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TRANSMISSION PARTS

Instructions

Toyota A340E/F, Late

Oversized Secondary Pressure Regulator Valve Kit

TOOL REQUIRED

Part No.
97741-18K

- Valve
- End Plug
- O-Rings (2) 1 extra

NOTE: Fits '00-later V6 & V8, late models, Type 3 & 4 valve bodies.

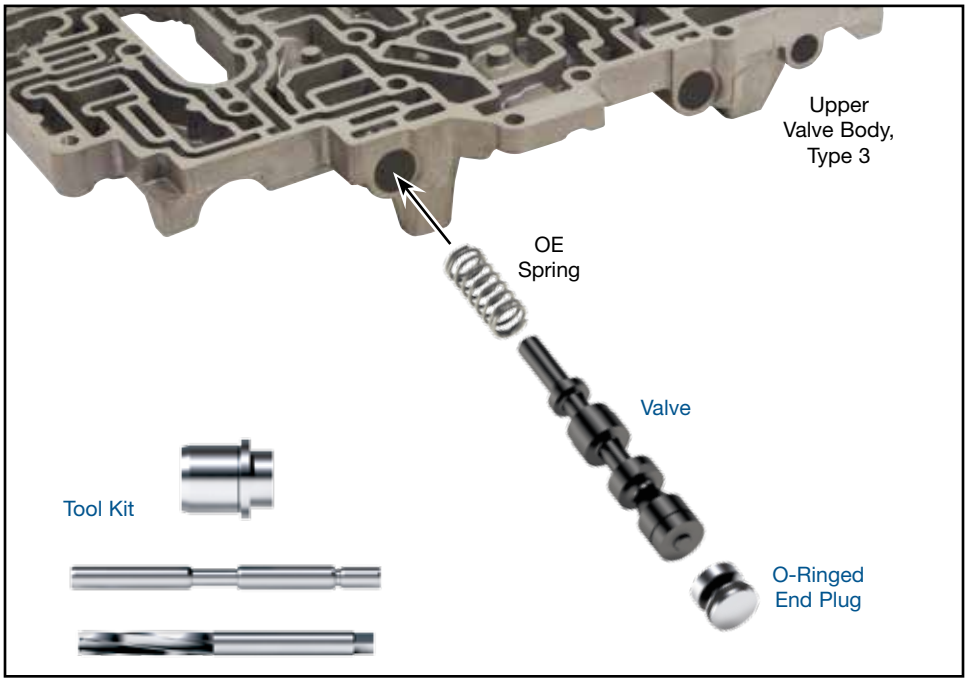
Tool Kit

VALVE BODY FIXTURE REQUIRED

Part No.
F-97741-TL18

- 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 can be found online at www.sonnax.com.



1. Disassembly

a. Remove and discard the OE secondary pressure regulator valve and end plug.

b. Save the OE spring and retainer for reuse.

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. Mobilmet 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 in 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 debris must be cleaned to ensure 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.

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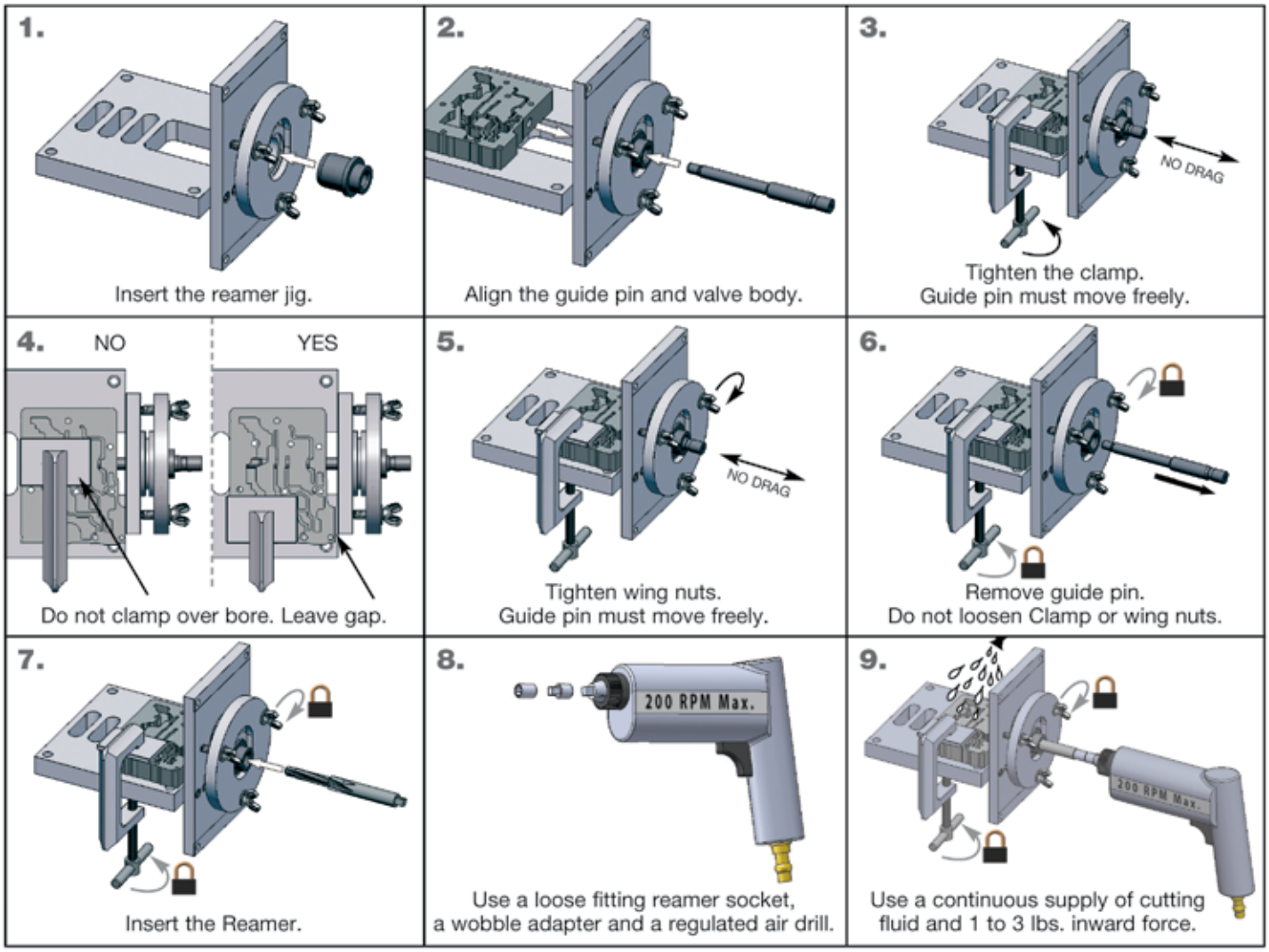
3. Bore Reaming

Use the associated "F-Tool" **F-97741-TL18** kit and **VB-FIX** reaming fixture as illustrated below to ream the bore.



4. Installation & Assembly

a. Place the OE spring onto the replacement valve. Install OE spring and Sonnax valve into the reamed and cleaned bore, spring end first as shown in main photo.

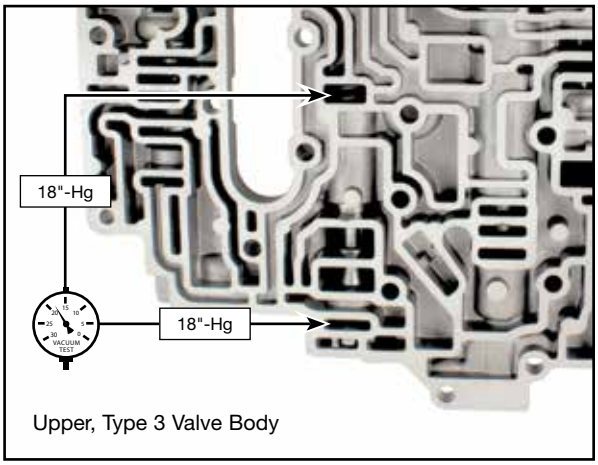
b. Place the Sonnax O-ring into the shallow groove on Sonnax end plug. Lubricate with **O-LUBE** or equivalent and roll the O-ringed end plug on the bench to size.

c. Carefully install the Sonnax O-ringed end plug into the bore with O-ringed land outboard.

d. Retain with OE retainer.

5. Final Testing

Vacuum tests at the ports indicated hold the recommended minimum amount of 18 in-Hg.



Upper, Type 3 Valve Body

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