

VB-FIX Adapter Plate Kit



Part No.

F-15741-TL29PL

- Adapter Plate
- Screws (2) M5-0.8 x 12mm
- Screw M5-0.8 x 15mm
- Screw M5-0.8 x 25mm
- Washer (2) M5-10mm x 1mm

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.

F-15741-TL29PL is also required to install **15741-18K**, **15741-29K** and **59947-29K** in: Volvo (AM6), Opel (AF40), Peugeot (TF80), Saab (AF40/6), Land Rover (TF80).

Also Available

TF-80SC:

Lockup Clutch Control Valve Kit

15741-29K & Tool Kit F-15741-TL29

TF-60SN:

Solenoid Modulator Valve Kit

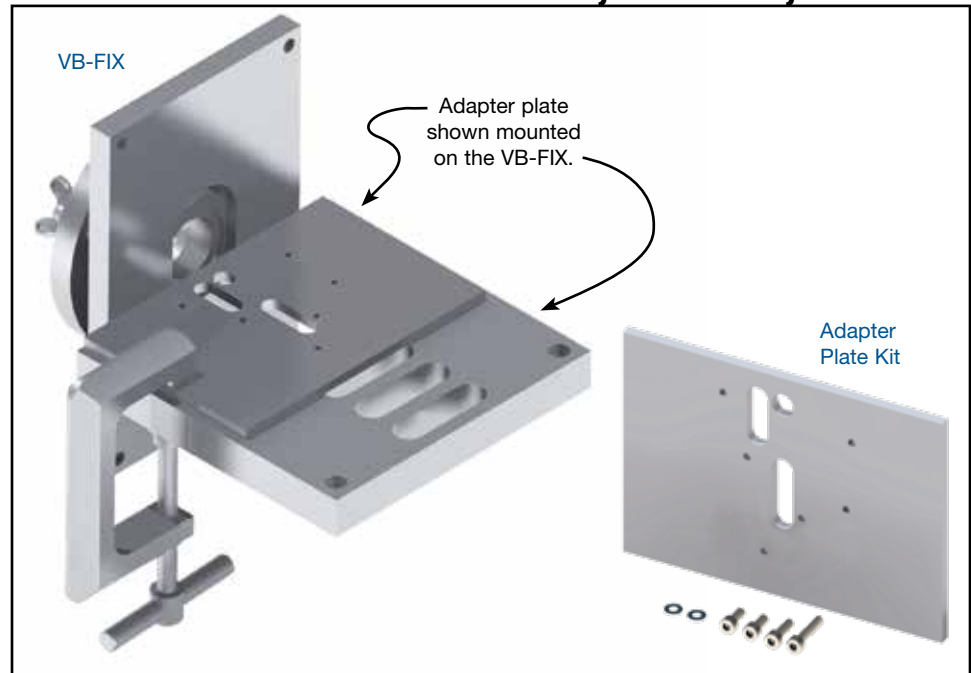
15741-18K & Tool Kit F-15741-TL18

55-50SN:

Oversized Lockup Control Valve & Boost Assembly Kit

59947-29K & Tool Kit F-59947-TL29

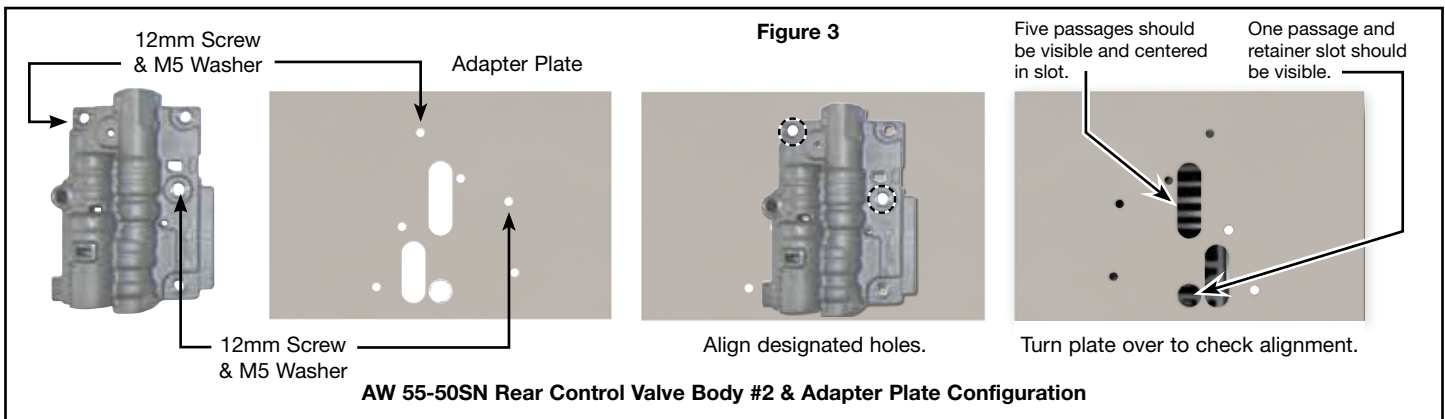
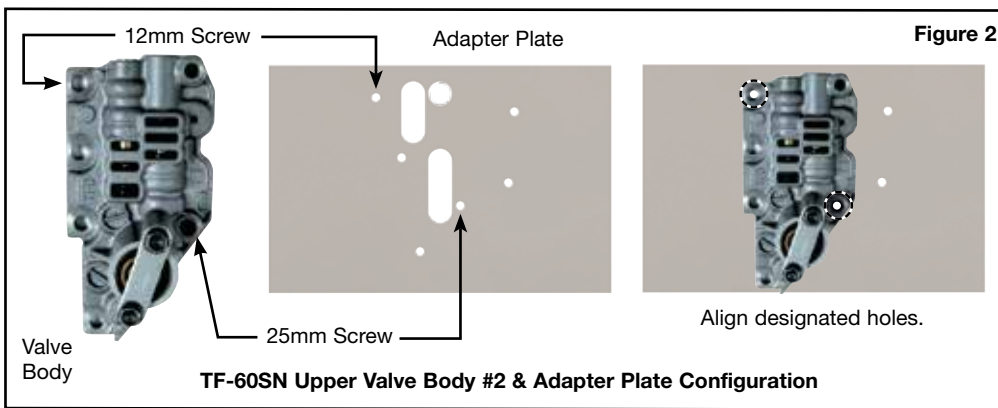
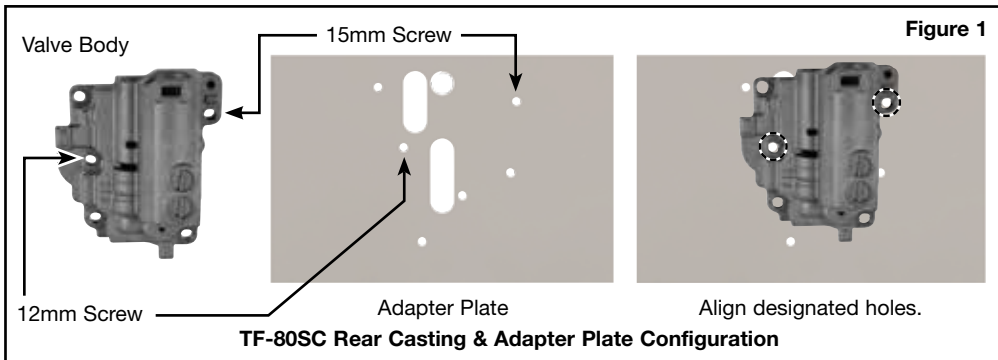
Aisin AW 55-50SN, TF-60SN, TF-80SC



NOTES & CAUTIONS: Adapter plate kit **F-15741-TL29PL** is required to help secure small valve bodies to the **VB-FIX**. If you do NOT have these six designated screw holes (see above) on your adapter plate, you have an early-style with four designated screw holes. This early-style adapter plate must be modified for the AW55-50SN application. Directions on how to do this are located on page 2.

Installation & Assembly

1. Mount valve body section to plate (**Figures 1-4**) using the required screws and washers as listed below:
 - **TF-80SC** uses one 12mm and one 15mm long screw.
 - **TF-60SN** uses one 12mm and one 25mm long screw.
 - **AW55-50SN** uses two 12mm long screws and two M5 washers.
2. When properly mounted, the bore centerline will be visible through the slot in the adapter plate.
3. Place adapter plate and valve body section onto the **VB-FIX**. Align and secure the valve body and adapter plate to the **VB-FIX** according to the **VB-FIX** instructions, using the guide pin and reamer jig from the **F-15741-TL29**, **F-15741-TL18** or **F-59947-TL29** tool kits.
4. Clamp adapter plate to **VB-FIX**. Do not clamp on the valve body.
5. Follow reaming, cleaning and assembly instructions included with each of the following repair kits: **F-15741-TL29**, **F-15741-TL18** or **F-59947-TL29**.



Early-Style Adapter Plate Modification

If you do not have an adapter plate with six screw holes, you have an early-style adapter plate. The early-style adapter plate must be modified in order to service the AW55-50SN rear control valve body #2. To begin, locate and mark two M5 tapped holes. You can do this two ways:

1. Use these dimensions to locate and mark two M5 tapped holes.
2. Position and clamp the AW55-50SN rear control valve body #2 on the adapter plate using the specified distances from the edges as shown. With a transfer punch, mark the two holes which need to be drilled and tapped. Turn adapter plate over to verify alignment (**Figure 3**). Unclamp and remove valve body.

Once these locations have been located, drill the holes through the adapter plate with a .165" drill and tap with an M5 x 0.8 tap.

