

## Oversized Secondary Pulley Control Valve Kit

### 113741-19K

1 O/S Secondary  
Pulley Control Valve  
1 End Plug

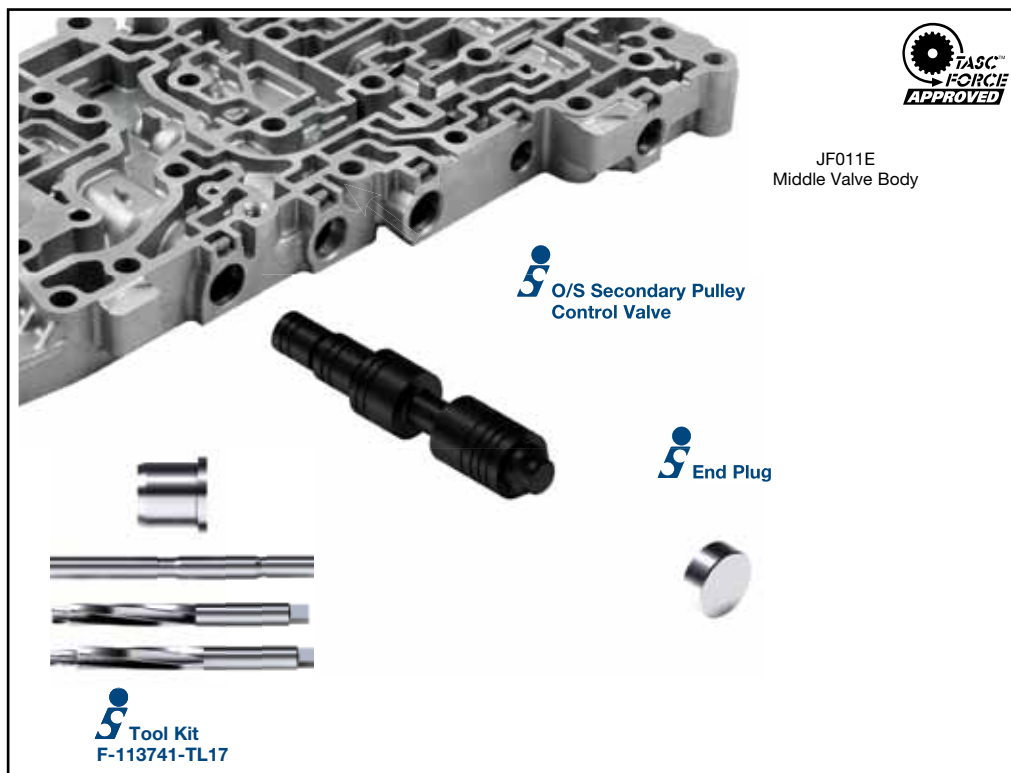
**NOTE:** Fits JF011E only

### F-113741-TL17

2 Reamers  
1 Reamer Jig  
1 Guide Pin

Tool Kit for 113741-19K can also be used  
for 113741-17K

**NOTE:** Sonnax "F" tool kits designed to  
service a specific bore require the Sonnax  
VB-FIX, a self-aligning valve body ream-  
ing fixture. More information and instruc-  
tions are available at [www.sonnax.com](http://www.sonnax.com).



### Disassembly

1. Remove and discard the OEM valve and end plug.
2. Keep the OEM retainer and the OEM spring for reuse.

### Important Notes

**Tool Kit F-113741-TL17 contains two reamers**

**For JF011E valve bodies, use reamer F-113741-RM19 only**

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. Mobilment 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 land 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.

### Cautions and Suggestions

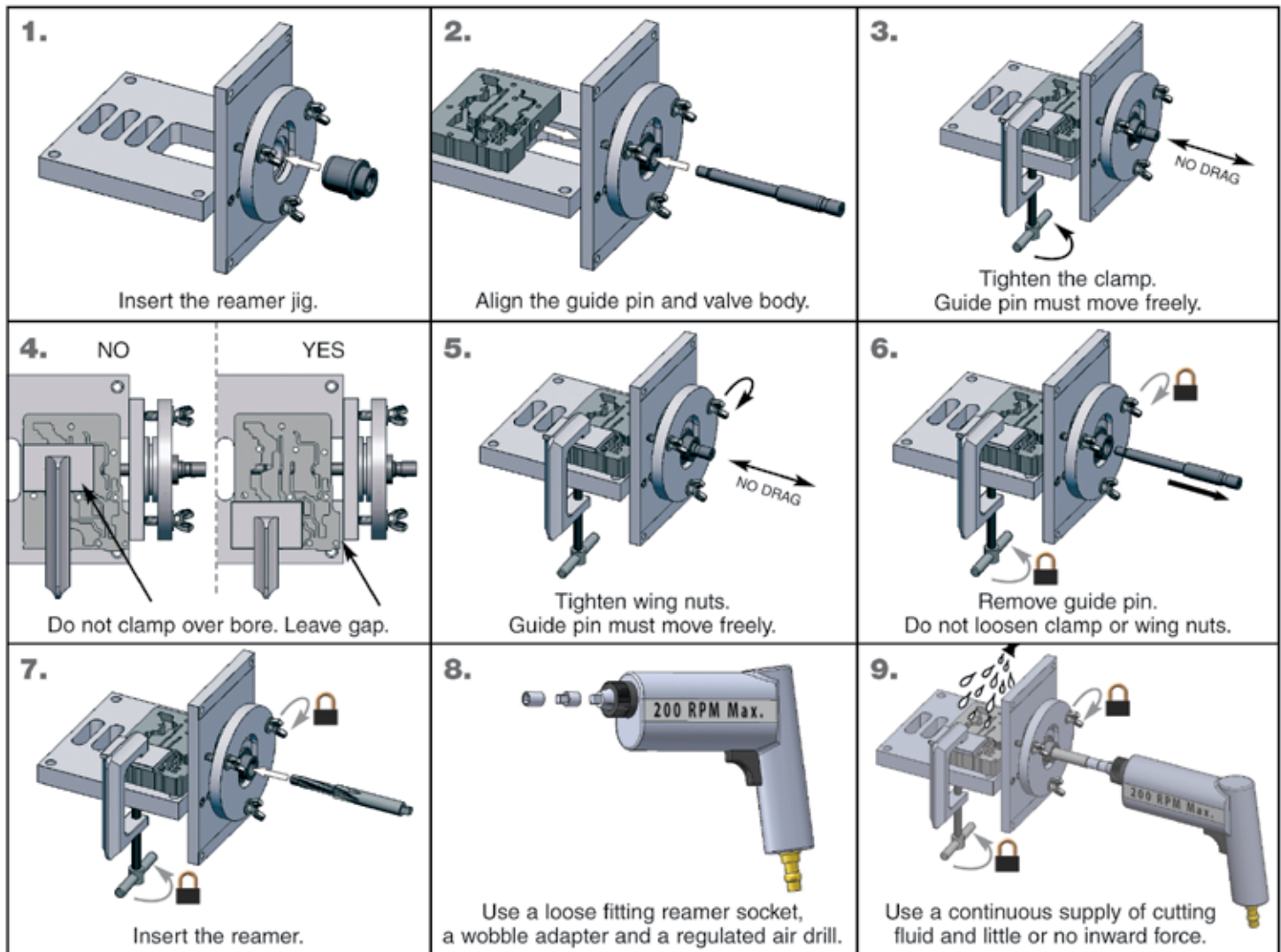
1. Turning the reamer backward will dull it prematurely.
2. Pushing on the reamer will result in poor surface finish and inadequate and sporadic material removal.
3. Never use a crescent wrench, ratchet or pliers to turn the reamer.
4. A dull reamer will cut a smaller hole. Reamers can be sharpened, but should only be done by a professional tool sharpener. Actual life of a reamer before resharpening or replacing averages 50-70 bores.

# JATCO/NISSAN CVT

PART NUMBERS 113741-19K, F-113741-TL17

**Oversized Secondary Pulley  
Control Valve Kit**

## Reaming Instructions:



## Installation

1. Remove all debris from the valve bores and body.
2. Install the Sonnax secondary pulley control valve.
3. Reinstall the OEM spring.
4. Install the Sonnax end plug.
5. Reinstall the OEM retaining clip.

## Final Verification Steps

Vacuum testing at the test port indicated should hold 16" or more.

