

Oversized Solenoid Modulator Valve Kit

Part No.
47740-25K



- Valve
- End Plug

NOTE: Fits U760E/F. For U660E/F use 47740-24K. See chart (Figure 1).

Tool Kit

Part No.
F-47740-TL24

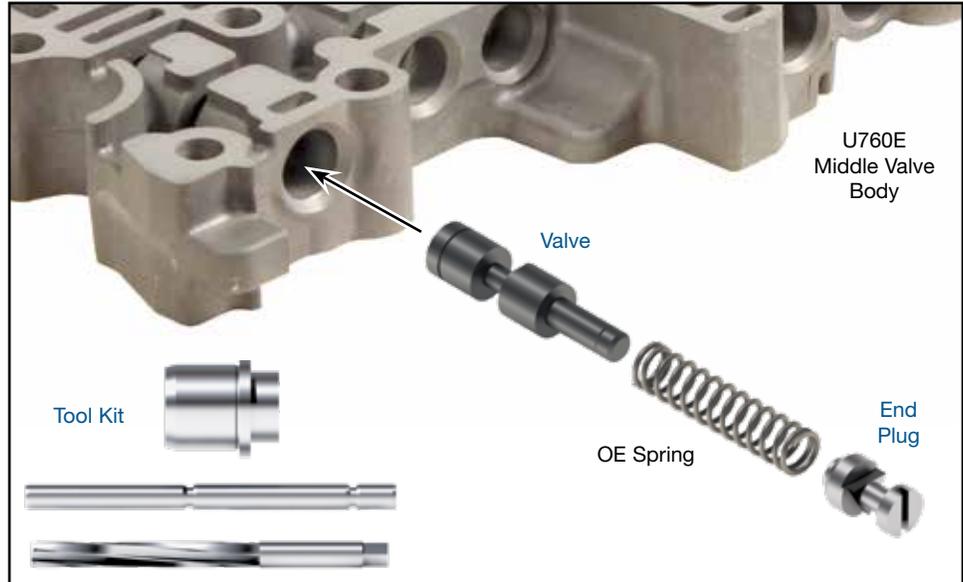


- Reamer
- Reamer Jig
- Guide Pin

NOTE: This tool kit can also be used to install oversized solenoid modulator valve kit 47740-24K.

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.

Toyota/Lexus U760E, U760F



CAUTION: If OE end plug is adjustable, note which setting the end plug is set to. This will be needed during installation of Sonnax valve and end plug.

1. Disassembly

- Note and record adjustable end plug setting position, if applicable, then remove OE lineup.
- Save OE spring and retainer for reuse.
- Discard OE valve and end plug.

2. Bore Reaming

Ream solenoid modulator bore (for reaming instructions/reamer care, please visit www.sonnax.com). Sonnax reaming tool kit F-47740-TL24 and VB-FIX are required for this operation.

3. Installation & Assembly

- Be certain all debris has been removed from the valve bore and valve body.
- Install Sonnax valve, stem facing outboard, followed by the OE spring.
- Install Sonnax end plug; be certain to match the noted setting of the OE end plug, if applicable. If the OE plug was non-adjustable, set the Sonnax end plug to the middle position.
- Reinstall OE retainer.

4. Final Testing

Vacuum testing at the port(s) indicated holds the recommended minimum 18 in-Hg (Figure 2).

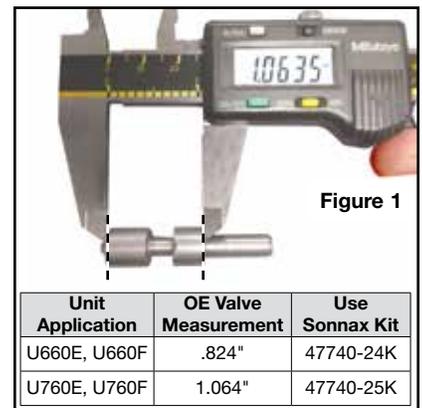
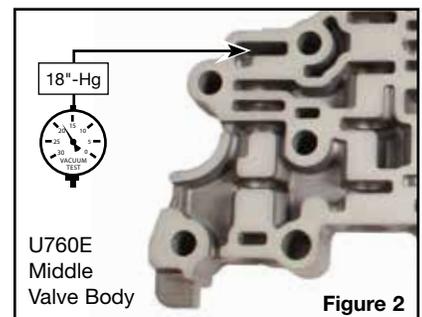


Figure 1

Unit Application	OE Valve Measurement	Use Sonnax Kit
U660E, U660F	.824"	47740-24K
U760E, U760F	1.064"	47740-25K



U760E Middle Valve Body

Figure 2