

Secondary Pressure Regulator Valve Kit

Part No.
15741-11K



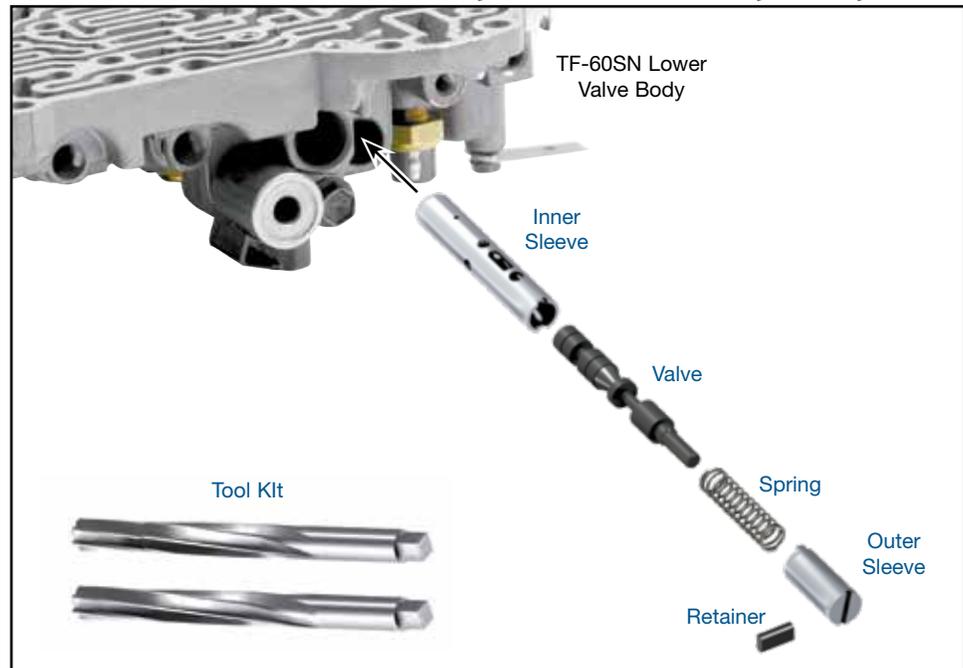
- Inner Sleeve
- Outer Sleeve
- Valve
- Spring
- Retainer

Tool Kit

Part No.
15741-TL11

- Reamers (2)

Aisin AW TF-60SN; Mini 6F21WA; VW/Audi 09G, 09K, 09M



1. Disassembly

Remove all components from the bore.

2. Bore & Reaming Preparation

- a. Clean the bore thoroughly in a solvent tank.
- b. Securely clamp the valve body to a bench or vise, making sure not to clamp directly over the bore to be reamed.

3. Reaming



CAUTIONS & SUGGESTIONS:

- The reaming action must be clockwise in a smooth and continuous motion.
 - Turning the reamer backward will dull it prematurely.
 - Pushing on the reamer results 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 this should only be done by a professional tool sharpener. Actual life of a Sonnax reamer before resharpening or replacing averages 50-70 bores.
- a. 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.

3. Reaming (continued)

- b. Gently insert Sonnax Reamer #1 (15741-RM11) into the bore until the cutting tip contacts the first bore to be reamed.
- c. Use a loose fitting reamer socket and a wobble adapter to ream the bore. The reamer can be turned by using a speed handle or with a low-RPM, high-torque air drill regulated to a maximum of 200 RPM. The reaming actions must be clockwise in smooth and continuous motion at 60-200 RPM. Continue reaming until the reamer stop is reached.
- d. Using low air pressure, blow the chips free before removing the reamer.
- e. To remove the reamer, turn clockwise while slowly pulling outward on the reamer.
- f. Gently insert Sonnax Reamer #2 (15741-RM12) into the bore until the cutting tip contacts the first bore to be reamed.
- g. Repeat steps 3c. through 3f.

4. Finish & Clean Up

- a. 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 embedded into the surface. Post cleaning involves several progressive steps with solvent on a lint-free rag.
- b. Clean the reamer after each use and store in its protective tube.

5. Installation & Assembly

- a. Ensure all debris has been removed from the valve bore and valve body.
- b. Insert Sonnax valve into Sonnax longer inner sleeve (**main photo**).
- c. Install Sonnax sleeve and valve assembly into bore, with undercut O.D. end entering bore first.
- d. Using a flathead screwdriver in outer slots, radially position inner sleeve so that the large cross slot is visible when looking into the line port in the casting.
- e. Install Sonnax spring over valve stem.
- f. Radially orient Sonnax outer sleeve so tangs will fit into outer slots of the inboard sleeve when installed, and retainer groove will be aligned with the retainer port in the casting.
- g. Insert Sonnax retainer into the retainer port, and secure with the OE solenoid plate.