

Oversized Solenoid Modulator Valve Kit

Part No.

39741-18K



- Solenoid Modulator Valve
- Solenoid Modulator Sleeve
- Spring
- End Plug Use in TF-81SC Only

NOTE: Can be used in either of 2 locations in both valve bodies.

Fits Volvo (AM6); Opel (AF40); Peugeot (TF80); Saab (Af40/6); Land Rover (TF80); Ford (AF21) and Mazda (AW6A-EL).

Tool Kit



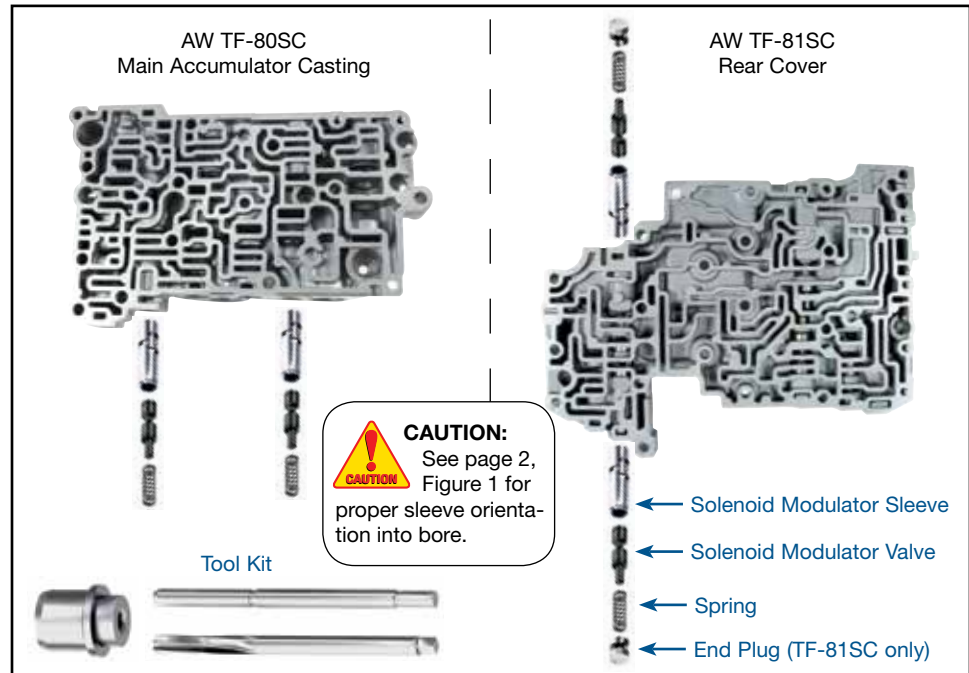
Part No.

F-39741-TL18

- Reamer
- Guide Pin
- Reamer Jig

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.

Aisin AW TF-80/81SC



1. Disassembly

Remove and discard the OE solenoid modulator valve, spring and end plug, if applicable.

2. Bore Preparation

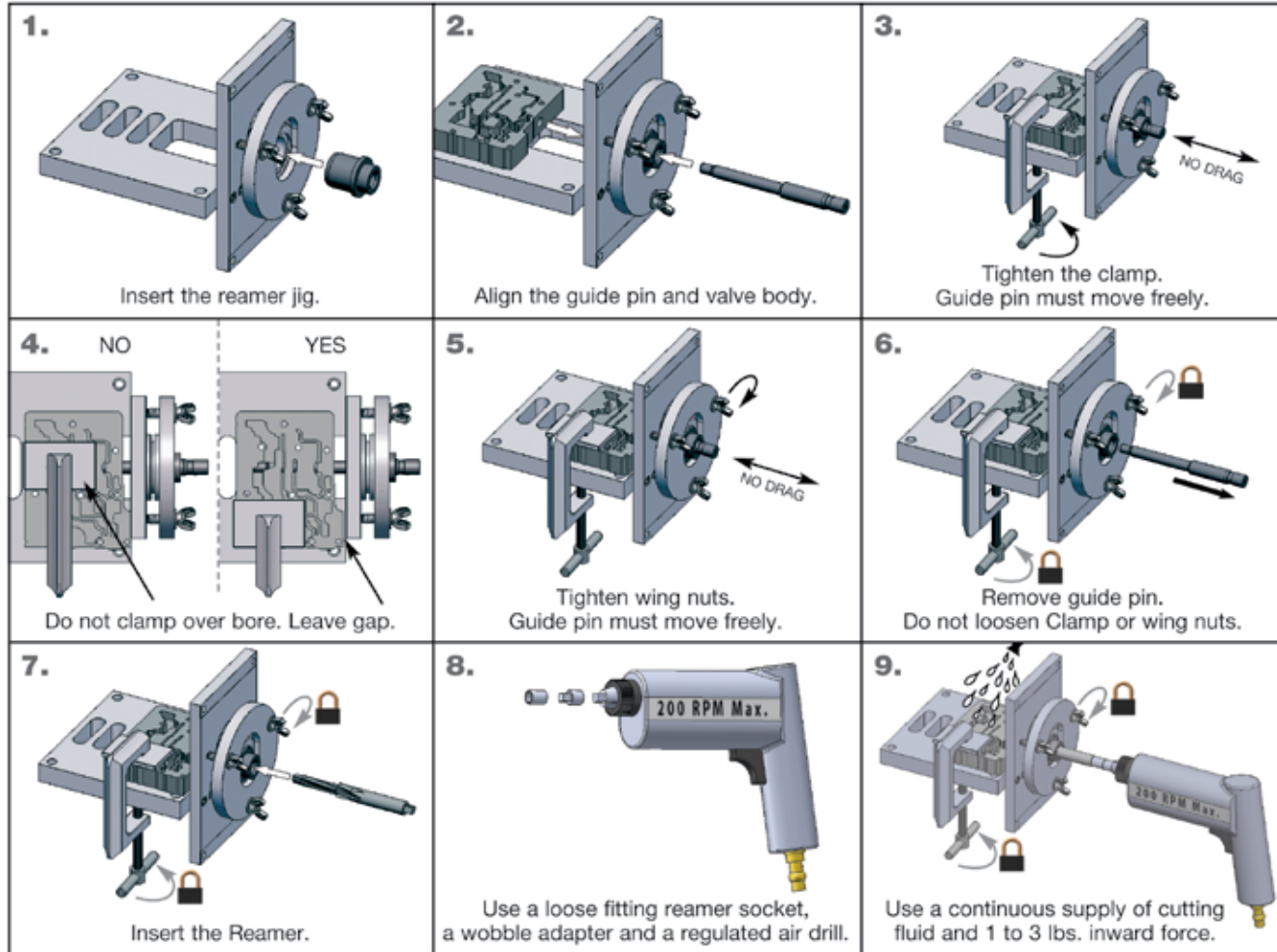
- Clean the bore thoroughly in a solvent tank.
- Generously lubricate the bore and reamer with cutting fluid (i.e. Mobilmet S-122, Lubgard[®] Bio-Tap, Tap Magic[™], etc.). For best results, provide a continuous flow of water-soluble cutting fluid (i.e. Mobilmet S-122) during the reaming process.
- The reamers should be turned using a low RPM, high-torque air drill regulated to a maximum of 200 RPM.
- Examine the bore after cleaning for surface finish, debris and burrs. Flashing and burrs on the exit side of land and in bores must be carefully removed. A small piece of Scotch-Brite[™] material attached to a wire and powered with a drill motor is ideal for the task. Scotch-Brite[™] is a very abrasive material and all residual debris must be cleaned to ensure particles do not migrate or remain imbedded into the surface. Post cleaning involves several progressive steps with solvent on a lint-free rag.

CAUTIONS AND SUGGESTIONS:

- Turning the reamer backward will dull it prematurely.
- Pushing on the reamer will result in poor surface finish and inadequate and sporadic material removal.
- Never use a crescent wrench, ratchet or pliers to turn the reamer.
- A dull reamer will cut a smaller hole. Reamers can be sharpened, but should only be done by a professional tool sharpener. Actual life of a Sonnax reamer before resharpening or replacing averages 50-70 bores.

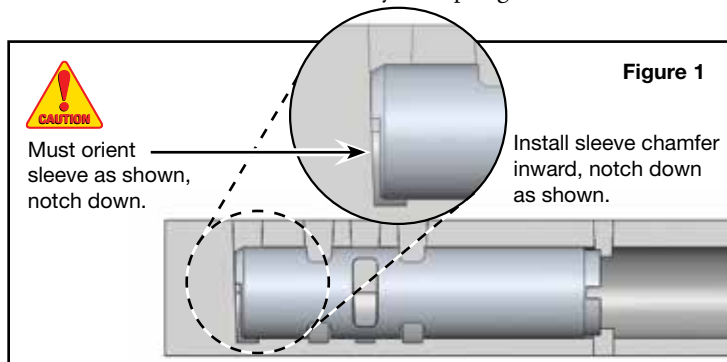
3. Bore Reaming

Use the associated "F-Tool" F-39741-TL18 kit and VB-FIX reaming fixture as illustrated below to ream the bore.



4. Installation & Assembly

- Insert the Sonnax valve/sleeve assembly into bore, with the sleeve recessed end/notch down (**Figure 1**) and valve spring stem facing outboard (**main photo**).
- Install replacement spring over the valve stem.
- If applicable, insert replacement end plug into bore and secure sleeve and valve assembly and spring with OE retainer.



NOTE: In some instances, the sleeve may be slightly long (.010" to .020") for the bore, preventing the retainer from securing the parts properly. If this is the case, carefully flat sand the outboard face of the sleeve (at the recess area) until the sleeve is of proper length to fit in the bore.

5. Final Testing

Vacuum tests at the ports indicated hold the recommended minimum of 18 in-Hg.

