

## Secondary Regulator Valve Kit

### 39741-11K

1 Secondary Regulator Valve  
1 Secondary Regulator Sleeve  
1 Spring  
1 Plug  
Use with TF-81SC Only

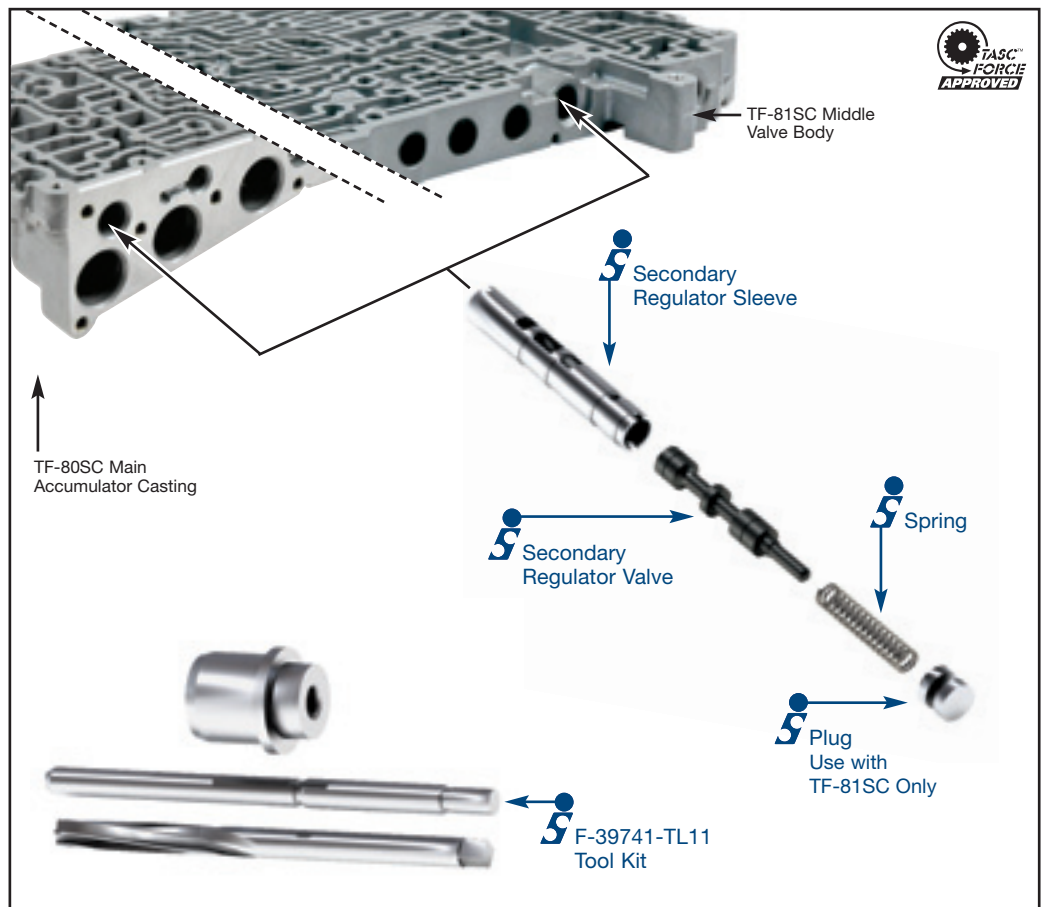


### F-39741-TL11

1 Reamer  
1 Guide Pin  
1 Reamer Jig



**Note:** Fits Volvo (AM6); Opel (AF40); Peugeot (TF80); Saab (AF40/6); Land Rover (TF80); Ford (AF21) & Mazda (AW6A-EL).



### Prep & Set-Up

1. Remove all components from the bore.
2. Clean the bore thoroughly in a solvent tank.
3. Align the valve body on the fixture according to VB-FIX instructions:

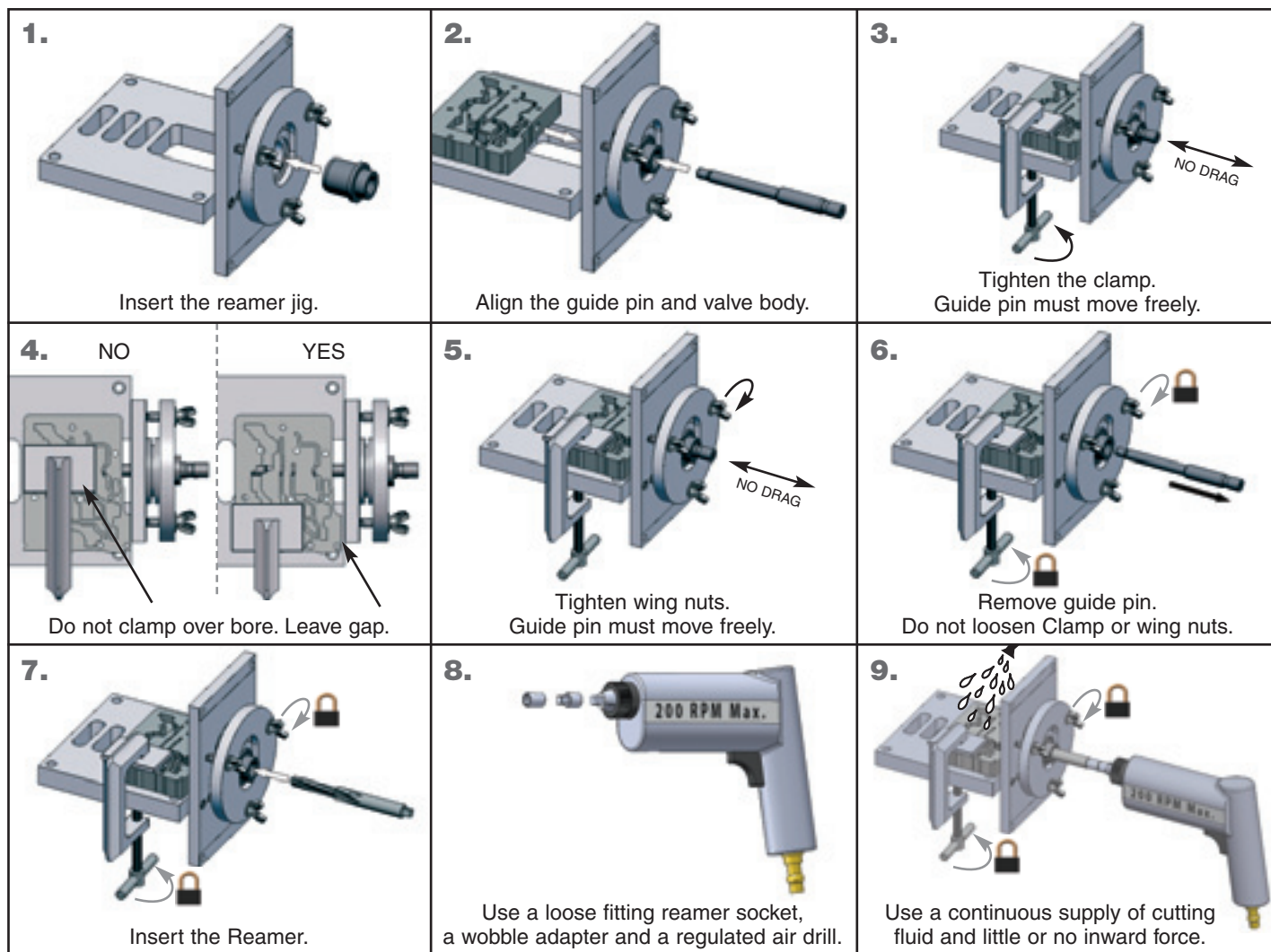
### Important Notes:

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

...start on page two.

## 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. 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 sharpening 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. Install the new Sonnax Secondary Regulator Valve & Sleeve assembly, Spring and End Plug if applicable.