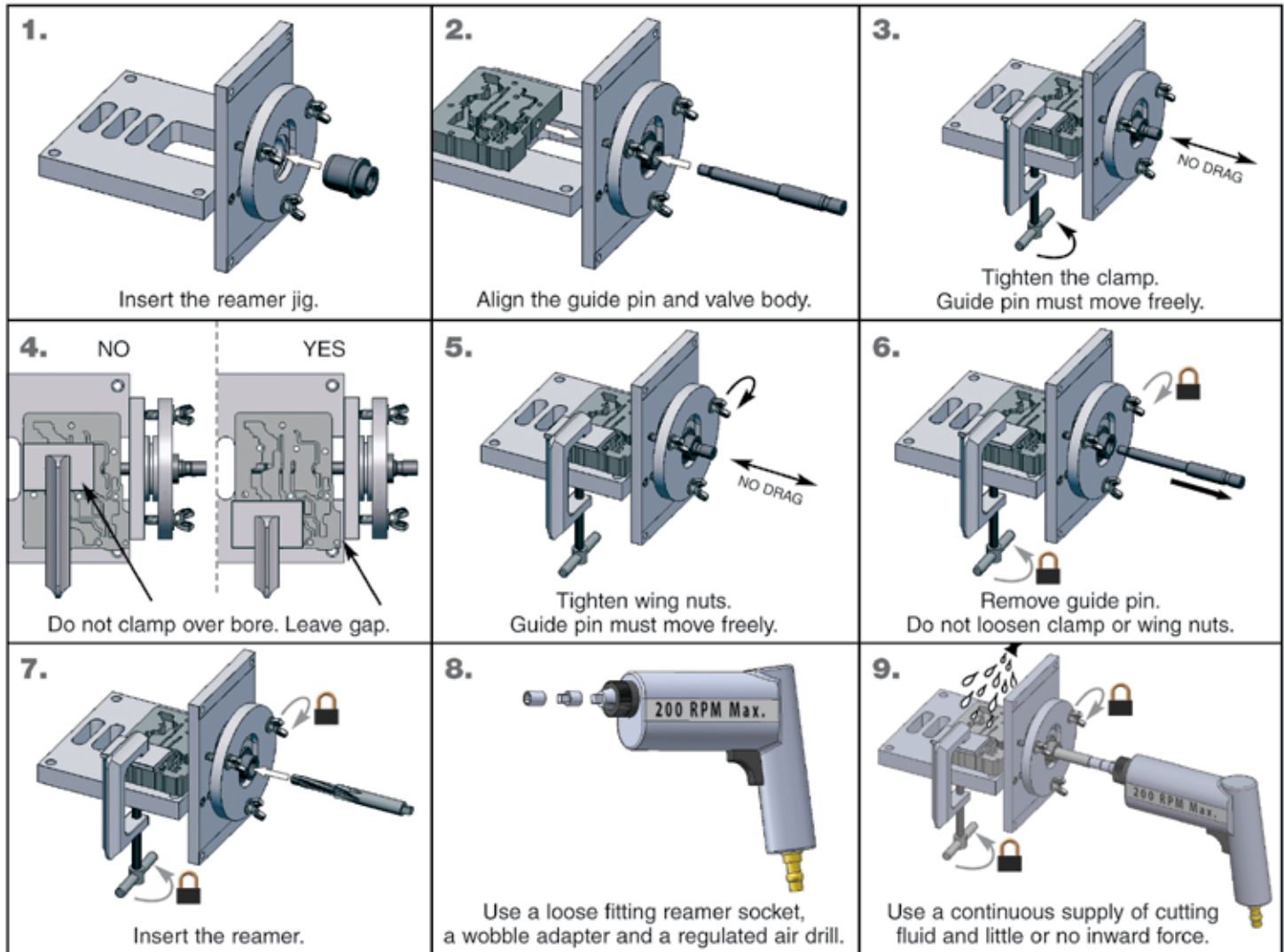
PART NUMBERS 25741-29K, F-25741-TL29

INSTRUCTION DATA SHEET

**Lockup Clutch
Control Valve Kit**

3. Bore Reaming

Use the associated “F-Tool” kit F-25741-TL29 and VB-FIX reaming fixture as illustrated below to ream the bore.



4. Installation & Assembly

- Insert the Sonnax lockup clutch control valve and sleeve assembly into the reamed bore with the smaller sleeve OD inboard.
- Insert the Sonnax plunger spring into the plunger sleeve, followed by the plunger valve. Install the plunger assembly into the reamed bore with the sleeve's open end inboard.
- Install the OE retainer.

NOTE: If the stack-up of components does not allow the installation of the retainer, carefully remove the minimum necessary material from the open, or inboard end, of the plunger sleeve. Be sure to remove any burrs which may interfere with plunger valve movement.

5. Final Testing

A vacuum test at the indicated ports fails to yield 18 in-hg or greater.

