

Oversized B2 Apply Control Valve Kit

Part No.
47740-27K



- Inboard Valve Three-Spool
- Outboard Valve Four-Spool
- Spring
- End Plug

Tool Kit

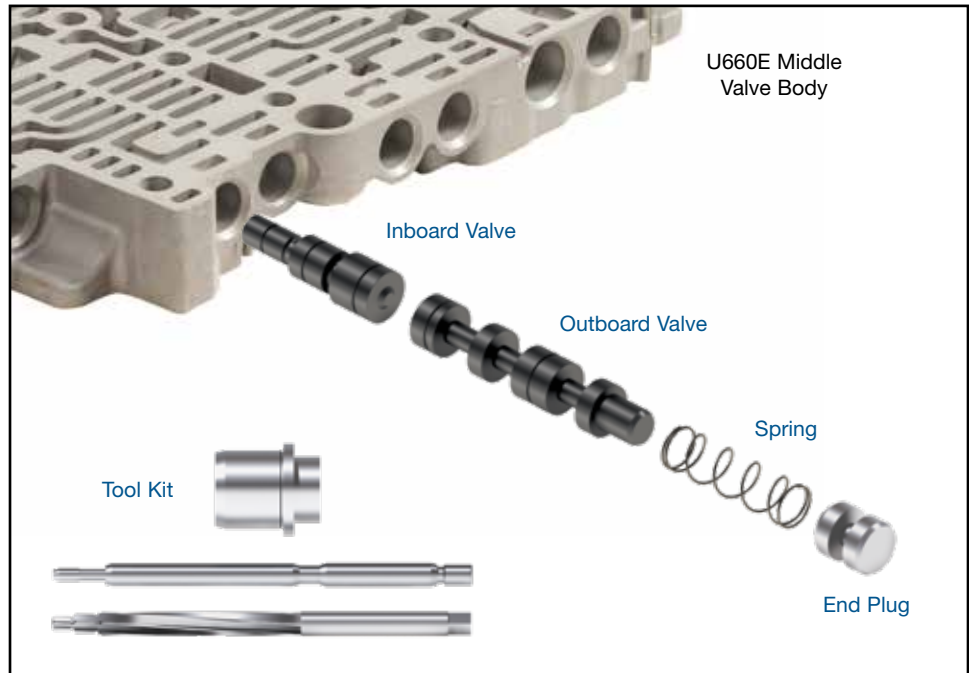
Part No.
F-47740-TL27



- 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 U660E, U660F, U760E, U760F



1. Disassembly

- Remove OE retainer pin and set aside for reuse.
- Remove and discard OE end plug, spring, four-spool valve and three-spool valve.

2. Bore Reaming

Ream B2 bore (for reaming instructions/reamer care, please visit www.sonnax.com). Sonnax reaming tool kit **F-47740-TL27** and **VB-FIX** are required for this operation.

NOTE: Reamer tip will stop approximately .060" short of bore bottom (**Figure 1**).

3. Installation & Assembly

- Be certain all debris has been removed from valve bore and valve body.
- Install Sonnax three-spool valve, small spool inboard.
- Install Sonnax four-spool valve, spring guide outboard.
- Install Sonnax spring over valve spring guide.
- Install Sonnax end plug and secure with OE retaining pin.

4. Final Testing

Vacuum tests at the ports indicated hold a minimum of 14 in-Hg.

