

Secondary Regulator Valve Kit

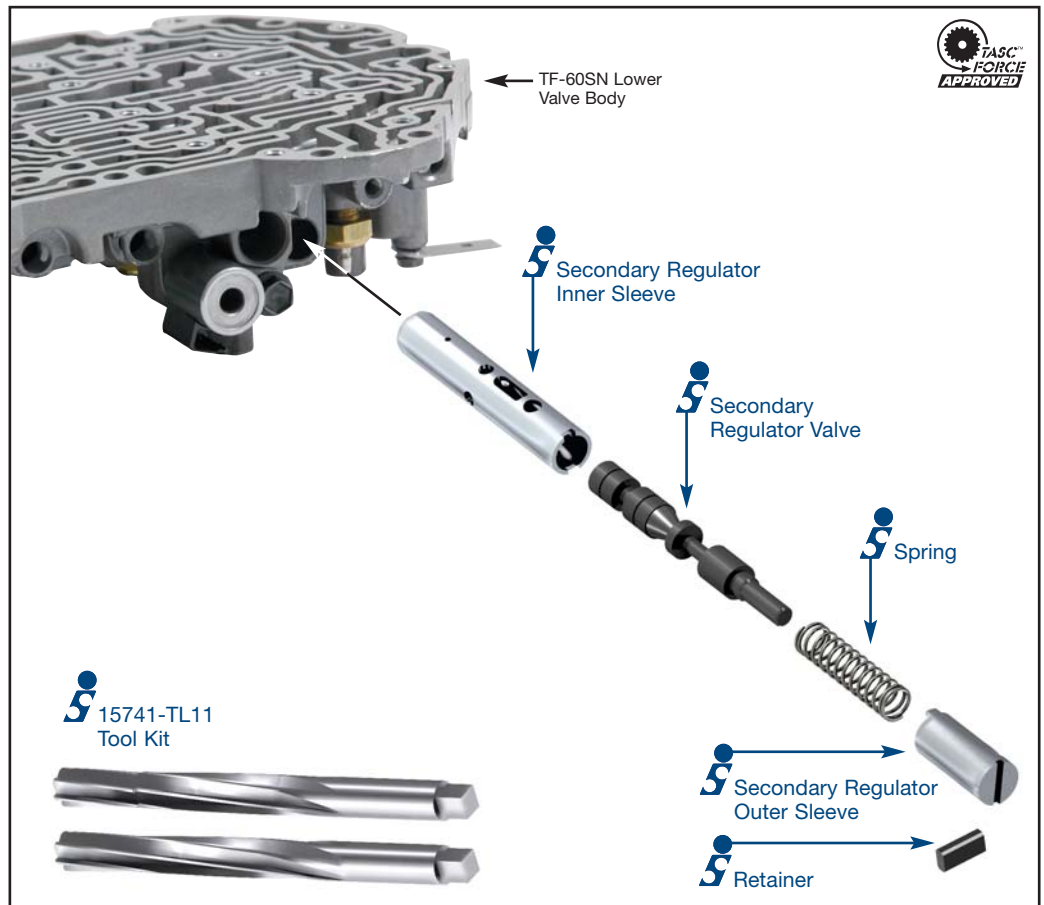
15741-11K

- 1 Inner Sleeve
- 1 Outer Sleeve
- 1 Secondary Regulator Valve
- 1 Spring
- 1 Retainer

15741-TL11

- 2 Reamers

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



Prep & Set-Up

1. Remove all components from the bore.
2. Clean the bore thoroughly in a solvent tank.

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

1. Clamp valve body section to bench or stationary surface. For best results, flow coolant into port passages during reaming process to keep reamer lubricated and chips evacuating.
2. Using Reamer #1 (15741-RM11) with appropriate socket, wobble adapter and either a regulated air drill or speed handle, ream the bore until the reamer bottoms in the bore.
3. Carefully remove reamer from bore and clean bore of chips.
4. Repeat steps 1-2 using Reamer #2 (15741-RM12).

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. The leading cutting edge will hold material if inward force and turning speed are incorrect. If a burr occurs, remove it by drawing a tool along the edge of the flute from the rear of the tool toward the tip.
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. Be certain all debris has been removed from the valve bores and valve body.
2. Insert valve into longer inboard sleeve, in the orientation pictured.
3. Install this sleeve and valve assembly into bore, with the undercut OD end entering bore first, as pictured.
4. Using a flathead screwdriver in the outer slots, radially position the sleeve so that the large cross slot is visible when looking into the line port in the casting.
5. Install the replacement spring over the valve stem.
6. Radially orient the outboard sleeve so that the tangs will fit into the outer slots of the inboard sleeve when installed, and that the retainer groove will be aligned with the retainer port in the casting.
7. Insert the replacement retainer into the retainer port, and secure with the OEM solenoid plate.