

## Oversized Clutch Cooling Control Valve Kit



**Part No.**  
**225740-01K**

- Valve
- O-Rings (2) 1 Extra

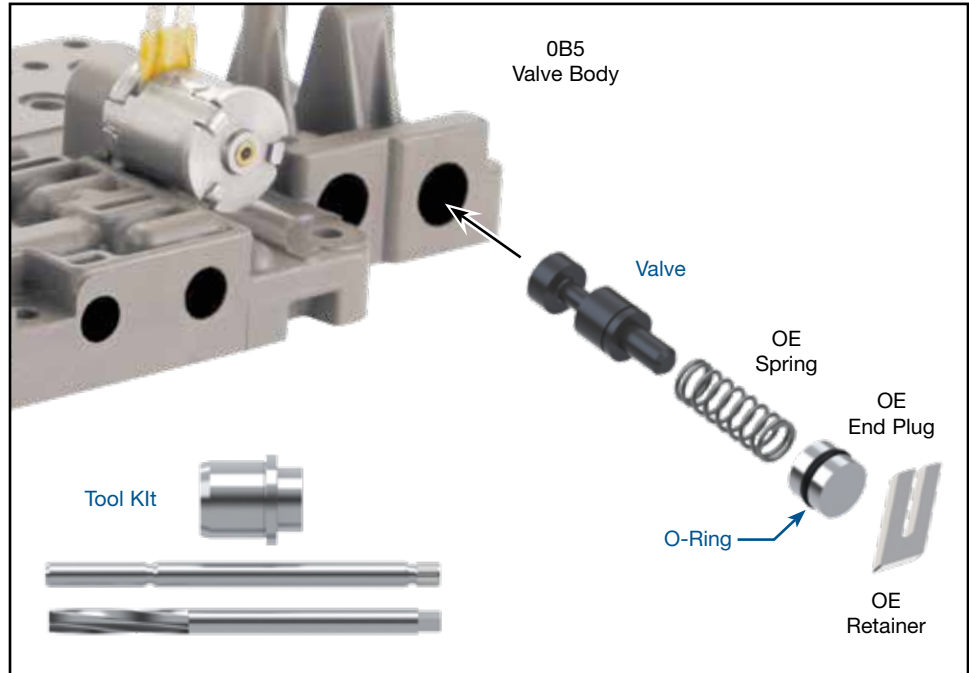
## Tool Kit



**Part No.**  
**F-225740-TL**

- 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](http://www.sonnax.com).



### 1. Disassembly

- Remove OE retainer, end plug and spring. Set aside for reuse.
- Remove and discard OE valve.

### 2. Bore Reaming

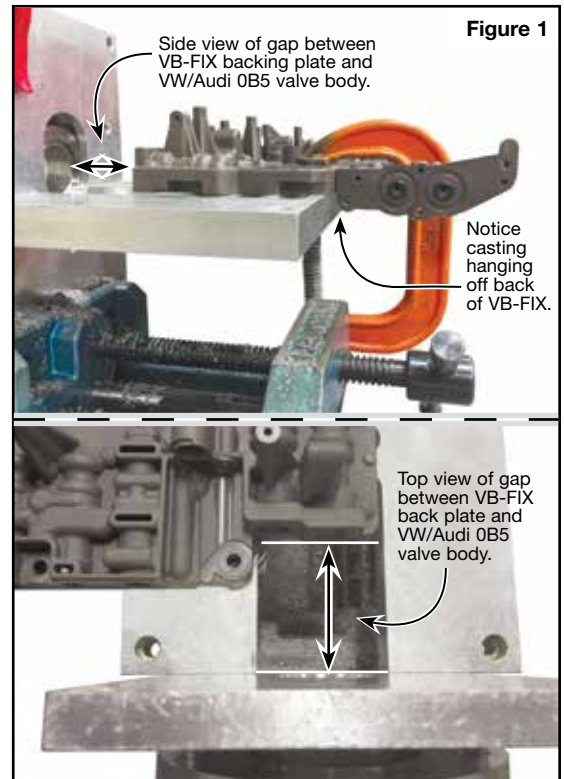


**CAUTION:** Due to shape of casting, valve body must be placed further away from the backing plate of VB-FIX as shown (Figure 1).

Ream clutch cooling control bore (for reaming instructions/reamer care, please visit [www.sonnax.com](http://www.sonnax.com)). Sonnax reaming tool kit **F-225740-TL** and **VB-FIX** are required for this operation.

### 3. Installation & Assembly

- Ensure valve bore and valve body are clean and clear of debris.
- Install Sonnax valve with stem facing outward.
- Reinstall OE spring, ensuring it seats over valve stem.



### 3. Installation & Assembly (continued)

- d. Remove O-ring from OE end plug and install Sonnax O-ring into end plug groove. Lubricate and roll on clean flat surface to size O-ring into groove.
- e. Reinstall OE end plug and secure with OE retainer.

### 4. Final Testing

Vacuum testing at the port(s) indicated holds the recommended minimum 16 in-Hg (**Figure 2**).

