

B1 Band Control Valve Kit

Part No.
39741-22K



- Valve
- Spring
- Sleeve

NOTE: Also fits Volvo (AM6), Opel (AF40), Peugeot (TF-80), Saab (AF40/6), Land Rover (TF-80), Ford (AF21) and Mazda (AW6A-EL).

Tool Kit



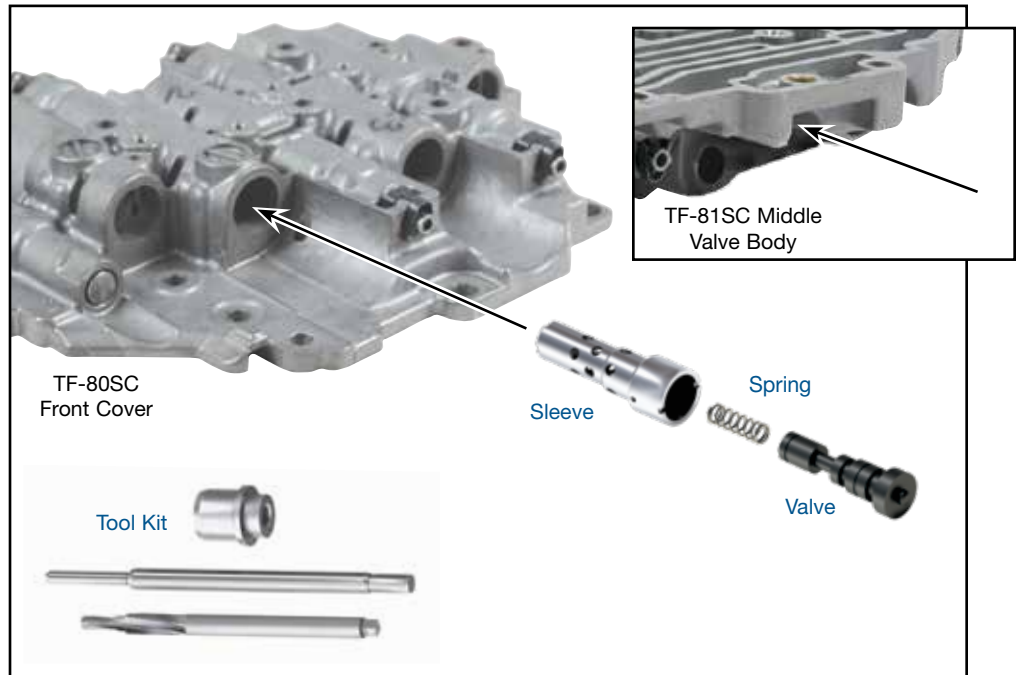
Part No.
F-39741-TL22

- 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.

WARNING: Required tool kit F-39741-TL22 is no longer in production. Check with your distributor for availability.

Aisin AW TF-80SC, TF-81SC



CAUTION: Prior to removal of spring adjustment plug, measure and record distance from end of plug to the casting (**Figure 1**). This dimension must be matched during reassembly.

1. Disassembly

- Remove and save OE retaining clip.
- Measure and record adjustment plug to casting distance, then remove and save OE adjuster.
- Remove the OE retaining pin, solenoid, valve and spring, discarding valve and spring.
- Reinstall adjustment plug into empty bore, such that the inboard nub is just visible at the casting port (**Figure 2**). The approximate measurement from casting face to the end of plug is .270". Hold in place with OE clip. The end plug will serve as the stop for the guide pin and reamer.

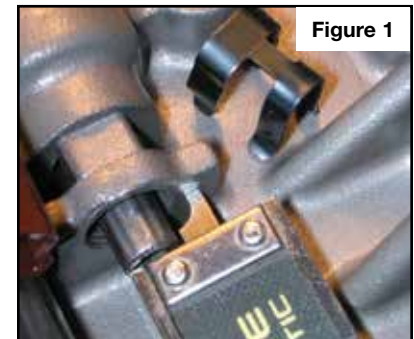


Figure 1

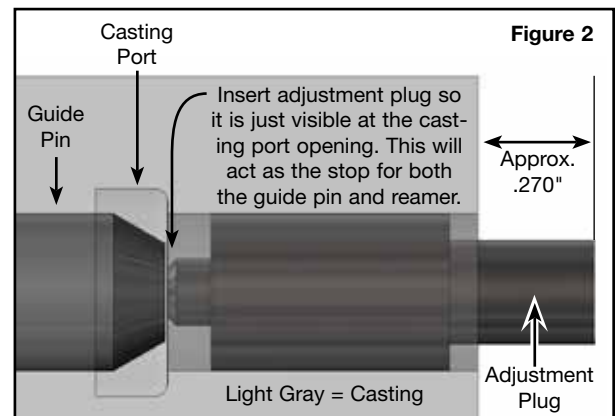


Figure 2

2. Bore Reaming

Ream B1 band control valve bore (for reaming instructions/reamer care, please visit www.sonnax.com). Sonnax reaming tool kit **F-39741-TL22** 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.
- Reinstall OE spring adjustment plug and set to reference dimension noted in disassembly procedure, then reinstall OE adjustment plug retaining clip.



NOTE: To reduce pressure loss past spring adjustment plug threads, an ATF-compatible thread sealant can be used. Permatex® 24163 surface prep activator combined with blue thread locker works well for this purpose. Compound used must not create a permanent set.

- Install Sonnax spring, ensuring spring I.D. goes over spring adjuster nub.
- Install Sonnax valve/sleeve assembly.
- Reinstall OE solenoid and retaining pin.

4. Final Testing

Vacuum testing at the port(s) indicated holds the recommended minimum 18 in-Hg (**Figure 2**).

