

### Solenoid Modulator Valve Kit



**Part No.**

**25741-18K**

- Sleeve
- Valve
- Spring
- End Plug

**NOTE:** Fits either of 2 locations.

### Tool Kit



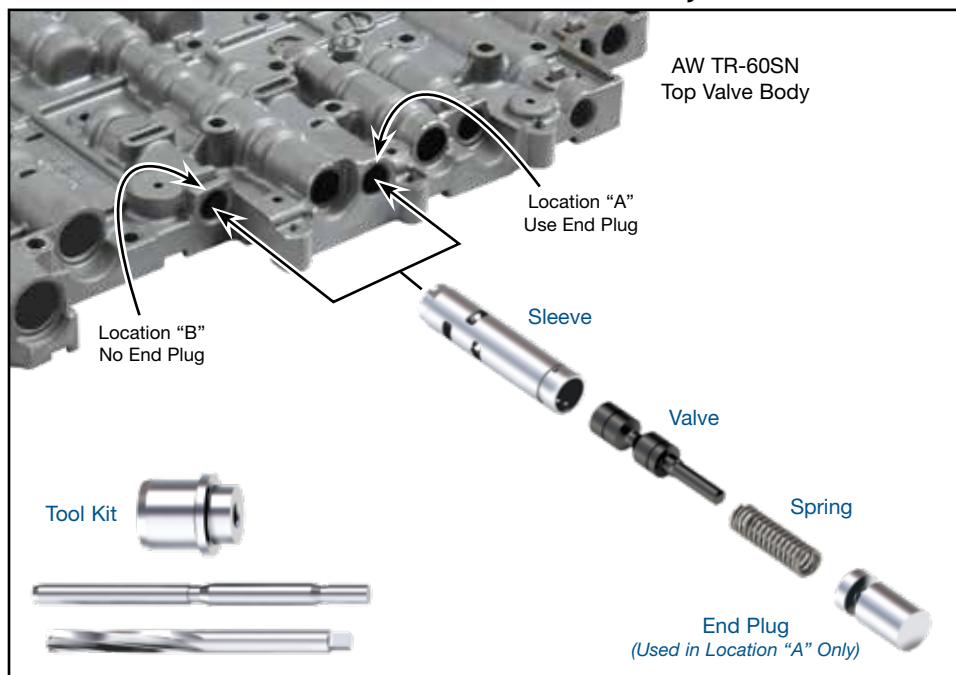
**Part No.**

**F-25741-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](http://www.sonnax.com).

### Aisin AW TR-60SN; VW/Audi 09D



#### 1. Disassembly

- Remove and discard OE valve, spring (in bore "A" and "B") and end plug (in bore "A" only).
- Keep OE retainer for reuse.

#### 2. Bore Reaming

Ream solenoid modulator bore (for reaming instructions/reamer care, please visit [www.sonnax.com](http://www.sonnax.com)). Sonnax reaming tool kit **F-25741-TL18** and **VB-FIX** are required for this operation.

#### 3. Installation & Assembly

- Be certain all debris has been removed from the valve bore and valve body.
- Install Sonnax sleeve and valve. Ensure notched end of sleeve is installed into valve body first. Install valve with spool diameter end first, so the spring guide is facing out.
- Install Sonnax spring.
- Install Sonnax end plug (in bore "A" only). The retaining clip groove end should be installed first, so that it is closest to the spring.
- Reinstall the OE retaining clip.

#### 4. Final Testing

Vacuum testing at the port(s) indicated holds the recommended minimum 18 in-Hg.

