

## Oversized C2 Apply Control Valve Kit

**Part No.**  
**47740-63K**



- Valve
- Spring Orange-U660E/F
- Spring Green-U760E/F
- End Plug
- O-Rings (2) 1 Extra

## Tool Kit

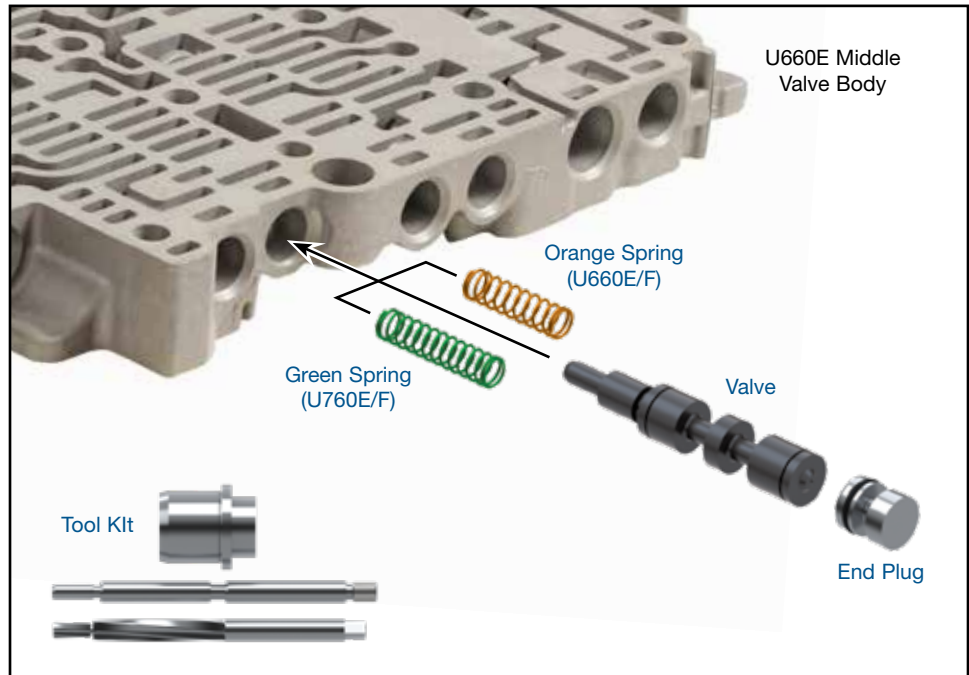
**Part No.**  
**F-47740-TL63**



- 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/Lexus U660E, U660F, U760E, U760F



### 1. Disassembly

- a. Remove OE retainer and save for reuse.
- b. Remove and discard OE C2 apply control valve, spring, and end plug.

### 2. Bore Reaming

Ream C2 apply control valve bore (for reaming instructions please visit [www.sonnax.com](http://www.sonnax.com)). Sonnax reaming tool kit **F-47740-TL63** and **VB-FIX** are required for this operation.

### 3. Installation & Assembly

- a. Be certain all debris has been removed from the valve bore and valve body.
- b. Install Sonnax selective spring (**Figure 1**) onto spring guide of Sonnax valve. Install into bore, spring side inboard.
- c. Install O-ring on Sonnax end plug and roll on a bench to size.
- d. Lubricate O-ring, and install the end plug with O-ring facing inward.
- e. Reinstall the OE retainer.

### 4. Final Testing

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

Figure 1

Application	Remove OE Spring	Replace with Sonnax Spring
U660E/F	Pink	Orange
U760E/F	Black	Green

