

K1 Clutch Control Valve Kit

25741-25K

- K1 Clutch Control Sleeve
- K1 Clutch Control Valve
- Spring

NOTE: Also fits VW/Audi 09D.



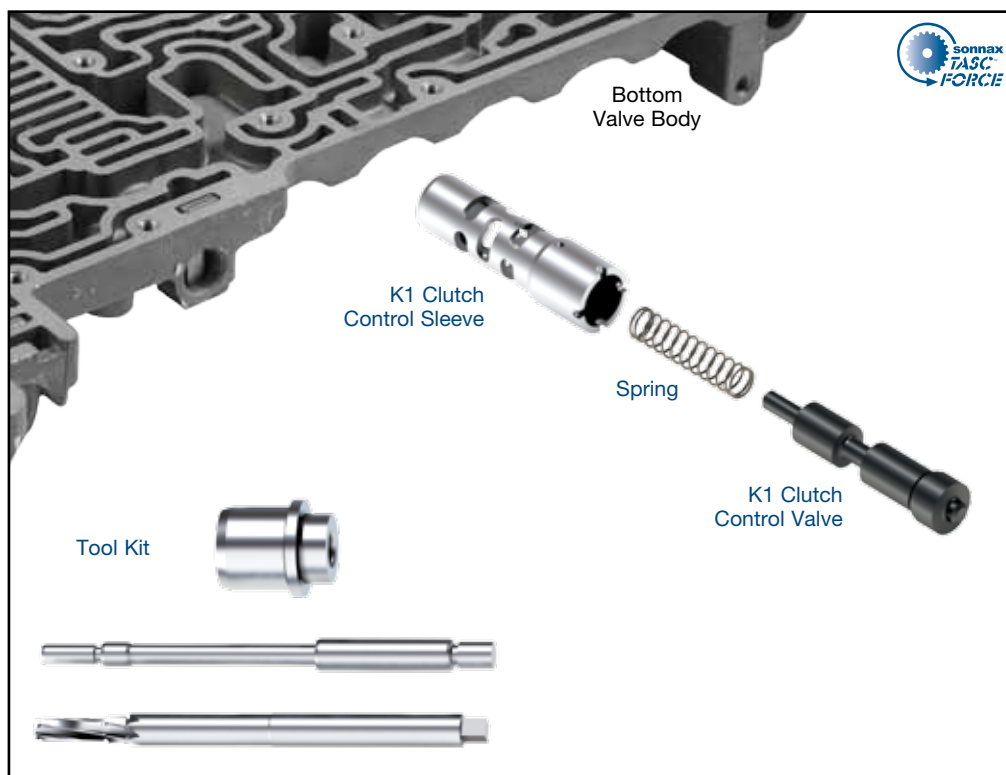
Tool Kit

F-25741-TL25

- 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.

- Measure and record the distance from the end of the adjuster to the valve body casting (**Figure 1**).
- Remove the solenoid retaining pin and solenoid, adjuster retainer and adjuster, and save all for reassembly.
- Remove and discard OE valve and spring.

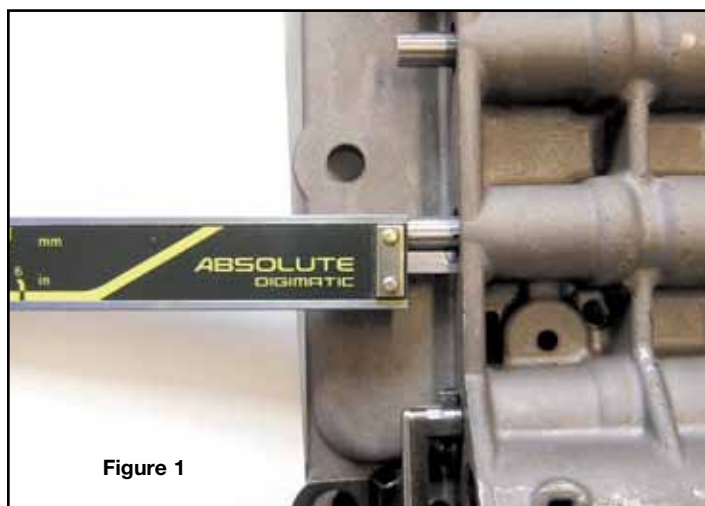


Figure 1

2. Bore Preparation

- Clean the bore thoroughly in a solvent tank.
- 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.
- The reamers should be turned using a low RPM, high-torque air drill regulated to a maximum of 200 RPM.
- 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.

AISIN AW TR-60SN

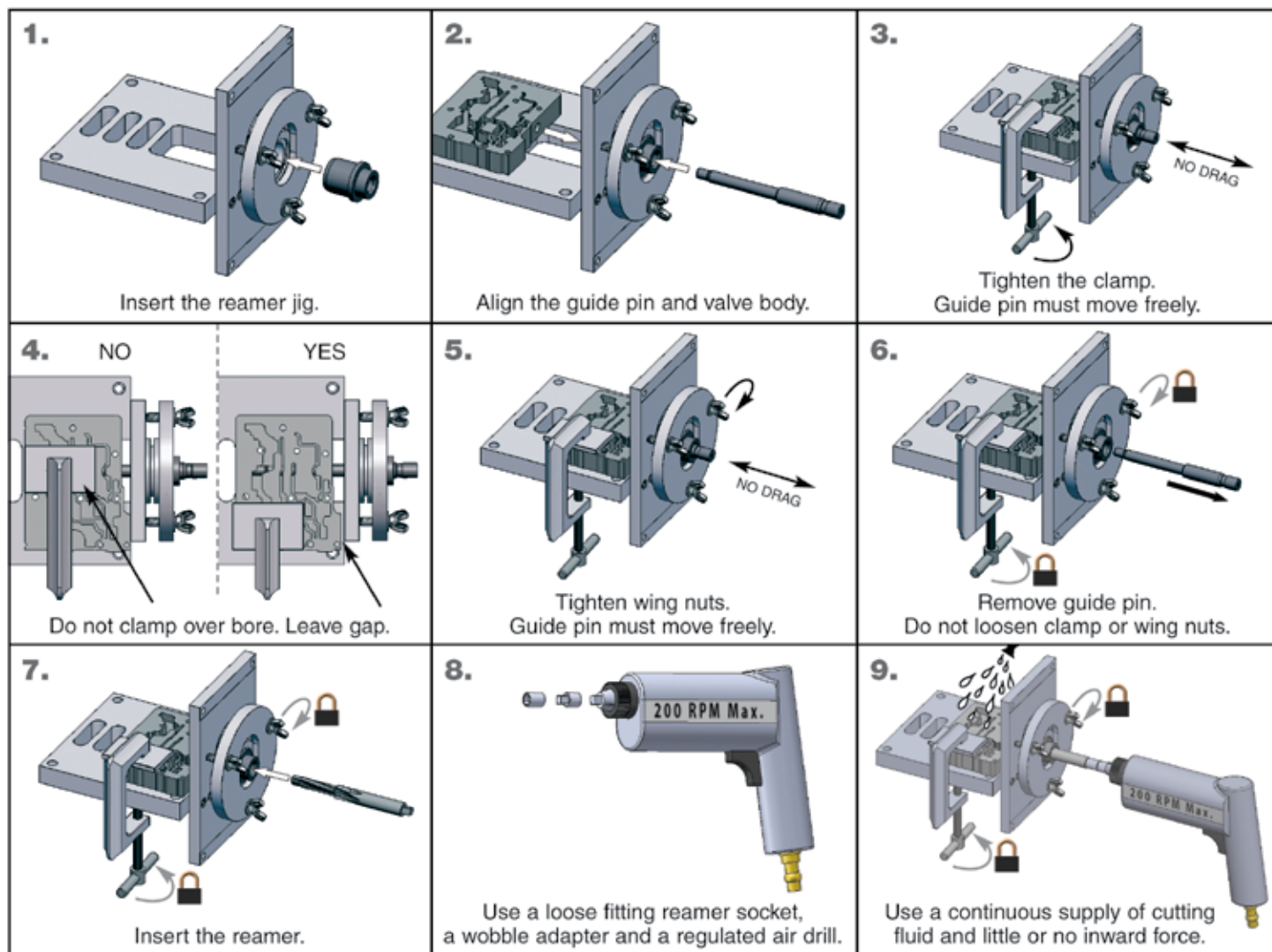
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Valve Kit**

PART NUMBERS 25741-25K, F-25741-TL25

INSTRUCTION DATA SHEET

3. Bore Reaming

Use the associated "F-Tool" kit F-25741-TL25 and VB-FIX reaming fixture as illustrated below to ream the bore.



4. Installation & Assembly

- Be certain all debris has been removed from the valve bores and valve body.
- Install adjuster to position previously recorded during disassembly procedure, followed by the retainer.
- Install Sonnax spring into the adjuster pocket.
- Install Sonnax sleeve and valve, ensuring the spring I.D. goes over the valve nub.
- Reinstall the solenoid and solenoid retaining pin.

5. Final Testing

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

