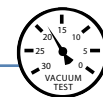




Critical Wear Areas & Vacuum Test Locations



NOTE: OE valves are shown in rest position and should be tested in rest position unless otherwise indicated. Test locations are pointed to with an arrow. Springs are not shown for visual clarity. Low vacuum reading indicates wear.

Lower Valve Body – Bottom Side • U250E Shown Here

Click on Sonnax part numbers to see more information.

4-5 Shift Valve

- Delayed 3rd
- UD/C3 Clutch burned
- Delayed or no 5th gear

B2 (Low/Reverse) Switch Valve

- B2 Brake clutches burned
- Delayed Reverse
- No engine braking in manual low

B2 (Low/Reverse) Apply Control Plunger

- Delayed Reverse
- B2 Brake clutches burned
- No engine braking in manual low
- Erratic shift timing

Replace with Sonnax Part No. 27741-06K

B1 (2nd) Apply Control Plunger

- 2-3 or 4-3 Bind-up
- B1 brake clutches burned
- Harsh 1 through 4 maneuver shifts
- Erratic shift timing

Replace with Sonnax Part No. 27741-04K
NOTE: Seal port on opposite side when testing.

Boost Valve

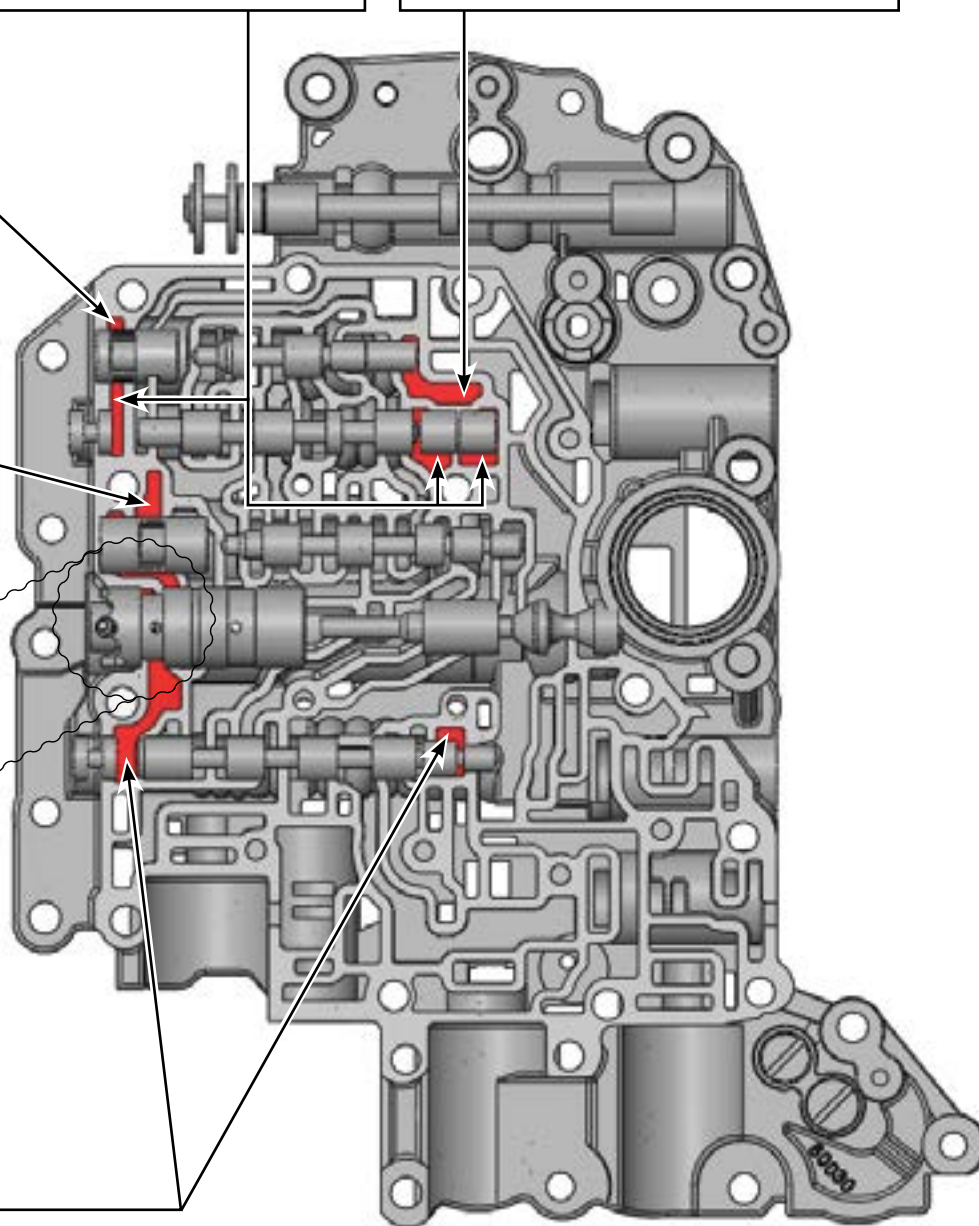
- Soft shifts
- Low line rise in Drive
- High line pressure in Reverse

Replace with Sonnax Part No. 27741-01K

Clutch Apply Control Valve

- Burnt Forward/C1 Clutch, Direct/C0 Clutch and 2nd/B1 Brake
- Flare shifts • Bind-ups

Replace with Sonnax Part No. 27741-18K Requires F-27741-TL18 & VB-FIX
NOTE: Stroke valve to ensure it is not stuck.





Critical Wear Areas & Vacuum Test Locations



NOTE: OE valves are shown in rest position and should be tested in rest position unless otherwise indicated. Test locations are pointed to with an arrow. Springs are not shown for visual clarity. Low vacuum reading indicates wear and Sonnax parts noted for replacement.

Lower Valve Body – Bottom Side • U250E Shown Here

Click on Sonnax part numbers to see more information.

End Plugs, Multiple Locations

- Inconsistent shift quality • Flare shifts
- Clutch failure • Bump shifts • Bang shifts
- Shift codes

Replace with **Sonnax Part No. 27741-20K**

NOTE: Two Locations = ★

Pressure Regulator Valve

- Soft shifts • Low line pressure • Harsh shifts
- High line pressure in Reverse
- Clutch & band failures
- Low converter pressure • High line pressure

Replace with **Sonnax Part No. 27741-08K** Requires 57917E-TL8

Clutch Apply Control Valve

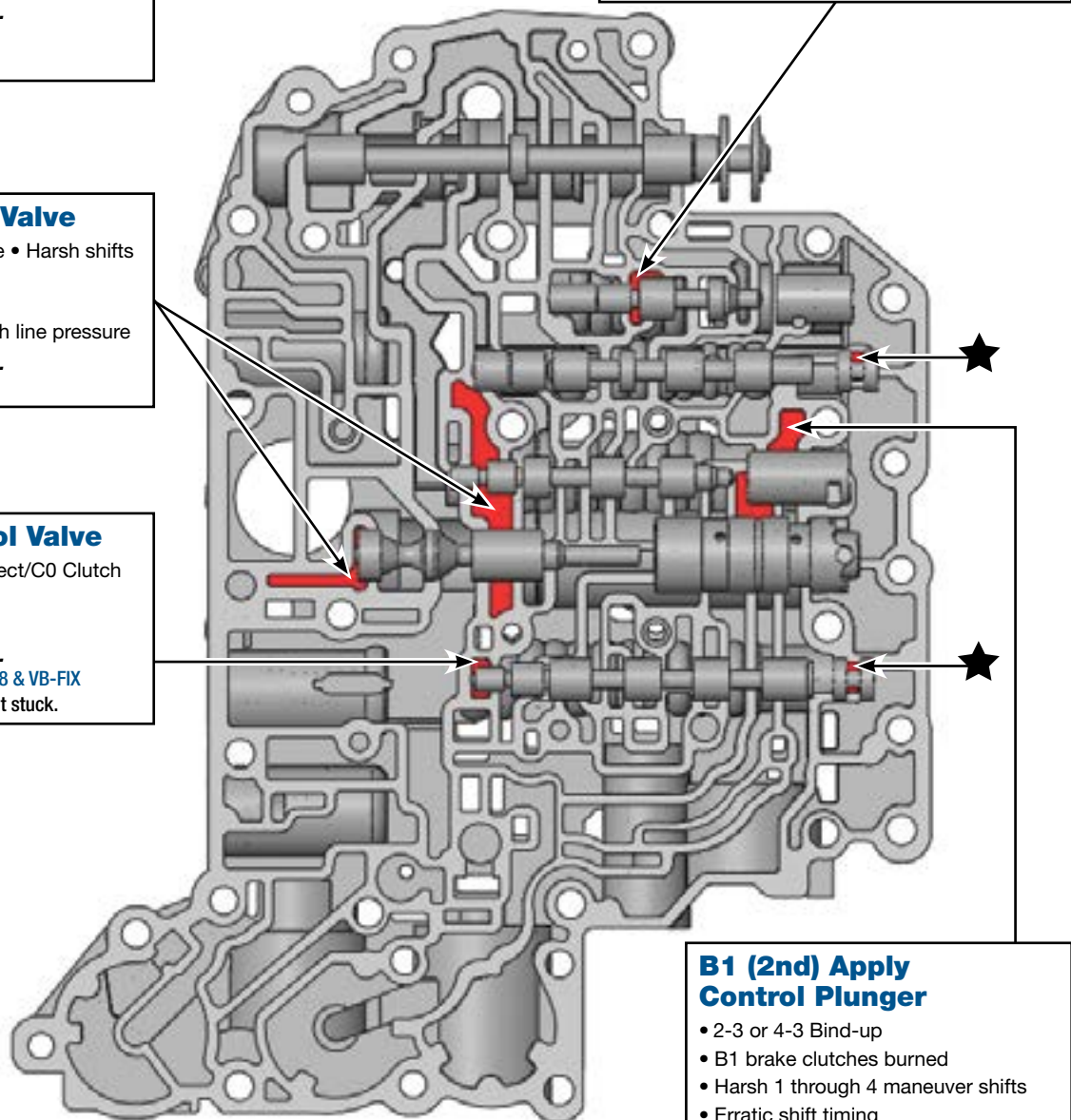
- Burnt Forward/C1 Clutch, Direct/C0 Clutch & 2nd/B1 Brake
- Flare shifts • Bind-ups

Replace with **Sonnax Part No. 27741-18K** Requires F-27741-TL18 & VB-FIX

NOTE: Stroke valve to ensure it is not stuck.

B2 (Low/Reverse) Switch Valve

- B2 Brake clutches burned
- Delayed Reverse
- No engine braking in manual low



B1 (2nd) Apply Control Plunger

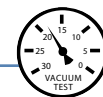
- 2-3 or 4-3 Bind-up
- B1 brake clutches burned
- Harsh 1 through 4 maneuver shifts
- Erratic shift timing

Replace with **Sonnax Part No. 27741-04K**

NOTE: Seal this port and test on opposite side.



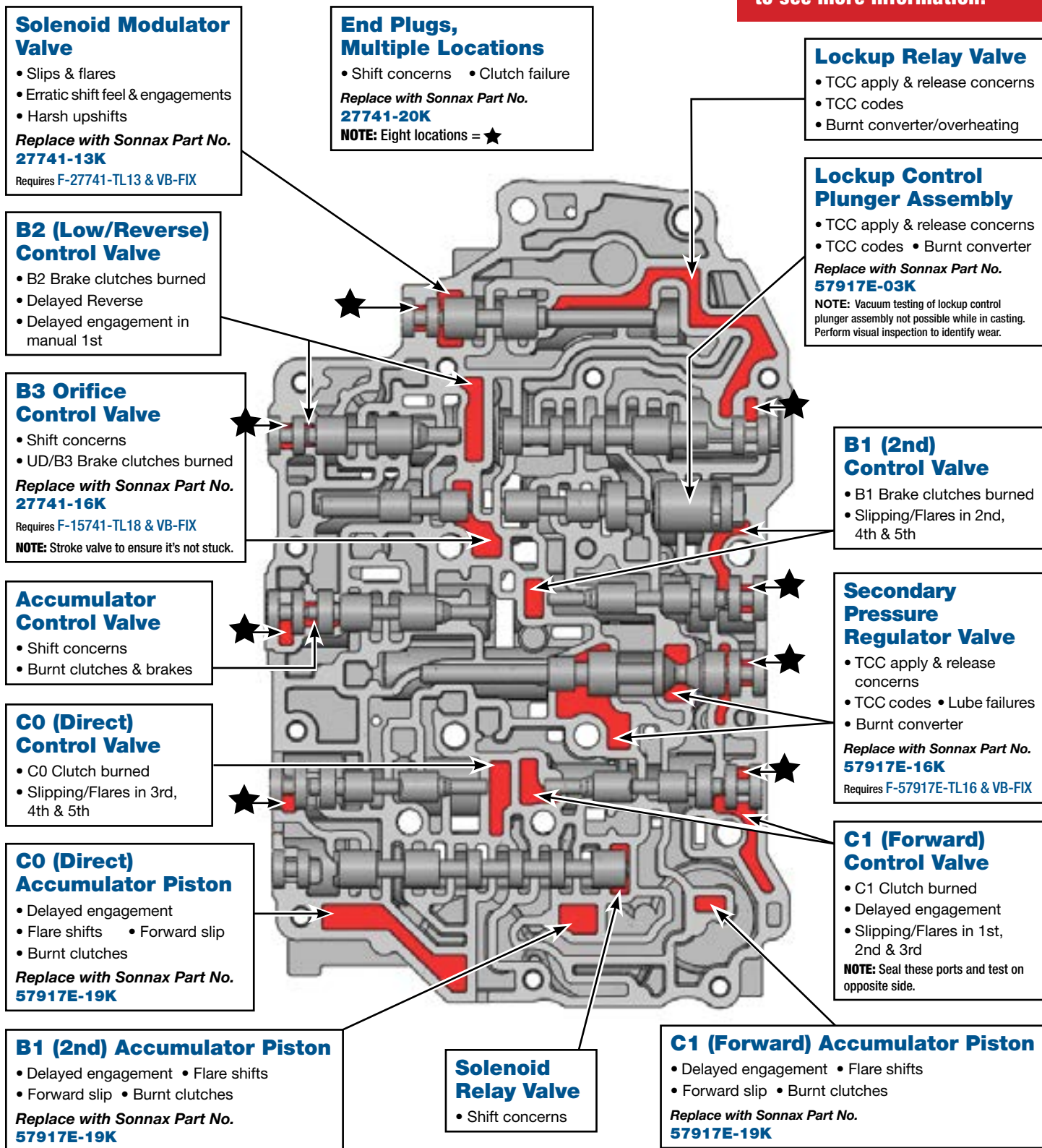
Critical Wear Areas & Vacuum Test Locations



NOTE: OE valves are shown in rest position and should be tested in rest position unless otherwise indicated. Test locations are pointed to with an arrow. Springs are not shown for visual clarity. Low vacuum reading indicates wear.

Upper Valve Body – Bottom Side • U250E Shown Here

Click on Sonnax part numbers to see more information.



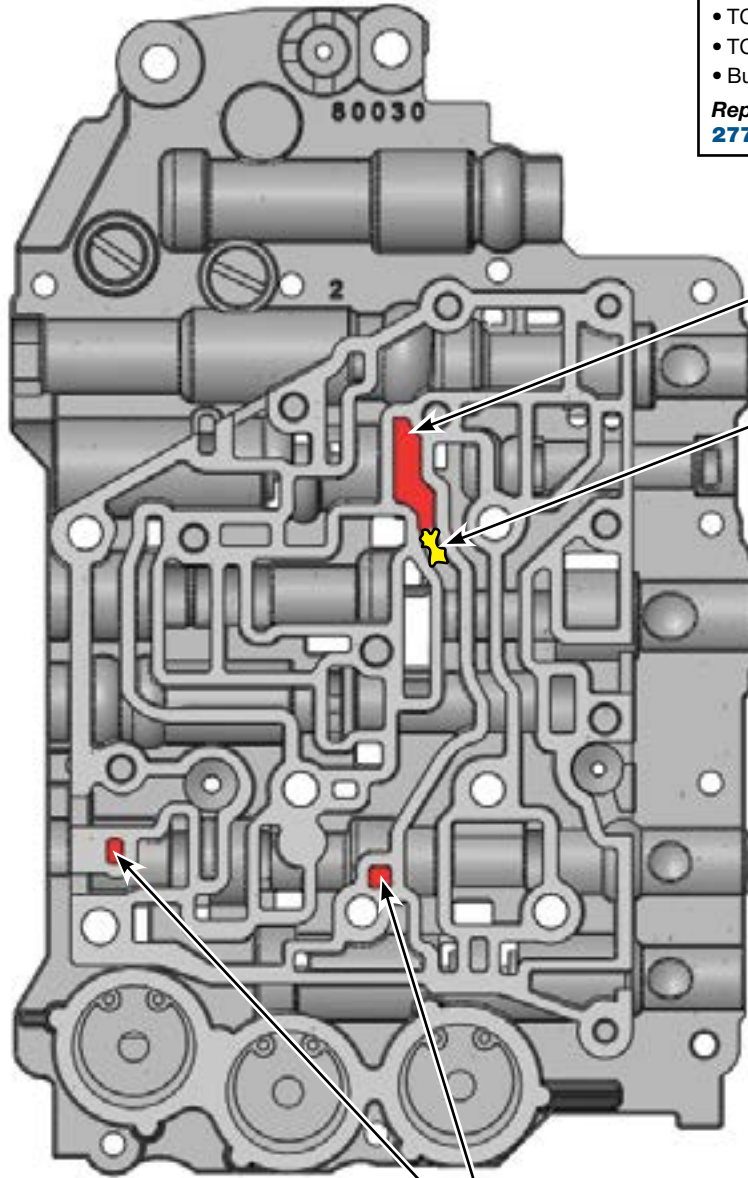


Critical Wear Areas & Vacuum Test Locations



NOTE: OE valves are shown in rest position and should be tested in rest position unless otherwise indicated. Test locations are pointed to with an arrow. Springs are not shown for visual clarity. Low vacuum reading indicates wear.

Upper Valve Body – Top Side • U250E Shown Here



Lockup Control Valve

- TCC apply & release concerns
- TCC codes
- Burnt converter

Replace with **Sonnax Part No. 27741-25K** REQUIRES F-27741-TL25 & VB-FIX

NOTE: Place clay here to isolate circuit.

C1 (Forward) Control Valve

- C1 Clutch burned
 - Delayed engagement
 - Slipping/Flares in 1st, 2nd & 3rd
- NOTE:** Seal ports on opposite side when testing.

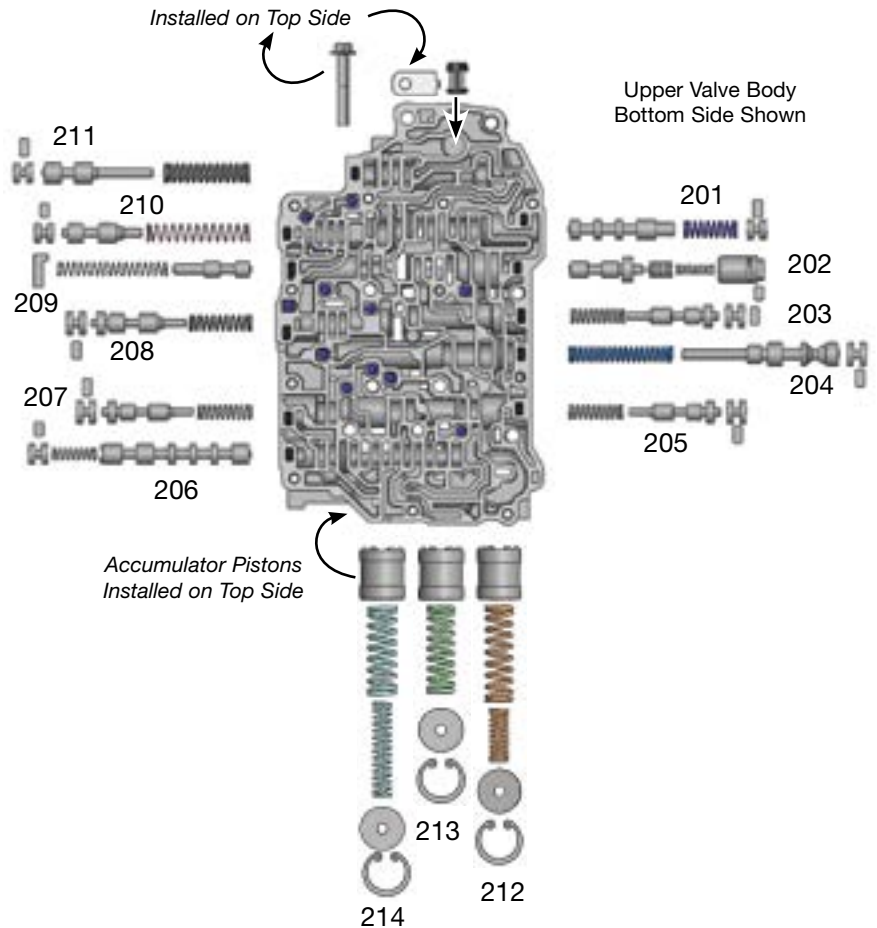


OE Exploded View

Upper & Lower Valve Body • U250E Shown Here

Upper Valve Body Descriptions

I.D. No.	Description
201	Lockup Relay Valve
202	Lockup Control Valve & Plunger Valve Assembly
203	B1 Control Valve
204	Secondary Regulator Valve
205	C1 Control Valve
206	Solenoid Relay Valve
207	C0 Control Valve
208	Accumulator Control Valve
209	B3 Orifice Control Valve
210	B2 Control Valve
211	Solenoid Modulator Valve
212	C0 Accumulator Piston
213	B1 Accumulator Piston
214	C1 Accumulator Piston



Lower Valve Body Descriptions

I.D. No.	Description
101	Manual Valve
102	B2 Switch Valve & Plunger Valve
103	4-5 Shift Valve
104	B1 Switch Valve & Plunger Valve Assembly
105	Main Pressure Regulator Valve & Boost Valve Assembly
106	Clutch Apply Control Valve

