

## Oversized B3 Orifice Control Valve Kit



### Part No.

**27741-16K**

- Valve
- Spring

## Tool Kit



### Part No.

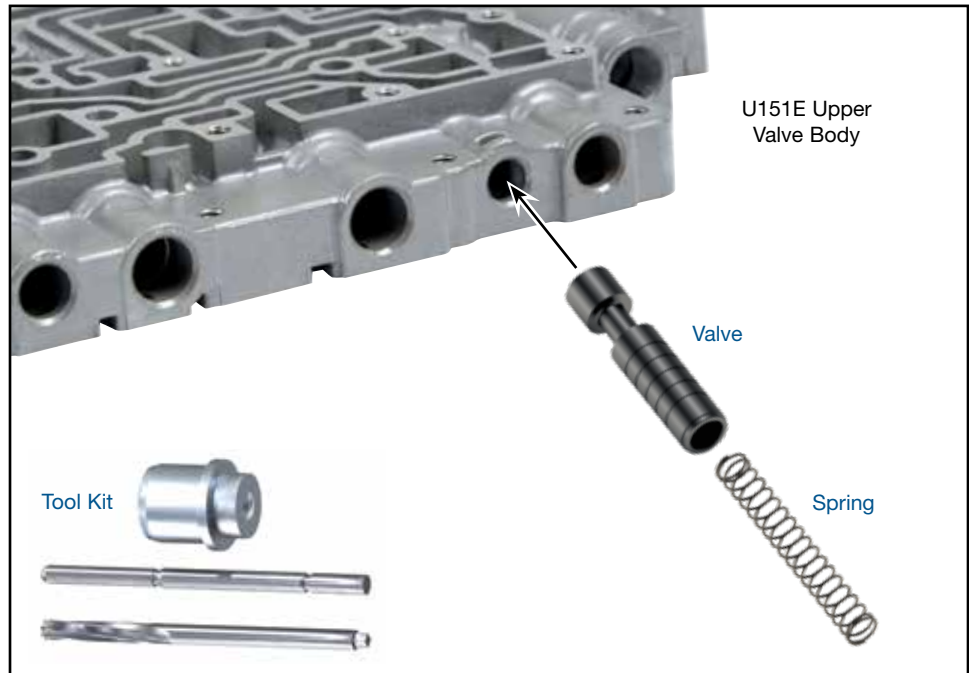
**F-15741-TL18**

- 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).

**NOTE:** Tool kit **F-15741-TL18** also can be used to install Sonnax solenoid modulator valve kit **15741-18K**.

## Toyota/Lexus U151E, U151F, U250E



### 1. Disassembly

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

### 2. Bore Reaming

Ream B3 orifice control bore (for reaming instructions/reamer care, please visit [www.sonnax.com](http://www.sonnax.com)). Sonnax reaming tool kit **F-15741-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.
- Place Sonnax spring into Sonnax valve spring pocket.
- Insert spring and valve assembly into bore, spring end facing out.
- Reinstall OE retainer.

### 4. Final Testing

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

