

## O-Ringed End Plug Kit

Part No.

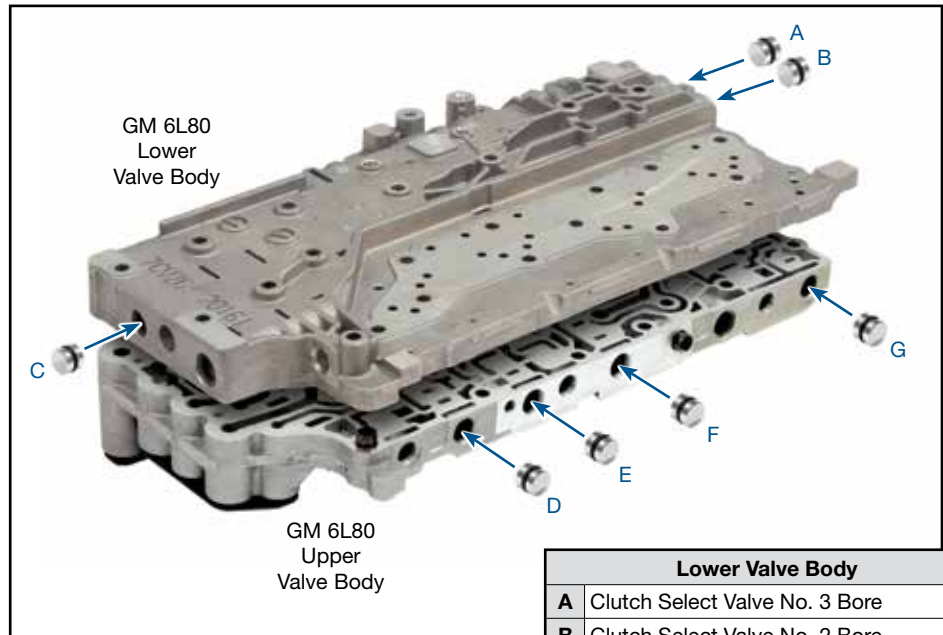
**104740-23K**

• End Plugs (7)

• O-Rings (9)

2 Extra

## GM 6L45, 6L50, 6L80, 6L90



Lower Valve Body	
<b>A</b>	Clutch Select Valve No. 3 Bore
<b>B</b>	Clutch Select Valve No. 2 Bore
<b>C</b>	TCC Regulator Apply Valve Bore
Upper Valve Body	
<b>D</b>	1-2-3-4 Clutch Regulator Valve Bore
<b>E</b>	3-5 Reverse Clutch Regulator Valve Bore
<b>F</b>	2-6 Clutch Regulator Valve Bore
<b>G</b>	CBR1/C456 Clutch Regulator Valve Bore

### 1. Dissassembly

- Remove OE plug retainers and keep for reuse.
- Remove and discard OE end plugs.

### 2. Installation & Assembly

- Install Sonnax O-ring in shallow groove on Sonnax end plug. Then lubricate with Sonnax Slippery Stick **O-LUBE** and roll on bench to size the O-ring in the groove.
- Carefully insert Sonnax O-ringed end plug into the bore just far enough to reinstall the OE retainer.

**NOTE:** A small, flat-bladed screwdriver inserted through the retainer port cavity may be used to help compress the O-ring into the bore.

### 3. Final Testing

Vacuum tests at the ports indicated hold the recommended minimum of 18 in-Hg.

