

Oversized B1 Band Control Valve Kit

Part No.
39741-48K



- Valve
- Spring

NOTE: Also fits Volvo (AM6); Opel (AF40); Peugeot (TF80); Saab (AF40/6); LandRover (TF80); Ford (AF21) & Mazda (AW6A-EL).

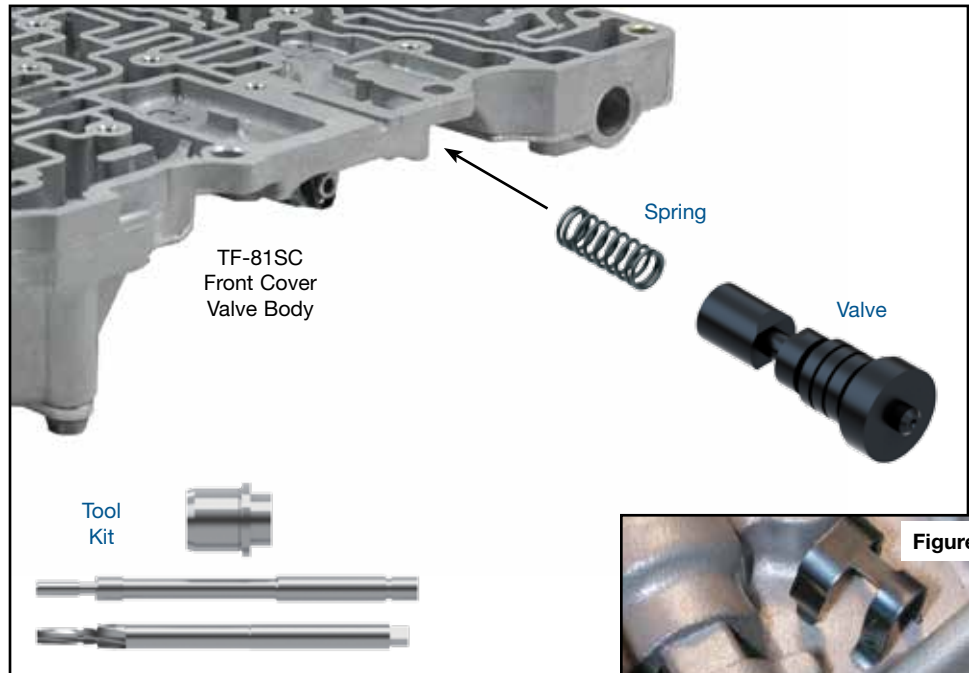
Tool Kit

Part No.
F-39741-TL48



- Reamer
- Reamer Jig
- Guide Pin

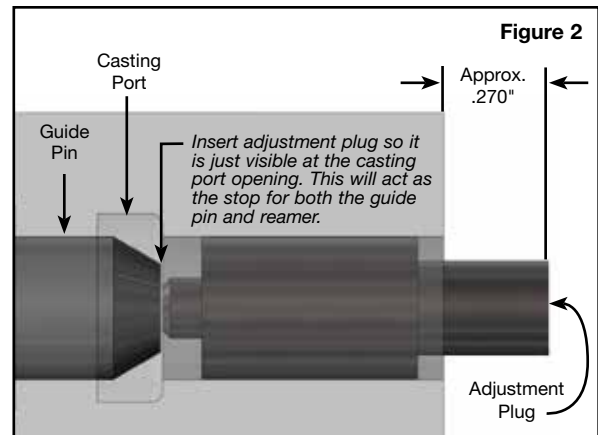
NOTE: Sonnax "F-Tool" kits designed to service a specific bore require the VB-FIX, a self-aligning valve body reaming fixture. More information and instructions can be found online at www.sonnax.com.



CAUTION: Prior to removal of spring adjustment plug, measure and record distance from end of plug to the casting (**Figure 1**). This dimension must be matched during reassembly.

1. Disassembly

- Remove and save OE adjustment plug retaining clip.
- Measure and record adjustment plug-to-casting distance, then remove and save OE adjustment plug (**Figure 1**).
- Remove OE retaining pin and solenoid, set aside for reuse.
- Remove and discard OE valve and spring.
- Reinstall adjustment plug into empty bore, ensuring the inboard nub is just visible at the casting port (**Figure 2**). The approximate measurement from casting face to the end of the plug is .270". Hold in place with OE adjustment plug retaining clip. The adjustment plug will serve as guide pin and reamer stop.



2. Bore Reaming

Ream B1 band control valve bore (for reaming instructions/reamer care, please visit www.sonnax.com). Sonnax reaming tool kit **F-39741-TL48** and **VB-FIX** are required for this operation.

3. Installation & Assembly

- Be certain all debris has been removed from valve bore and body.
- Reinstall OE spring adjustment plug and set to reference dimension noted in disassembly procedure, then reinstall OE adjustment plug retaining clip.



NOTE: To reduce pressure loss past spring adjustment plug threads, an ATF-compatible thread sealant can be used. Permatex® 24163 surface prep-activator combined with blue thread locker works well for this purpose. Compound used must not create a permanent set.

- Install Sonnax spring, followed by Sonnax valve; ensure spring is secured in valve spring pocket during installation.
- Reinstall OE solenoid and retaining pin.

4. Final Testing

Vacuum testing at the port(s) indicated holds the recommended minimum 18 in-Hg (**Figure 3**).

