

Aisin AW TF-60SN, TF-80SC, TF-81SC; Mini 6F21WA; VW/Audi 09G, 09K, 09M

Oversized Three-Spool Relay/Control/Switch Valve Kit



Part No.

15741-50K

- Valve
- End Plug

NOTE: This kit can be used in any of six locations in five different valve body applications. See chart **Figure 1** and identification photos **Figures 2, 3 & 4** for details.

Tool Kit



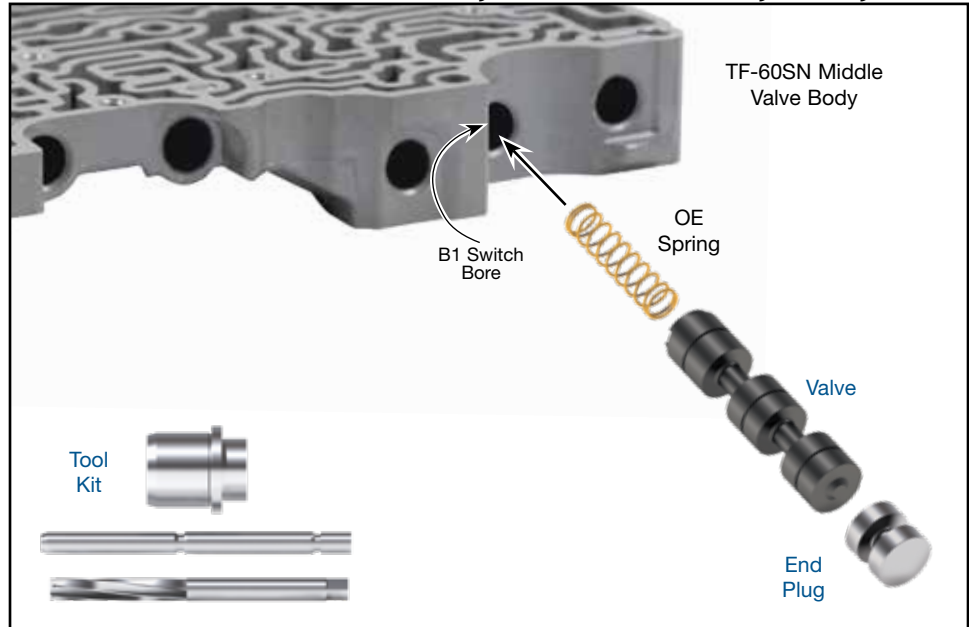
Part No.

F-33741B-TL1

- 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.

This tool kit also can be used with Sonnax kits **15741-49K** and **33741B-01**.



Application	Valve Body Section	Valve Name	Affected Gears
TF-60SN (VW 09G) 6F21WA	Middle Valve Body	B1 Switch	2nd & 6th
	Upper Valve Body #1	K3 Control	3rd, 5th & Reverse
TF-80SC	Middle Casting	B1/C3 Relay	2-3, 3-2, 5-6 & 6-5
		B1/C3 Switch	2-3, 3-2, 5-6 & 6-5
TF-81SC	Middle Valve Body	B1/C3 Relay	2-3, 3-2, 5-6 & 6-5
		B1/C3 Switch	2-3, 3-2, 5-6 & 6-5

1. Valve Bore ID & Disassembly

Locate and positively identify the valve body bore that needs repair.



NOTE: See chart (**Figure 1**) and photo identifications (**Figures 2, 3 & 4**) for important information on applications, bore locations, installation orientations and affected gears.

2. Disassembly

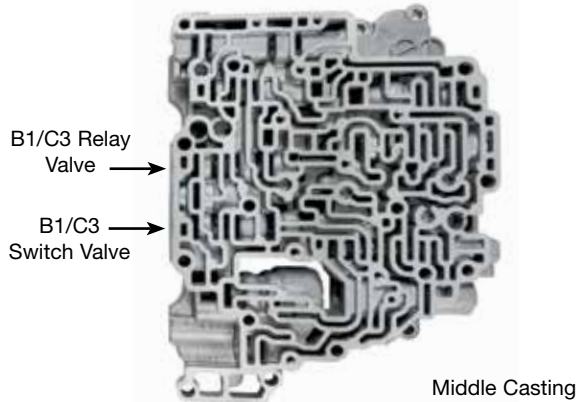
- Remove OE valve train.
- Save OE spring and end plug retainer for reuse, and discard OE valve and end plug.

2. Bore Preparation

- Ream intended bore (for reaming instructions/reamer care, please visit www.sonnax.com). Sonnax reaming tool kit **F-33741B-TL1** and **VB-FIX** are required for this operation.

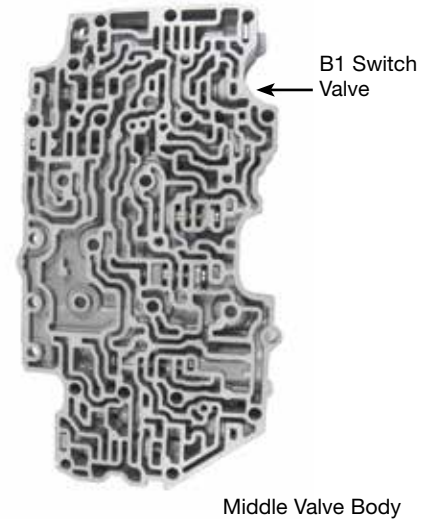
TF-80SC Valve Body • Three-Spool Relay/Control/Switch Valve Locations

Figure 2



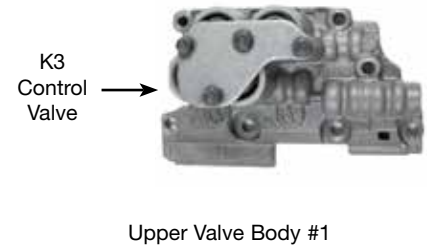
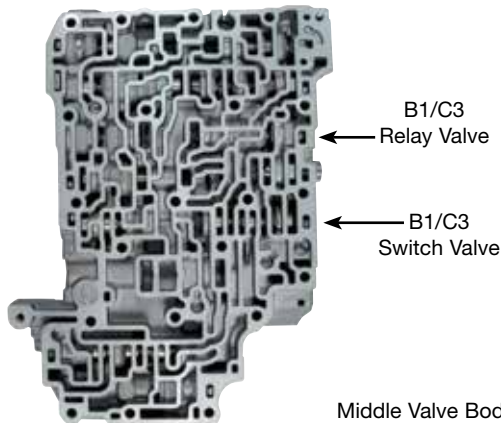
**TF-60SN Valve Body
Three-Spool Relay/Control/Switch
Valve Locations**

Figure 4



TF-81SC Valve Body • Three-Spool Relay/Control/Switch Valve Locations

Figure 3

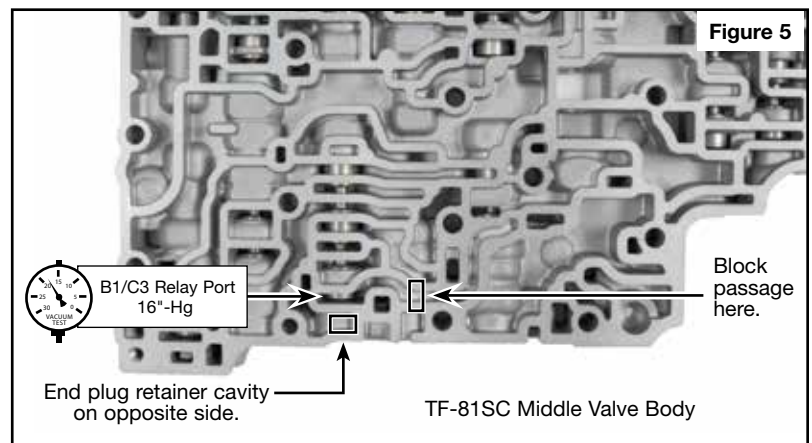


4. Installation & Assembly

- Reinstall OE spring into the reamed bore.
- Install Sonnax valve with the spring pocket end going into the bore first as shown (**main photo**).
- Be certain that the spring sits into the valve spring pocket and does not catch the edge of the valve adjacent to the spring pocket.
- Install Sonnax end plug.
- Reinstall OE end plug retainer to secure Sonnax end plug.

5. Final Testing

Vacuum testing at the port(s) indicated holds the recommended minimum 16 in-Hg (**Figure 5**).



NOTE: The vacuum test above for the B1/C3 Relay Port in TF-81SC application is an example of a typical port location. All the other valves should be checked similarly at the port associated with the plug-to-valve spool interface.