

## Solenoid Modulator Valve Kit



Part No.

**27741-13K**

- Valve
- Sleeve
- Spring

## Tool Kit



Part No.

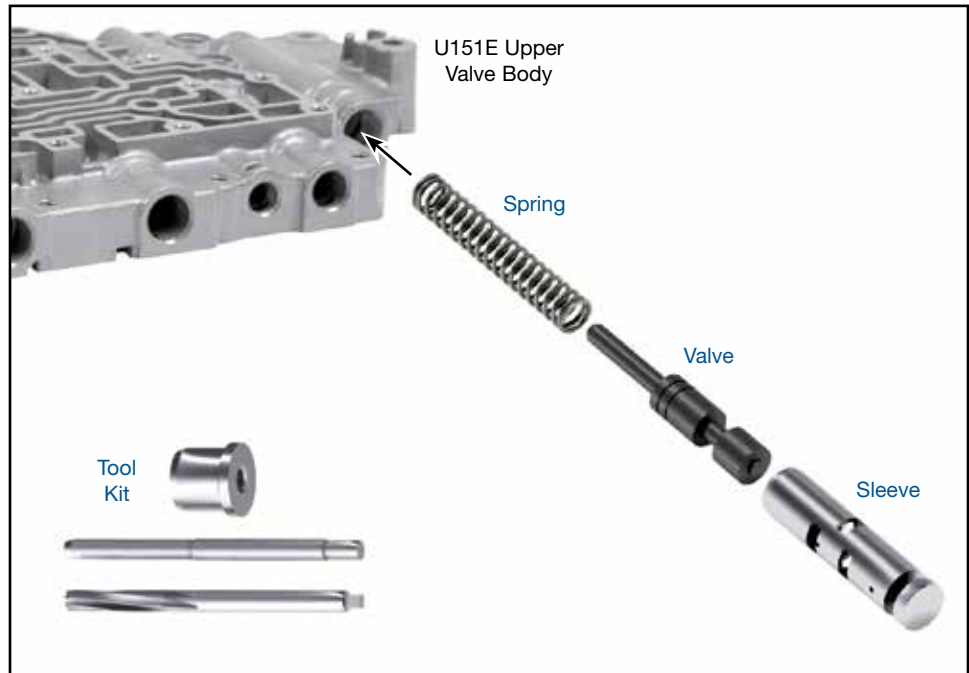
**F-27741-TL13**

- 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).

Tool kit can also be used for 56947J-23K, 56947J-29K, 56947J-56K and 56947J-59K.

## Toyota/Lexus U151E, U151F, U250E



### 1. Disassembly

- Remove and discard OE end plug, valve and spring.
- Keep OE retainer for reuse.

### 2. Bore Reaming

Ream solenoid modulator valve bore (for reaming instructions/reamer care, please visit [www.sonnax.com](http://www.sonnax.com)). Sonnax reaming tool kit **F-27741-TL13** 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.
- Place Sonnax spring over the long stem on Sonnax valve.
- Push spring and valve assembly into Sonnax sleeve.

**NOTE:** To minimize effect of line port side-loading, install Sonnax sleeve as shown in main photo so that the balance orifice and line port opening can be seen when looking into the casting ports.

- Install Sonnax assembly into bore, spring end first.
- Reinstall OE retainer into Sonnax sleeve groove.

### 4. Final Testing

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

