Instruction Data Sheet

Aisin AW TR-60SN

PART NUMBERS **25741-05K, F-25741-TL5**

K2 Clutch/B1 Brake Control Valve Kit

25741-05K

- K2 Clutch/B1 Brake Control Sleeve
- K2 Clutch/B1 Brake Control Valve
- Spring

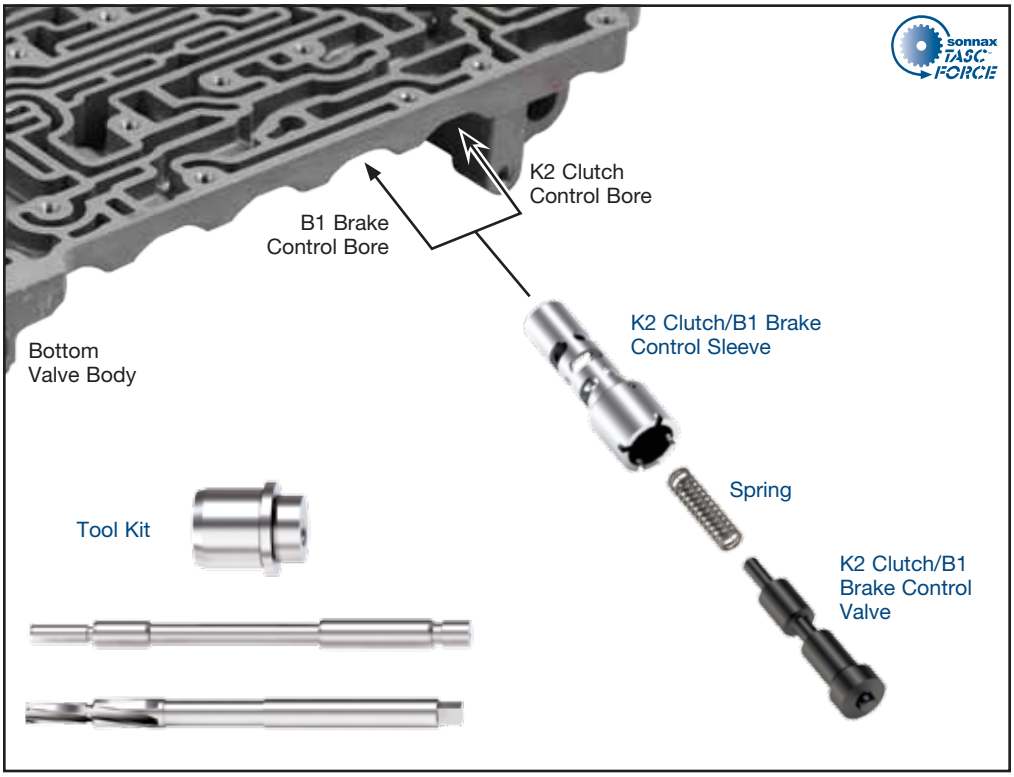
NOTE: Also fits VW/Audi 09D.

Tool Kit

F-25741-TL5

- 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

NOTE: The spring adjuster position must be recorded, and the adjuster returned to its OE position during reassembly.

a. Measure and record the distance from the end of the adjuster to the valve body casting (**Figure 1**).

b. Remove and save the solenoid retaining pin and solenoid, adjuster retainer and adjuster.

c. Remove and discard OE valve and spring.

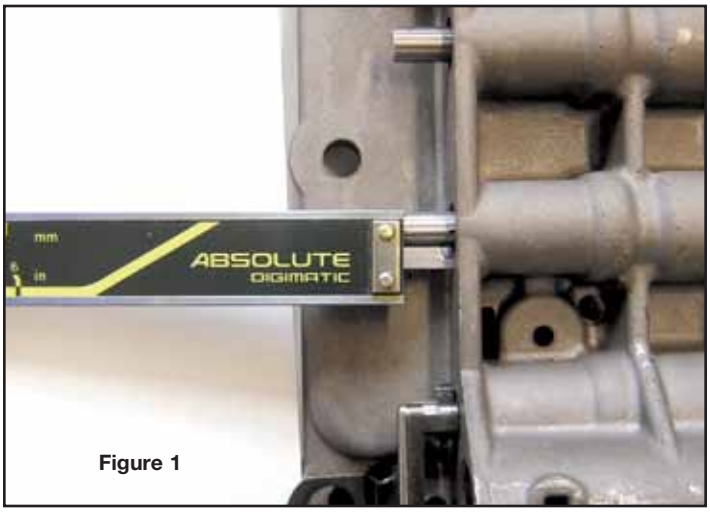


Figure 1

2. Bore Preparation

a. Clean the bore thoroughly in a solvent tank.

b. 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.

c. The reamers should be turned using a low RPM, high-torque air drill regulated to a maximum of 200 RPM.

d. 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 resharpening or replacing averages 50-70 bores.

25741-05K Rev:- F-25741-TL5 Rev:-, 25741-05K-IN 11-17-10

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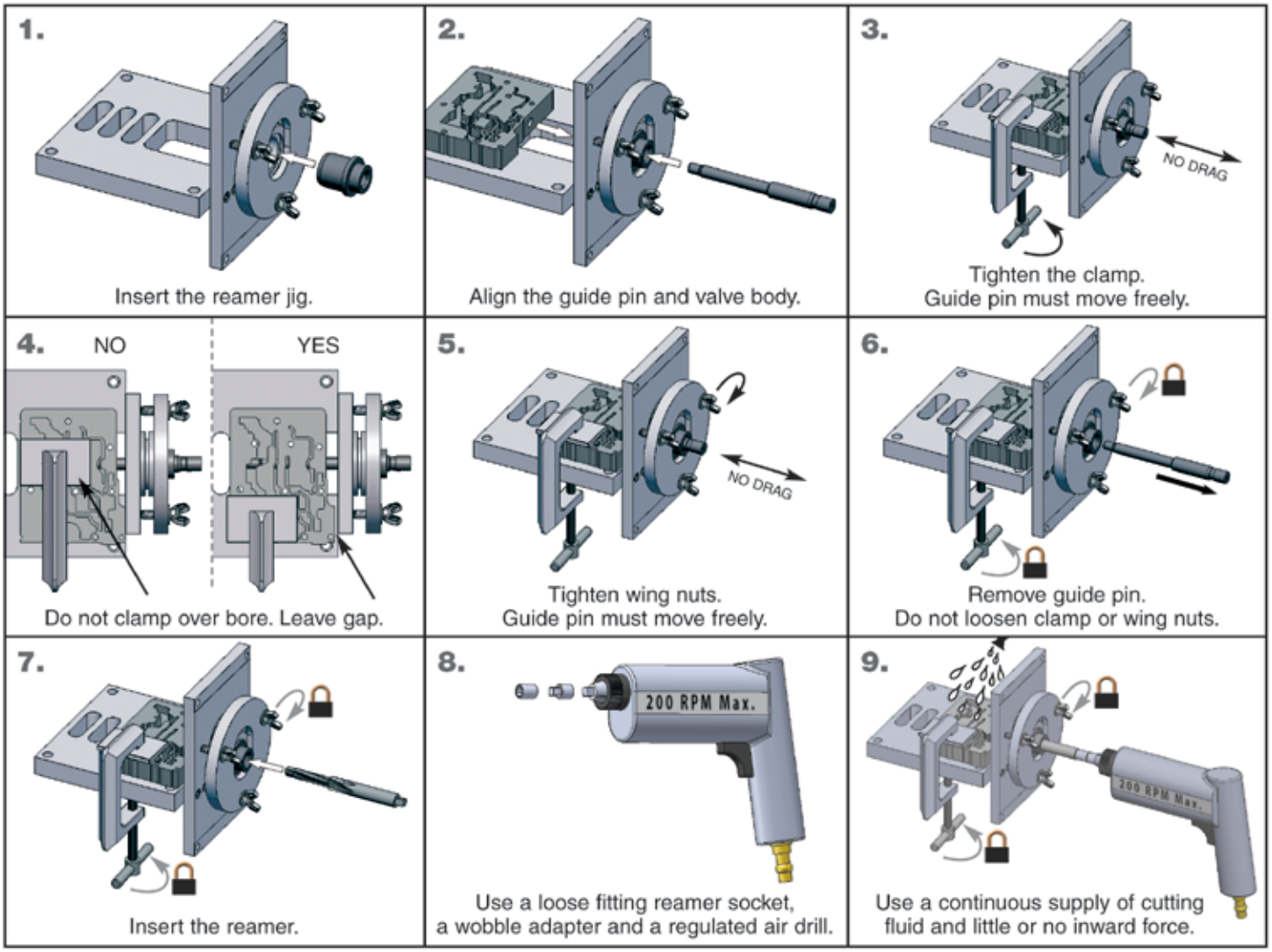
3. Bore Reaming

Use the associated "F-Tool" kit **F-25741-TL5** and **VB-FIX** reaming fixture as illustrated below to ream the bore.



4. Installation & Assembly

a. Be certain all debris has been removed from the valve bores and valve body.

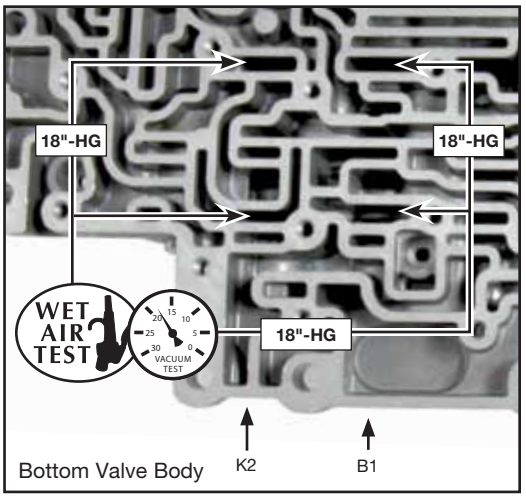
b. Install adjuster to position previously recorded during disassembly procedure, followed by the retainer.

NOTE: Component apply pressure leakage past the adjuster threads can be reduced by using an ATF compatible thread sealant, such as Permatex® 24163 Surface Prep and 24206 Thread Locker, on the spring adjuster. Compound must not create a permanent set.

c. Install Sonnax spring between Sonnax valve and sleeve.

d. Install Sonnax sleeve/spring/valve assembly. A deep well socket can be used for pressing the assembly into place.

e. Reinstall the OE solenoid and solenoid retaining pin.



5. Final Testing

A vacuum test at indicated ports should yield 18 in-hg or greater of vacuum.

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