

Oversized Lockup Relay Valve Kit



Part No.
147741-07K

- Lockup Relay Valve
- Control Valve
- Spring
- End Plug

Tool Kit

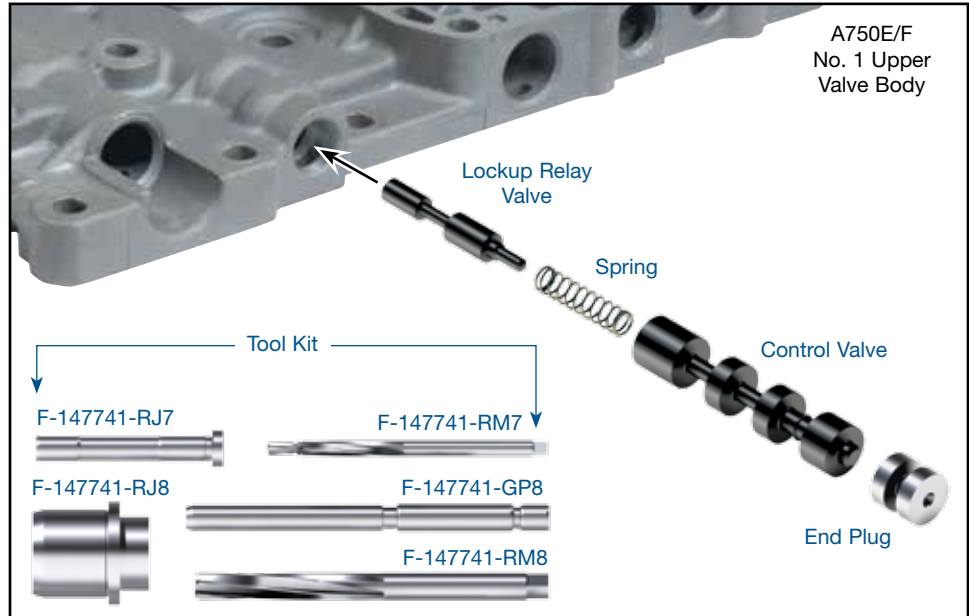


Part No.
F-147741-TL7

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|--------------|--------------|
| • Reamer | F-147741-RM7 |
| • Reamer Jig | F-147741-RJ7 |
| • Reamer | F-147741-RM8 |
| • Reamer Jig | F-147741-RJ8 |
| • Guide Pin | F-147741-GP8 |

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.

Toyota A750E/F, A760E/F/H, A761E, A960E/F, AB60E/F



A750E/F
No. 1 Upper
Valve Body



IMPORTANT CAUTION: Ream the small diameter inboard valve bore BEFORE reaming the larger diameter outboard bore. Failure to ream the smaller diameter inboard bore first will cause irreparable damage to valve body.

1. Disassembly

- Remove all OE components from bore.
- Keep OE retaining pin for reuse, discard all other OE parts.



WARNING: Reaming involves two separate operations that must be performed in order. Failure to follow correct order will result in irreparable damage to valve body.

2. First Reaming Procedure

- Securely clamp valve body to bench. Ensure clamp is not placed over bore to be reamed.
- Insert reamer jig **F-147741-RJ7** directly into bore.
- Insert reamer **F-147741-RM7** through reamer jig.
- Saturate bore and reamer with cutting fluid and begin reaming using a low-rpm, high-torque drill regulated to a maximum of 200 rpm. For best results, provide a continuous flow of water-soluble cutting fluid during reaming process.
- Continue reaming until reamer stop is reached.
- Remove reamer by turning clockwise while pulling outward.



WARNING: Turning the reamer backward will dull it prematurely.

- Clean bore thoroughly and remove all debris before beginning next reaming procedure.

3. Second Reaming Procedure

- Secure valve body on VB-FIX and align bore with reamer jig **F-147741-RJ8**.
- Ream bore with reamer **F-147741-RM8** (for in-depth VB-FIX reaming instructions, please visit www.sonnax.com).

4. Installation & Assembly

- Be certain all debris has been removed from valve bores and valve body.
- Install Sonnax lockup relay valve, spring, control valve and end plug as shown in main photo.
- Reinstall OE retaining pin.

5. Final Testing

Vacuum testing at the port(s) indicated holds the recommended minimum 14 in-Hg.

