

**Oversized Clutch
Apply Control
Valve Kit**



Part No.
27741-18K

- Valve
- Spring
- End Plug

Tool Kit

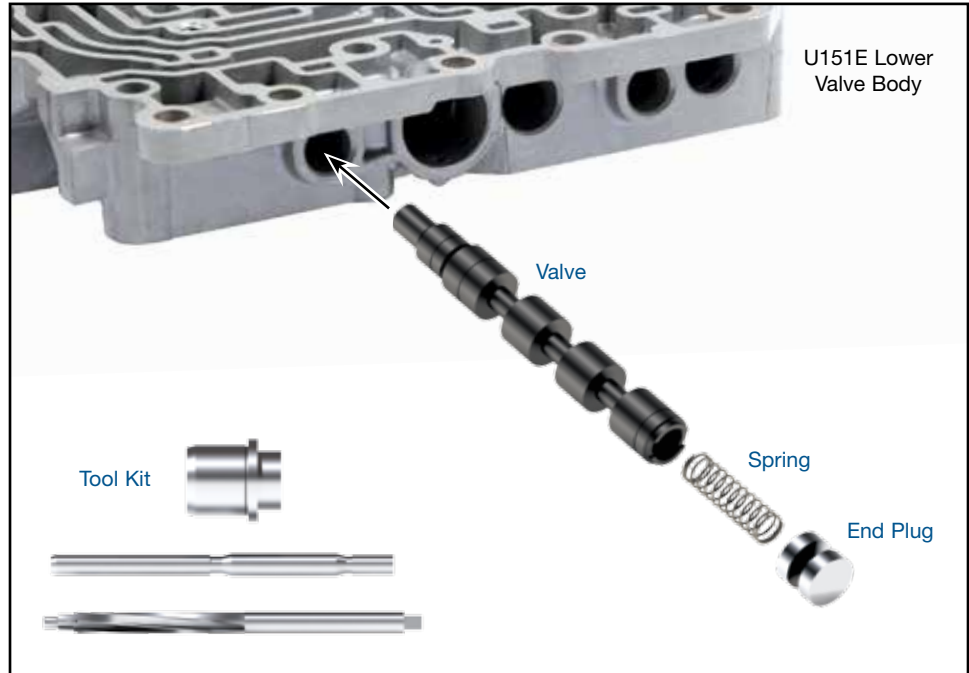


Part No.
F-27741-TL18

- 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.

Toyota/Lexus U151E, U151F, U250E



1. Disassembly

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

2. Bore Reaming

Ream clutch apply control bore (for reaming instructions/reamer care, please visit www.sonnax.com). Sonnax reaming tool kit F-27741-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.
- Install Sonnax end plug and secure with the OE retainer.

4. Final Testing

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

NOTE: Must use mat to seal other side while testing.

