

Solenoid Modulator Valve Kit

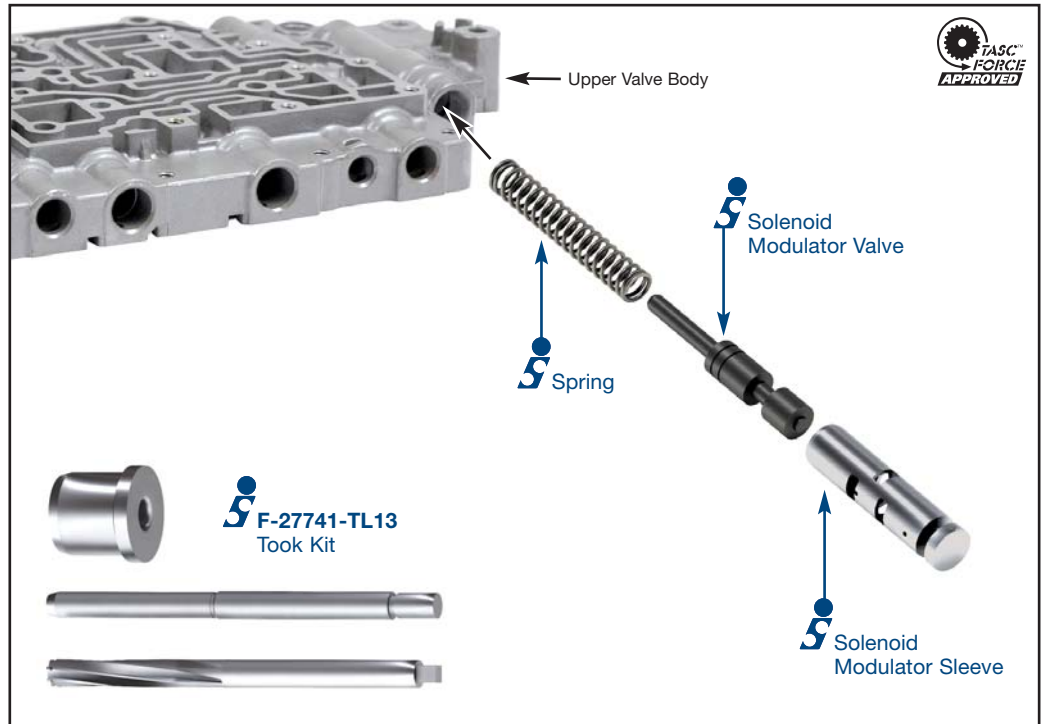
27741-13K

- 1 Solenoid Modulator Valve
- 1 Solenoid Modulator Sleeve
- 1 Spring



F-27741-TL13

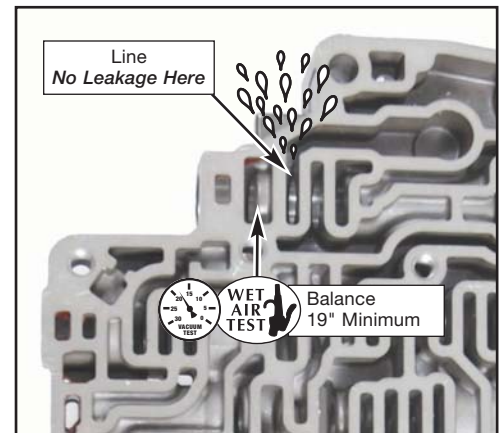
- 1 Reamer
- 1 Reamer Jig
- 1 Guide Pin



Wear Identification

Visible wear is often seen as a shiny patch on the inside diameter of the valve bore.

- **Wet Air Test:** Place a small amount of ATF into the balance line circuit. Follow with low air pressure while holding the valve outboard. There should be little or no leakage of air or oil past the valve spool and out the neighboring line port.
- **Vacuum test:** Vacuum testing of the balance line port should maintain a minimum of 19".



Disassembly Steps

1. Remove and discard the OEM end-plug, valve and spring.
2. Keep the OEM retainer for use with the replacement kit.

Reaming Instructions

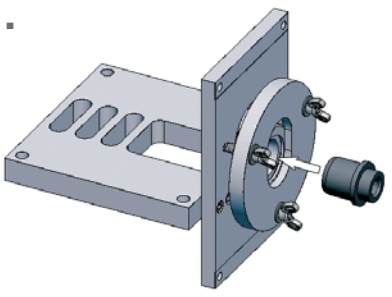
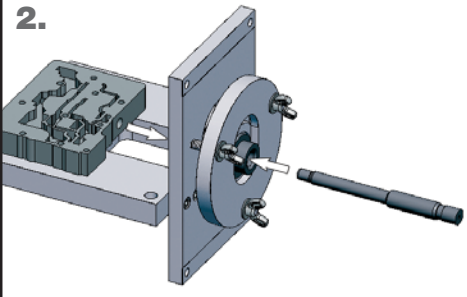
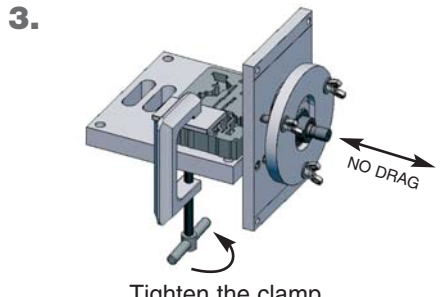
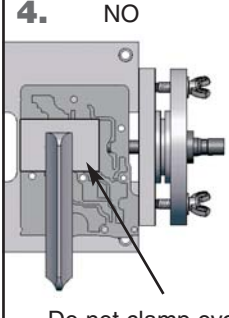
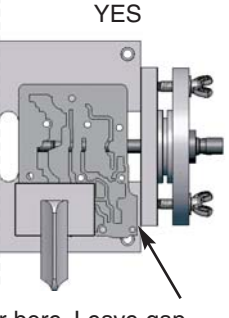
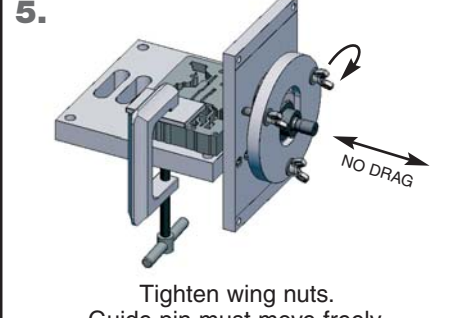
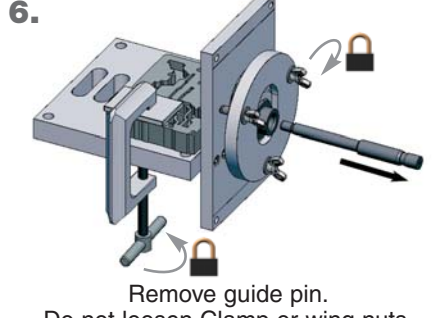
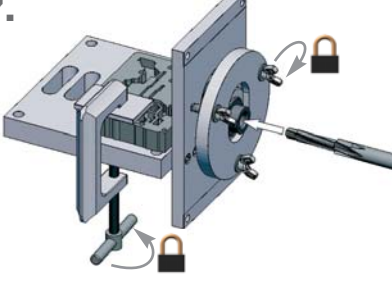
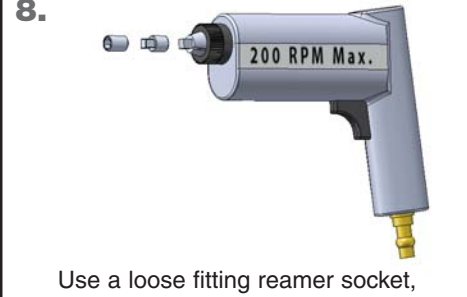
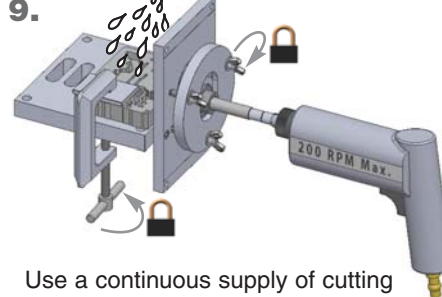
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U151E/F, U250E

PART NUMBERS 27741-13K, F-27741-TL13

Solenoid Modulator Valve 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.</p>
<p>4.</p> <div style="display: flex; justify-content: space-around;"><div><p>NO</p></div><div><p>YES</p></div></div> <p>Do not clamp over bore. Leave gap.</p>	<p>5.</p>  <p>Tighten wing nuts. Guide pin must move freely.</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.</p>	<p>9.</p>  <p>Use a continuous supply of cutting fluid and little or no inward force.</p>

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. Ream the bore per tool kit instructions.
2. Place the replacement spring over the long stem on the replacement valve.
3. Push the spring/valve/sleeve assembly into the bore, spring end first. To minimize effect of line port side-loading, install the sleeve as shown in the photo (*see page 1*) so that the balance orifice and line port opening can be seen when looking into the casting ports.
4. Install the OEM retainer into the sleeve groove.