

**Oversized Clutch Control Valve Kit**

**Part No.**  
**147741-22K**

- Oversized Clutch Control Valve
- Oversized End Plug



**Tool Kit**

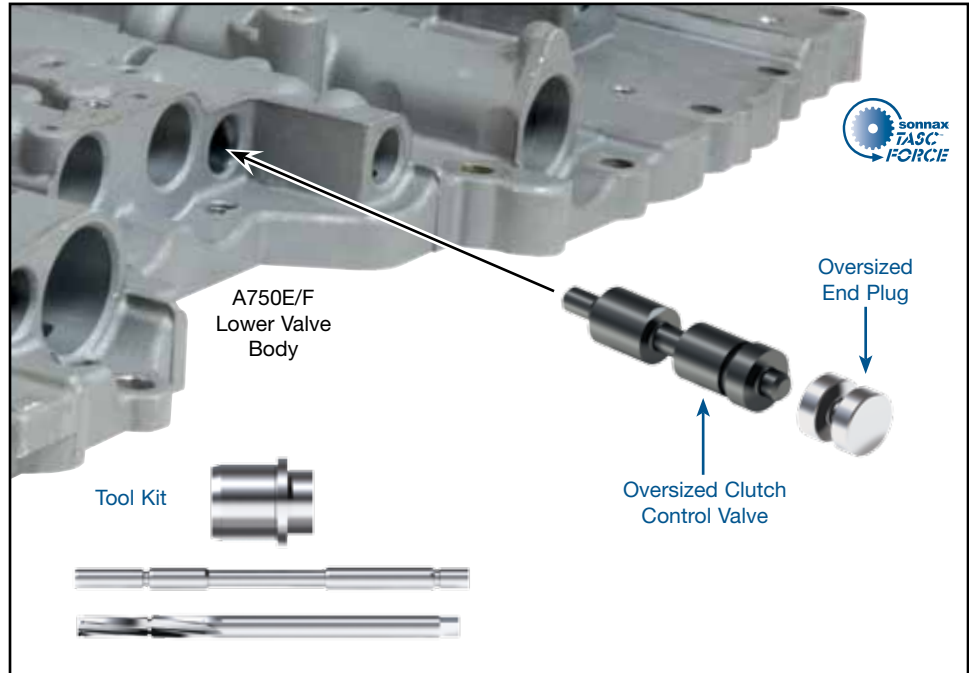
**Part No.**  
**F-147741-TL22**

- 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](http://www.sonnax.com).

**Toyota A750E/F**



**1. Disassembly**

Remove all OE components from the bore. Save the OE spring and retainer for reuse.

**2. Bore Preparation**

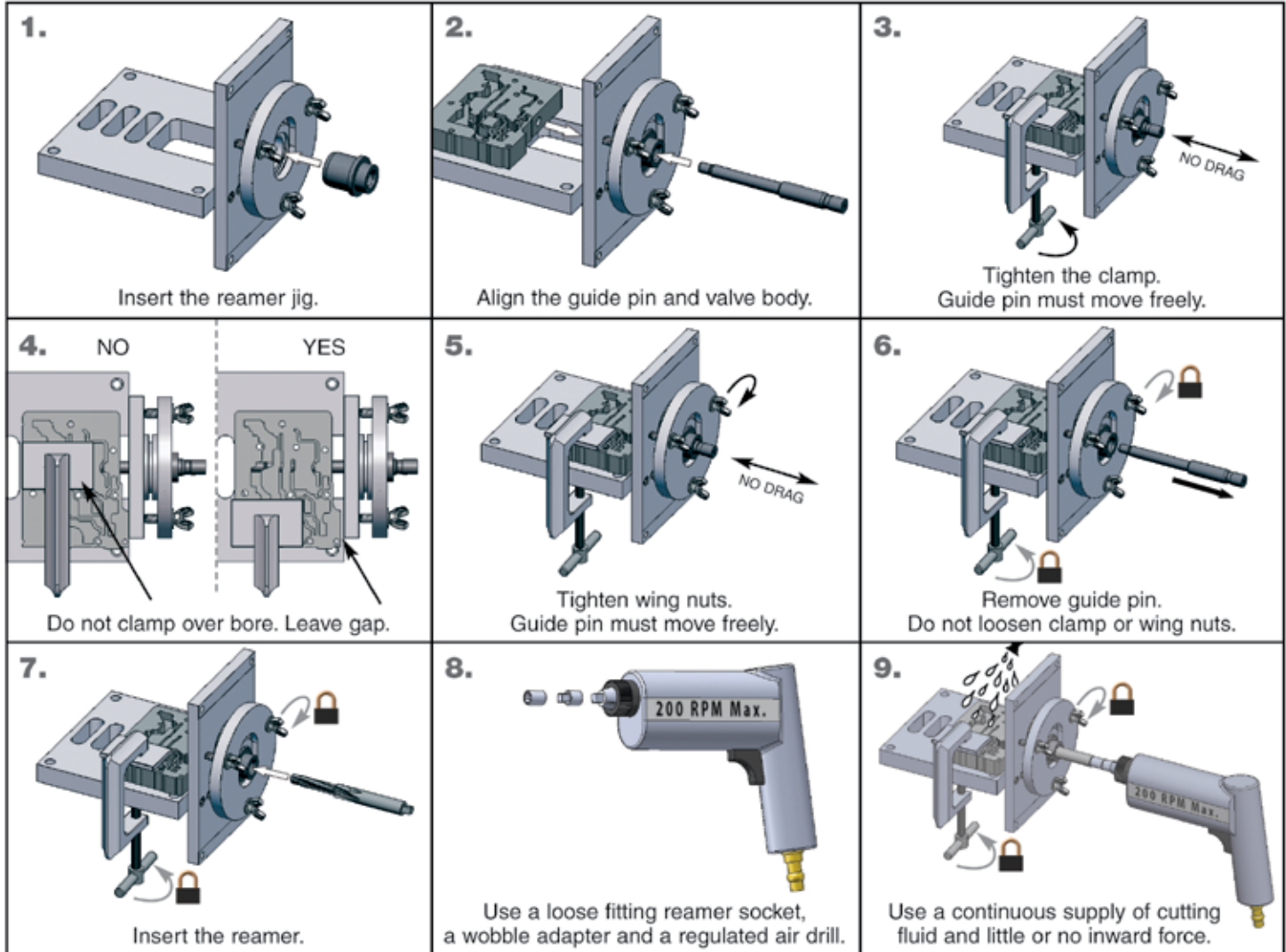
- Clean the bore thoroughly in a solvent tank.
- Generously lubricate the bore and reamer with cutting fluid (i.e. Mobilmet S-122, Lubegard<sup>®</sup> Bio-Tap, Tap Magic<sup>™</sup>, etc.). For best results, provide a continuous flow of water-soluble cutting fluid (i.e. Mobilmet S-122) during the reaming 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<sup>™</sup> material attached to a wire and powered with a drill motor is ideal for the task. Scotch-Brite<sup>™</sup> 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-147741-TL22 kit and VB-FIX reaming fixture as illustrated below to ream the bore.



### 4. Installation & Assembly

- Reinstall OE spring.
- Install Sonnax oversized clutch control valve and end plug.
- Reinstall the OE retainer.

### 5. Final Testing

Wet air test (WAT) or vacuum test at the feed ports indicated. If performing a WAT, no leakage should occur at the neighboring exhaust port. A vacuum test must hold a minimum vacuum reading as indicated.

