

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

Oversized Clutch Cutoff Valve Kit

Part No.

15741-63K

- Valve
- End Plug



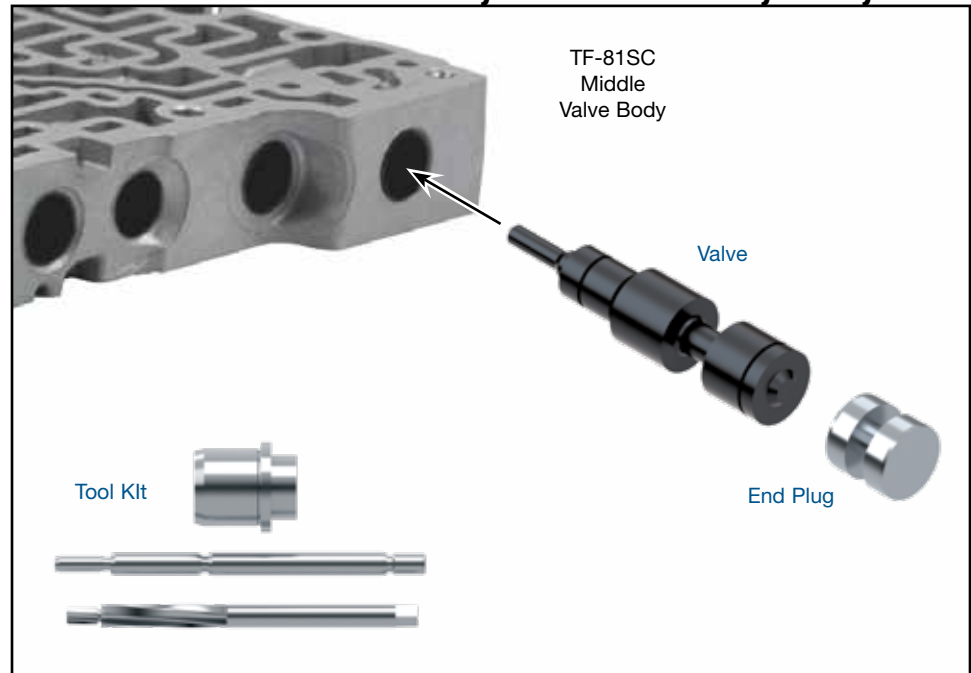
NOTE: Fits three locations in each unit. See Figures 1, 2 & 3 for details.

Tool Kit

Part No.

F-15741-TL63

- Reamer
- Reamer Jig
- Guide Pin



1. Disassembly

- Remove OE retaining clip and save for reuse.



NOTE: The TF-80SC valve location is retained with a bolt-on plate rather than an end plug. Set aside fasteners and plate for reuse.

- Remove and discard OE end plug and valve.
- Remove OE spring and save for reuse.

2. Bore Reaming

Ream clutch cutoff bore (for reaming instructions/reamer care, please visit www.sonnax.com). Sonnax reaming tool kit **F-15741-TL63** and **VB-FIX** are required for this operation.

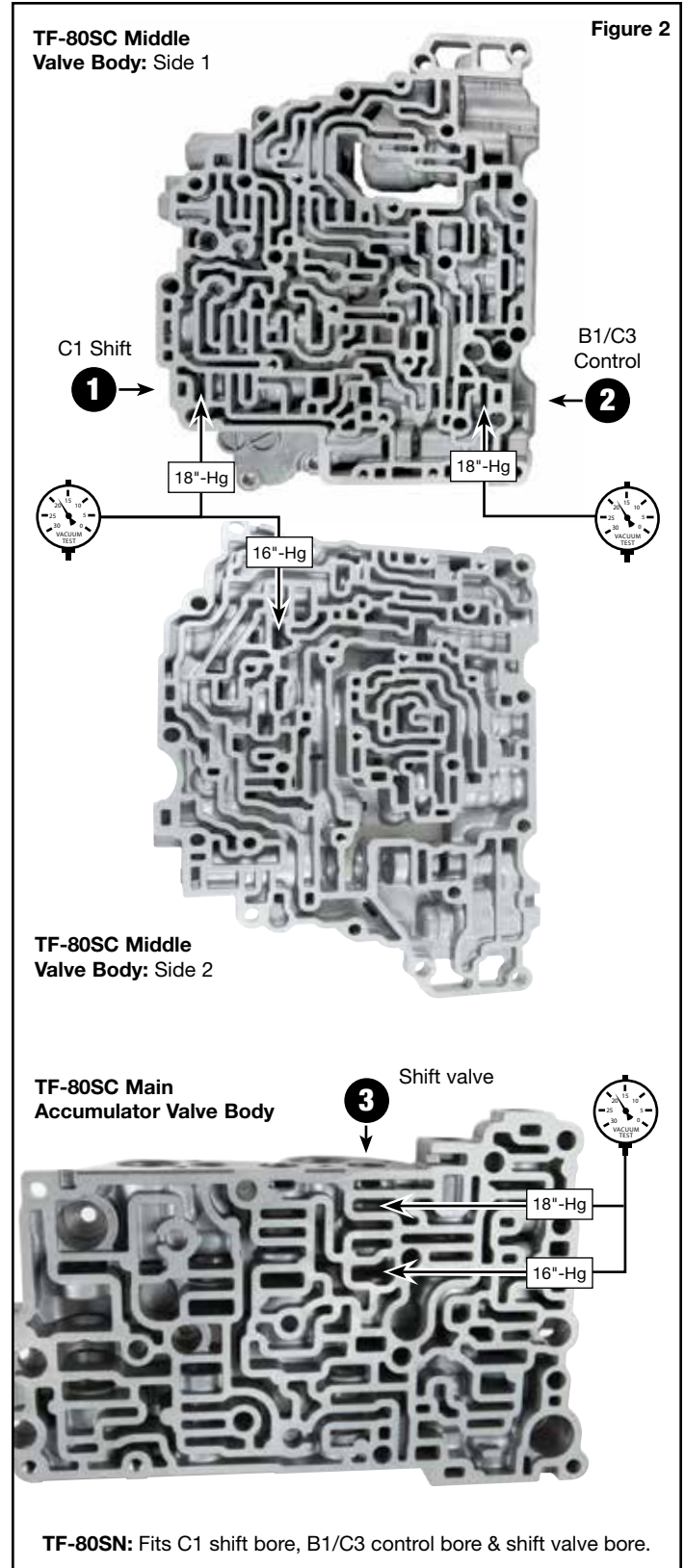
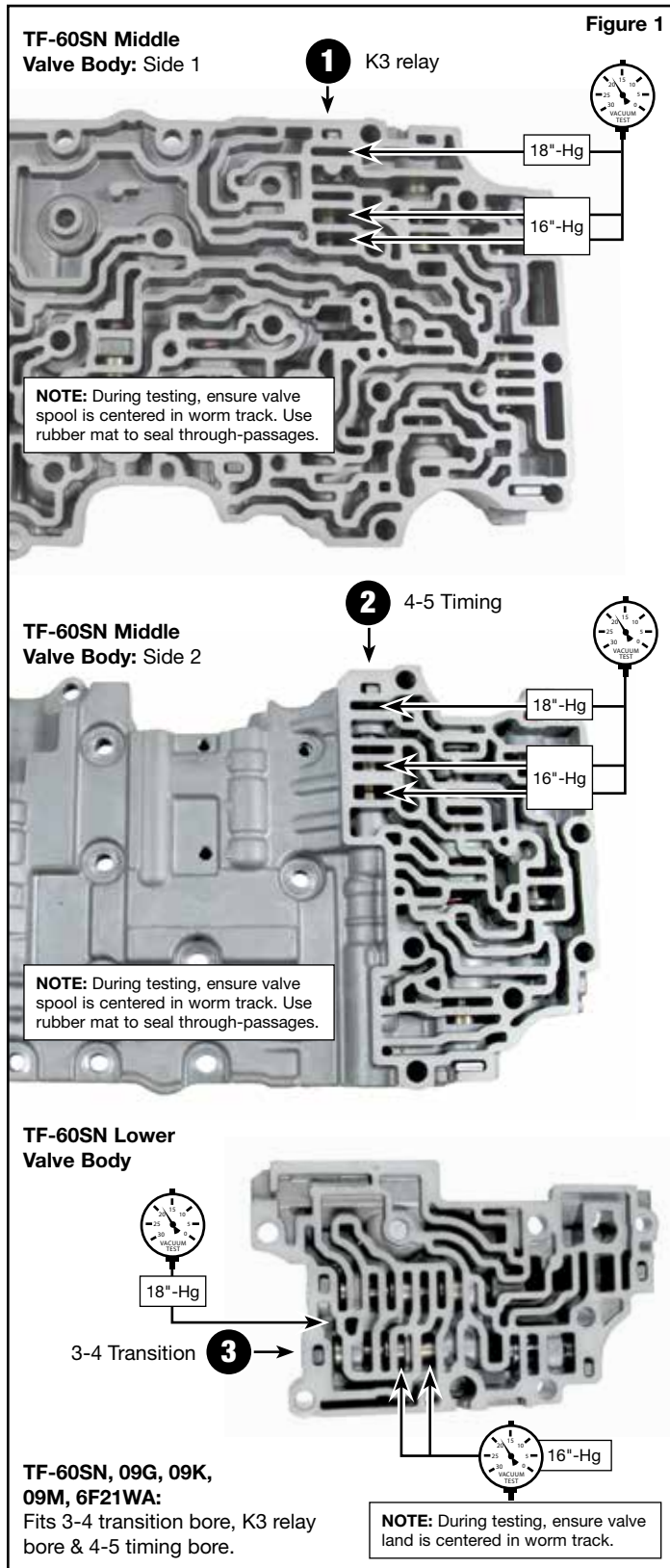
3. Installation & Assembly

- Ensure all debris has been removed from valve bore and body.
- Reinstall OE spring.
- Install Sonnax valve, ensuring spring seats over valve spring guide.
- Install Sonnax end plug and secure with OE retaining clip.
- For TF-80SC valve, reinstall and secure OE end plate.

4. Final Testing

Vacuum testing at the port(s) indicated holds the recommended minimum 16 and 18 in-Hg (**Figures 1, 2 & 3**).

Valve Fitment & Vacuum Testing Details



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