

**Aisin AW TF-60SN, TF-80SC, TF-81SC, TR-60SN;
Mini 6F21WA; VW/Audi 09D, 09G, 09K, 09M**

**O-Ringed
End Plug Kit**

Part No.
15741-36K

- Large End Plugs (5) 11mm
- Large O-Rings (7) 2 Extra

NOTE: Fits Volvo (AM6), Opel (AF40), Peugeot (TF80), Saab (AF40/6), Land Rover (TF80), Ford (AF21), Mazda (AW6A-EL).

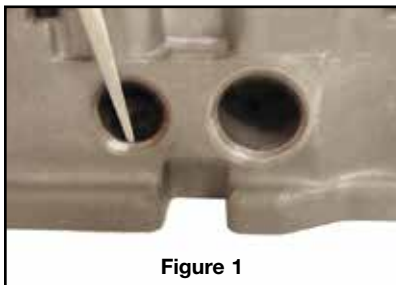


Figure 1

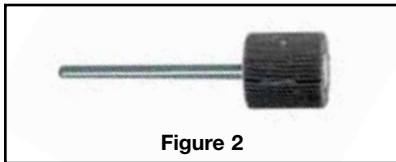


Figure 2

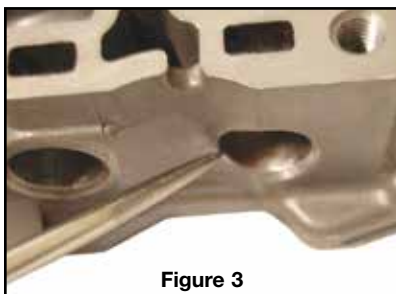


Figure 3

1. Disassembly

- a. Remove and discard the OE end plugs.
- b. Keep the OE plug retainer for reuse.

2. Preparation

- a. Inspect the bore entry surface for a ridge just inboard of the end or chamfer. The ridge is difficult to see with the naked eye, but can be felt by carefully dragging a sharp pick out the bore and down the chamfer (**Figure 1**).
- b. Ridges must be removed. Use a 3/8" diameter flap wheel (**Figure 2**) chucked in a miniature die grinder to smooth the transition from the chamfer into the bore.
- c. Use deburring tool or bearing scraper to complete the .020" to .030" wide chamfer all the way around the bore edge where the valve body contour may have caused the factory chamfer to be less than a full circle (**Figure 3**).
- d. Thoroughly clean valve body prior to assembly.

3. Installation & Assembly

- a. Install appropriate valve train into the valve body bore.
- b. Install Sonnax O-ring into shallow groove on Sonnax end plug (see above).
- c. Use small amount of of Transgel, Sonnax Slippery Stick™ O-LUBE or new ATF/STP mix to lubricate O-ring, end plug and valve body chamfer.
- d. Start placing end plug into bore (O-ring outboard). In all bores, the O-ring seals on the first land just inside the bore opening.
 - Use a small flat bladed screwdriver inserted through retainer post cavity to control movement of end plug as O-ring compresses into bore.
 - Do not allow O-ring to travel beyond first segment of bore, as O-ring will be destroyed by the sharp edges of intersecting retaining post cavity.
 - Using a brass or wood drift, carefully press end plug into bore, working in slow, incremental steps which will allow O-ring to enter and advance into contour without damage.
- e. Install OE retainer.