

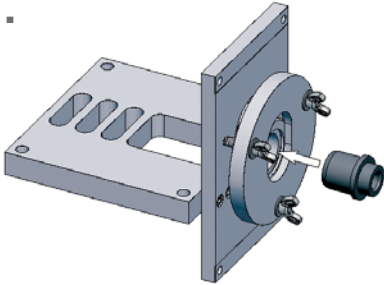
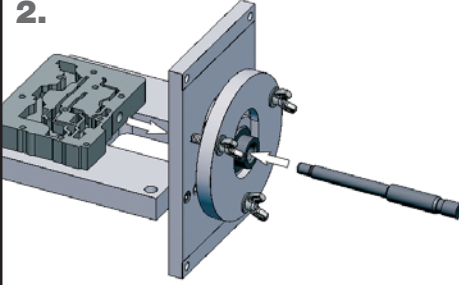
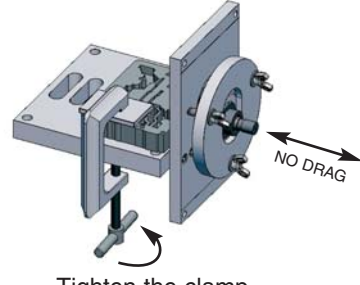
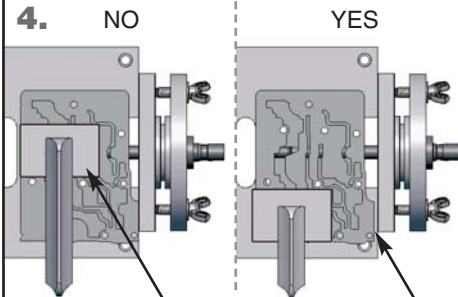
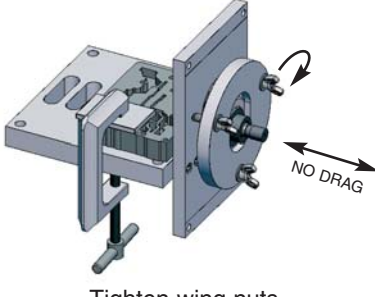
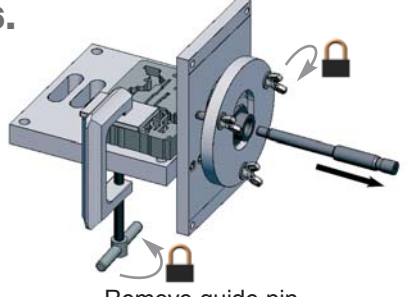
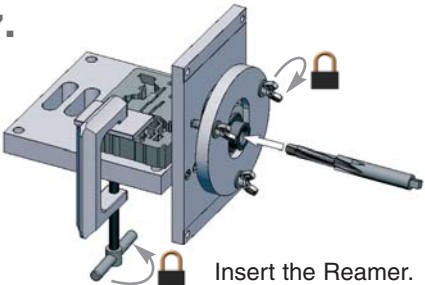
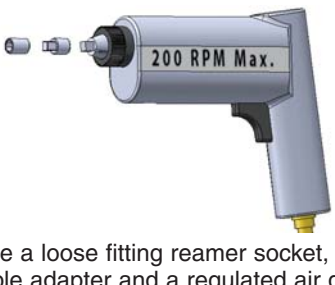
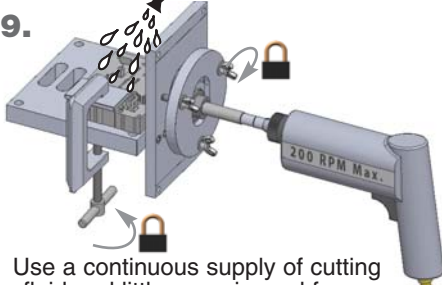


# TF-80/81SC, TF-60SN

PART NUMBERS 15741-29K, F-15741-TL29

**Lockup Clutch  
Control Valve Kit**

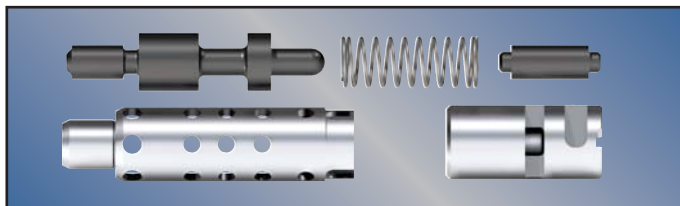
Reaming Instructions

<p><b>1.</b></p>  <p>Insert the reamer jig.</p>	<p><b>2.</b></p>  <p>Align the guide pin and valve body.</p>	<p><b>3.</b></p>  <p>Tighten the clamp. Guide pin must move freely.</p>
<p><b>4.</b> NO YES</p>  <p>Do not clamp over bore. Leave gap.</p>	<p><b>5.</b></p>  <p>Tighten wing nuts. Guide pin must move freely.</p>	<p><b>6.</b></p>  <p>Remove guide pin. Do not loosen Clamp or wing nuts.</p>
<p><b>7.</b></p>  <p>Insert the Reamer.</p>	<p><b>8.</b></p>  <p>Use a loose fitting reamer socket, a wobble adapter and a regulated air drill.</p>	<p><b>9.</b></p>  <p>Use a continuous supply of cutting fluid and little or no inward force.</p>

## Installation & Assembly Steps

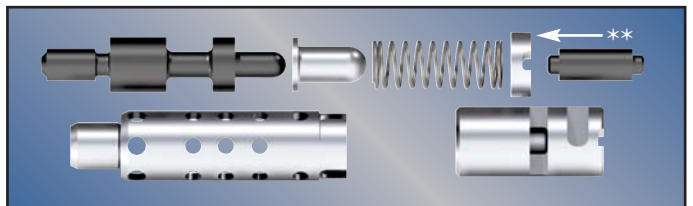
### For 2003-2004 TF-60SN only:

1. Insert the Sonnax Lockup Clutch Control valve and sleeve assembly into the reamed bore with the smaller OD in-board.
2. Insert the Sonnax spring.
3. Insert the Sonnax plunger valve/sleeve assembly into the reamed bore with the open end in-board.
4. Install the OE plunger sleeve retainer\*.



### For TF-80/81SC and 2005-Up TF-60SN:

1. Insert the Sonnax Lockup Clutch Control valve, cap & sleeve assembly into the reamed bore with the smaller sleeve OD in-board.
2. Insert the Sonnax spring.
3. Insert the Sonnax sleeve spacer into the reamed bore.
4. Insert the Sonnax plunger valve/sleeve assembly into the reamed bore with the open end in-board.
5. Install the OE plunger sleeve retainer\*.



\* If the stack-up of components does not allow the installation of the retainer, carefully remove the minimum necessary material from:

**'03-'04 TF-60SN Only:** The open or inboard end of the plunger sleeve. Be sure to remove any burrs that may interfere with plunger valve movement.

**TF-80/81SC & '05-Up TF-60SN :** File the castelated side\*\* of the sleeve spacer. Remove burrs.