

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

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.

Oversized Clutch

Cutoff Valve Kit

for details.

15741-63K

Part No.

• Valve

• End Plug

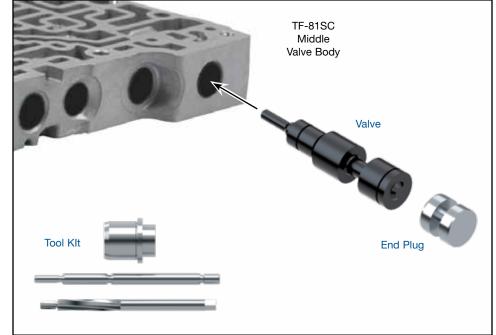
Tool Kit

Part No.

Reamer Reamer Jig Guide Pin

Instructions

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



1. Disassembly

a. 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.

- b. Remove and discard OE end plug and valve.
- c. 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

- a. Ensure all debris has been removed from valve bore and body.
- b. Reinstall OE spring.
- c. Install Sonnax valve, ensuring spring seats over valve spring guide.
- d. Install Sonnax end plug and secure with OE retaining clip.
- e. 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).

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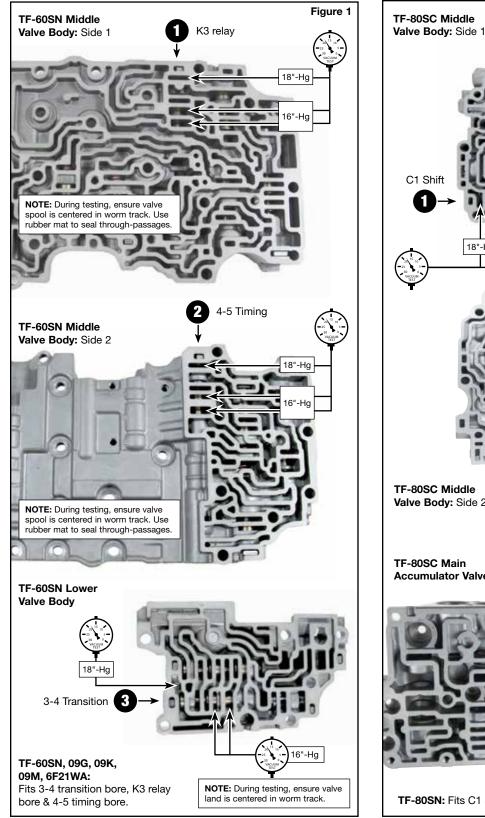
SONDAX®

OVERSIZED CLUTCH CUTOFF VALVE KIT 15741-63K, F-15741-TL63

Instructions

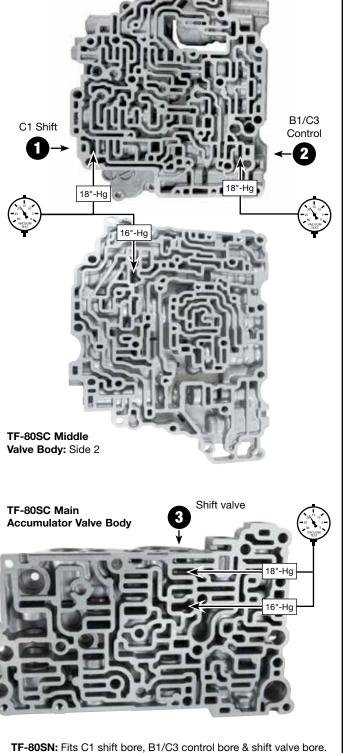
Figure 2

Valve Fitment & Vacuum Testing Details



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Instructions

Valve Fitment & Vacuum Testing Details

