

**Oversized B3
Orifice Control
Valve Kit**



Part No.

27741-16K

- Valve
- Spring

Tool Kit



Part No.

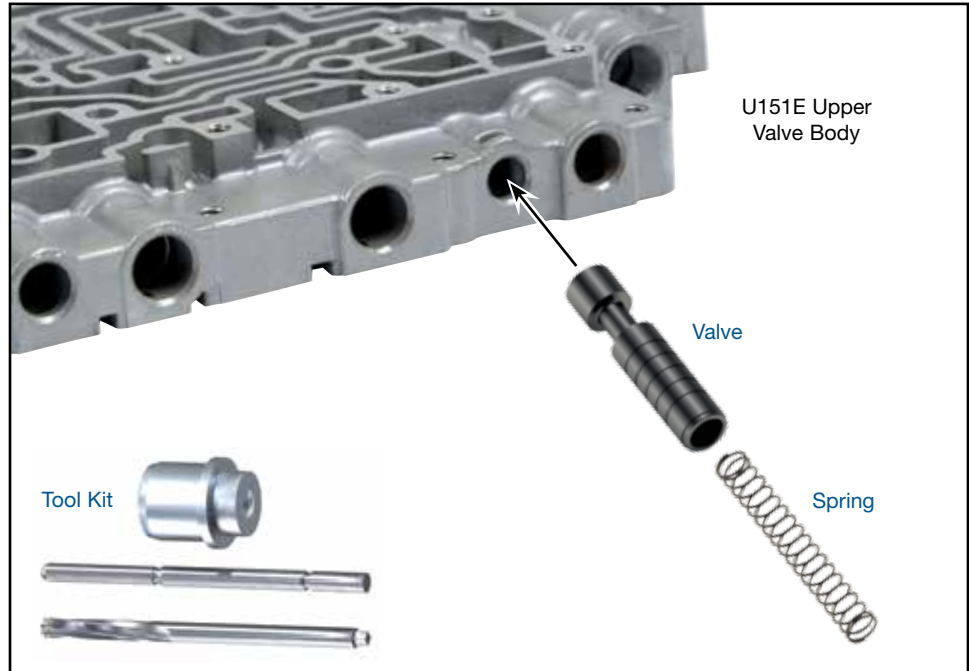
F-15741-TL18

- 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.

NOTE: Tool kit F-15741-TL18 also can be used to install Sonnax solenoid modulator valve kit 15741-18K for TF-60SN unit.

Toyota/Lexus U151E, U151F, U250E



1. Disassembly

- Remove and discard OE valve and spring.
- Keep OE retainer for reuse.

2. Bore Reaming

Ream B3 orifice control bore (for reaming instructions/reamer care, please visit www.sonnax.com). Sonnax reaming tool kit F-15741-TL18 and VB-FIX are required for this operation.

3. Installation & Assembly

- Be certain all debris has been removed from the valve bore and valve body.
- Place Sonnax spring into Sonnax valve spring pocket.
- Insert spring and valve assembly into bore, spring end facing out.
- Reinstall OE retainer.

4. Final Testing

Vacuum testing at the port(s) indicated holds the recommended minimum 18 in-Hg.

