

Oversized Solenoid Modulator Valve Kit

Part No.

39741-18K



- Valve
- Sleeve
- Spring
- End Plug Use in TF-81SC Only

NOTE: Fits either of 2 locations in both valve bodies.

Fits Volvo (AM6); Opel (AF40); Peugeot (TF80); Saab (Af40/6); Land Rover (TF80); Ford (AF21) and Mazda (AW6A-EL).

Tool Kit



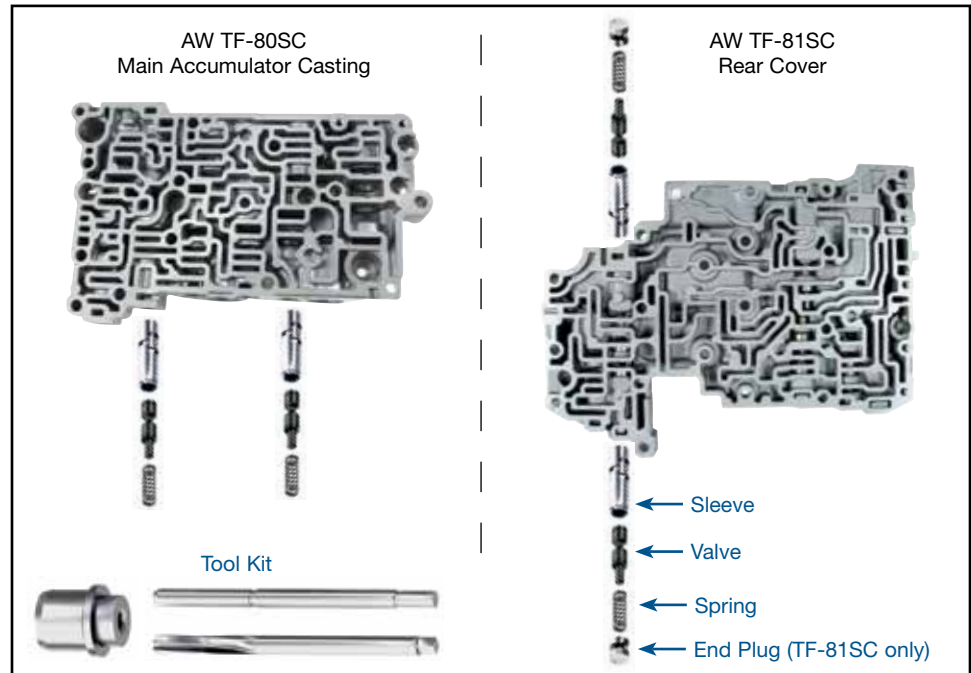
Part No.

F-39741-TL18

- Reamer
- Guide Pin
- Reamer Jig

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.

Aisin AW TF-80SC, TF-81SC



1. Disassembly

Remove and discard the OE solenoid modulator valve, spring and end plug, if applicable.

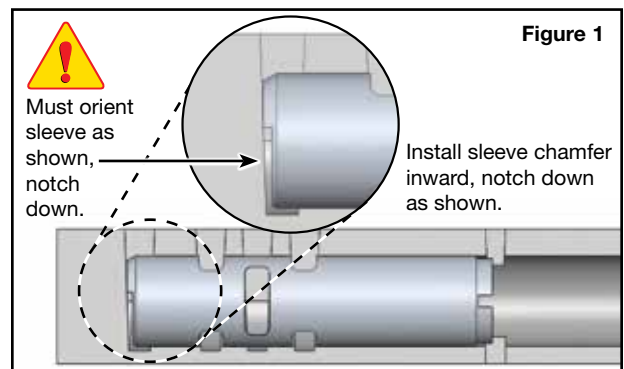
2. Bore Reaming

Ream solenoid modulator bore (for reaming instructions/reamer care, please visit www.sonnax.com). Sonnax reaming tool kit **F-39741-TL18** and **VB-FIX** are required for this operation.

3. Installation & Assembly

- Ensure all debris has been removed from valve bore and valve body.
- Insert Sonnax valve/sleeve assembly into bore, with the sleeve recessed end/notch down (**Figure 1**) and valve spring stem facing outboard (**main photo**).
- Install replacement spring over the valve stem.
- If applicable, insert Sonnax end plug into bore and secure sleeve and valve assembly and spring with OE retainer.

NOTE: In some instances, the sleeve may be slightly long (.010–.020") for the bore, preventing the retainer from securing the parts properly. If this is the case, carefully flat sand the outboard face of the sleeve (at the recess area) until the sleeve is of proper length to fit in the bore.



4. Final Testing

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

