

Toyota/Lexus A750E, A750F, A760E, A760F, A760H, A761E, A960E, A960F, AB60E, AB60F

Oversized Lockup Relay Valve Kit



Part No.

147741-07K

- Lockup Relay Valve
- Control Valve
- Spring
- End Plug

Tool Kit

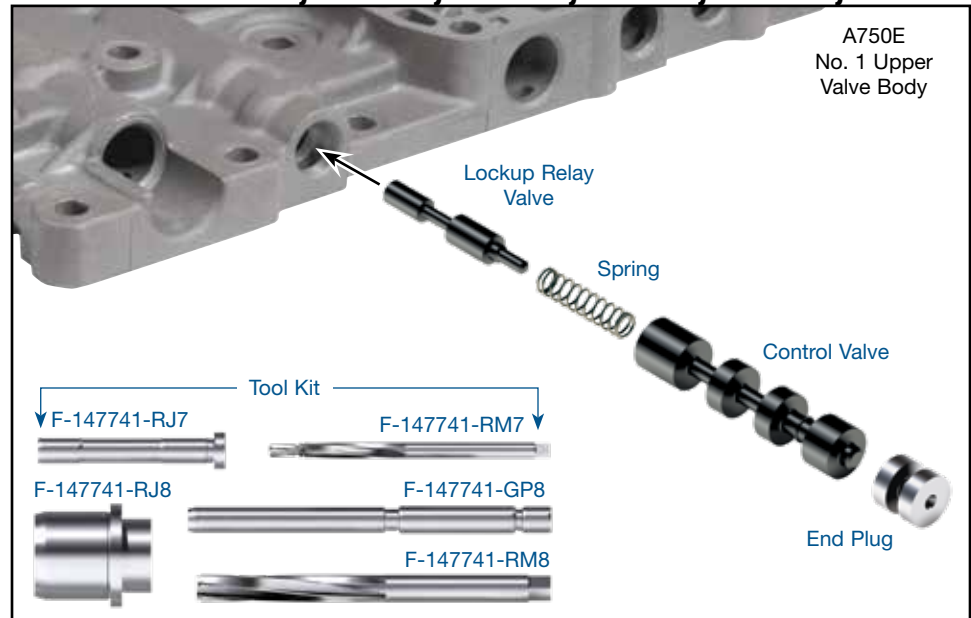


Part No.

F-147741-TL7

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|--------------|--------------|
| • Reamer | F-147741-RM7 |
| • Reamer Jig | F-147741-RJ7 |
| • Reamer | F-147741-RM8 |
| • Reamer Jig | F-147741-RJ8 |
| • Guide Pin | F-147741-GP8 |

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.



IMPORTANT CAUTION: Ream the small diameter inboard valve bore **BEFORE** reaming the larger diameter outboard bore. Failure to ream the smaller diameter inboard bore first will cause irreparable damage to valve body.

1. Disassembly

- Remove all OE components from bore.
- Keep OE retaining pin for reuse, discard all other OE parts.



WARNING: Reaming involves two separate operations that must be performed in order. Failure to follow correct order will result in irreparable damage to valve body.

2. First Reaming Procedure

- Securely clamp valve body to bench. Ensure clamp is not placed over bore to be reamed.
- Insert reamer jig **F-147741-RJ7** directly into bore.
- Insert reamer **F-147741-RM7** through reamer jig.
- Saturate bore and reamer with cutting fluid and begin reaming using a low-RPM, high-torque drill regulated to a maximum of 200 RPM. For best results, provide a continuous flow of water-soluble cutting fluid during reaming process.
- Continue reaming until reamer stop is reached.
- Remove reamer by turning clockwise while pulling outward.



WARNING: Turning the reamer backward will dull it prematurely.

- Clean bore thoroughly and remove all debris before beginning next reaming procedure.

3. Second Reaming Procedure

- Secure valve body on VB-FIX and align bore with reamer jig **F-147741-RJ8**.
- Ream bore with reamer **F-147741-RM8** (for in-depth VB-FIX reaming instructions, please visit www.sonnax.com).

4. Installation & Assembly

- Be certain all debris has been removed from valve bore and valve body.
- Install Sonnax lockup relay valve, spring, control valve and end plug as shown in main photo.
- Reinstall OE retaining pin.

5. Final Testing

Vacuum testing at the port(s) indicated holds the recommended minimum 14 in-Hg.

