

O-Ringed End Plug Kit

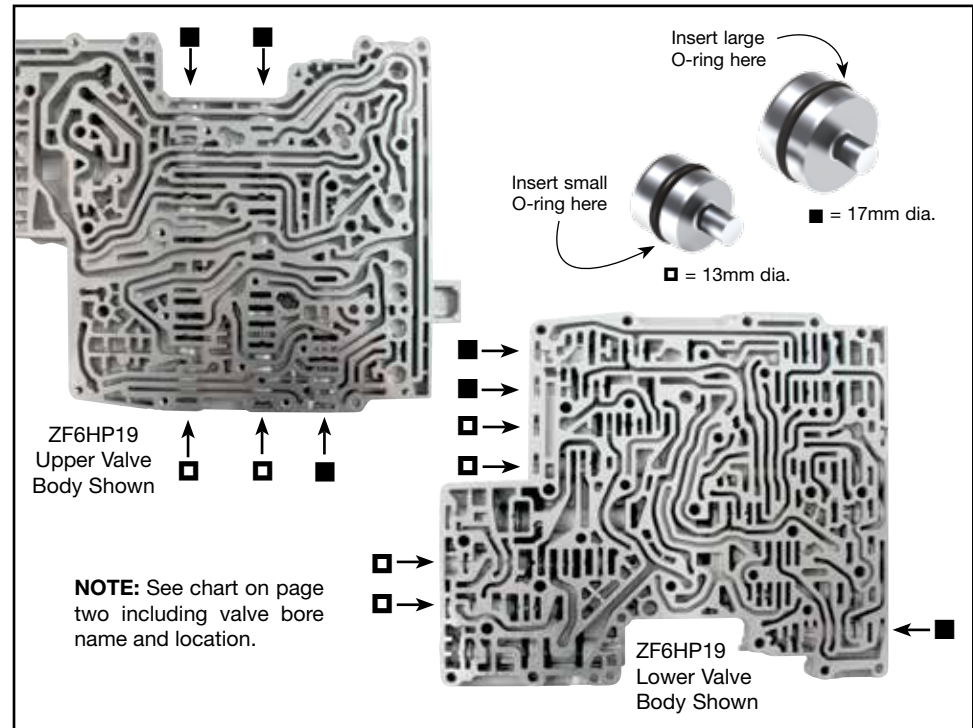
Part No.

95740-19K

- Large End Plugs (6) 17mm Dia.
- Large O-Rings (9)
- Small End Plugs (6) 13mm Dia.
- Small O-Rings (9)

NOTE: Kit is NOT compatible with ZF6HP21/28/34 (Gen. 2) units. To differentiate between Generation 1 and Generation 2 valve bodies, refer to ZF Identification Guide at www.sonnax.com.

Ford 6R60, 6R75, 6R80; ZF6HP19, ZF6HP26, ZF6HP32



1. Preparation

- a. Thoroughly clean valve body before and after disassembly as dirt and debris can damage the bore surface finish when extracting solenoids, end plugs and valves.
- b. Any sharp edge at the bore entrance or at the second wall should be dressed or chamfered to reduce the possibility of O-ring damage during end plug installation.

2. Disassembly

- a. Remove the OE end plug retaining clip and set aside for reuse.
- b. Remove and discard the OE end plug.

3. Installation & Assembly

- a. Install the Sonnax O-rings into the shallow grooves of Sonnax end plugs (**main image**).
- b. Lubricate the mounted O-rings, end plugs and bores with a small amount of Transgel, Sonnax Slippery Stick **O-LUBE**, or new ATF/STP.
- c. Install the appropriate valve train into the selected bore.
- d. Insert the end plug with the O-ringed spool inboard. The O-ring will seal on the second wall. The second wall is just inboard of the cavity that receives the end plug retaining pin.

NOTE: Ease the end plugs into position. If the O-ring(s) resists entering the bore with direct applied pressure, alternately push and release the pressure on the end plug to allow the flexible O-ring material to squirm into place. When releasing the pressure, only allow the end plug to move outboard the slightest distance.

- e. If the O-ring is damaged during the installation, remove the end plug and mount one of the extra O-rings included in the kit.

O-Ringed End Plug Location Key			
Sonnax Kit	Valve	Location	End Plug Dia.
95740-19K	Clutch A Control Pressure Regulator	Lower Valve Body	17mm (.669")
	Clutch E Control Pressure Regulator		17mm (.669")
	Clutch E Latch		13mm (.512")
	Bypass Clutch Control Regulator		13mm (.512")
	Converter Release Regulator		13mm (.512")
	Lubrication Control		13mm (.512")
	Delay Accumulator		17mm (.669")
	Clutch D1 Control Pressure Regulator	Upper Valve Body	17mm (.669")
	Clutch C Regulator		17mm (.669")
	Clutch D2 Latch		13mm (.512")
	Clutch D2 Regulator		13mm (.512")
	Clutch B Regulator		17mm (.669")