

## O-Ringed End Plug Kit

### Part No.

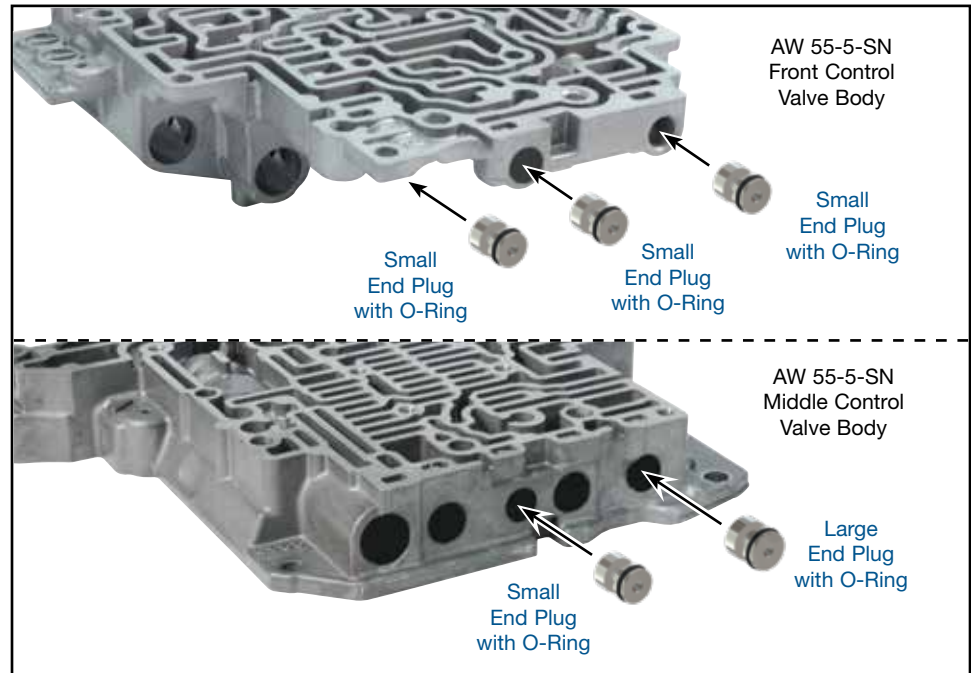
# 59947-21K

- End Plugs, Small (4) 9mm
- End Plug, Large 11mm
- O-Rings, Small (6) 2 Extra
- O-Rings, Large (2) 1 Extra

**NOTE:** Also fits AF23/33 & RE5F22A units.

**NOTE:** See chart on page 2 for valve body locations.

## Aisin AW 55-51SN, 55-50SN



### 1. Disassembly

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

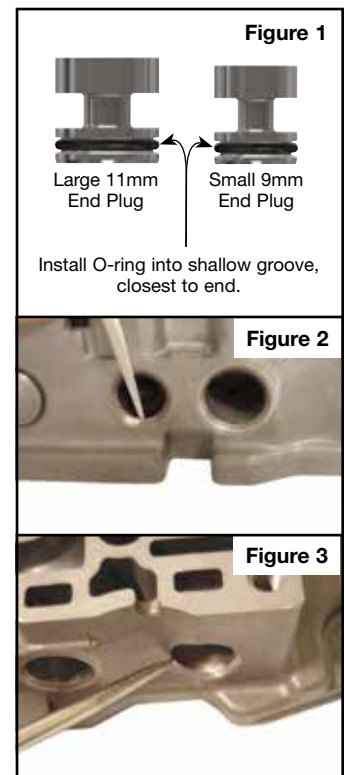
### 2. Install Preparation

- a. Install Sonnax O-rings into the shallow grooves on Sonnax end plugs (**Figure 1**).
- b. Inspect the bottom of the "cast-in" chamfer at each bore that will receive a Sonnax O-ringed end plug. Most valve bodies will have a small ridge at the entry of the valve bore. The ridge is difficult to see with the naked eye but can be located by carefully dragging a sharp "pick" down the chamfer (**Figure 2**).
- c. The recommended way to remove these ridges is with a 3/8" diameter flap wheel chucked in a miniature die grinder. However, any method that removes the ridge without damaging the bore is acceptable. Once removed, smooth the transition from chamfer into the bore.



**NOTE:** If ridge is not eliminated, it will destroy the O-ring.

- d. In the case of the 3rd Gear band (B4) release valve, it is necessary to form a small chamfer (approx. .020-.030" deep) along the contoured edge of the valve bore (**Figure 3**).
- e. Thoroughly clean the valve body prior to assembly.



### 3. Installation & Assembly

- a. Install the appropriate valve train into the valve body bore.
- b. Use a small amount of O-Lube lubricant on the O-ringed end plug and valve body chamfer.
- c. Start the end plug into bore with the 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 the retainer post cavity, to control the movement of the end plug as the O-ring compresses into the bore.
  - Do not allow the O-ring to travel beyond the first segment of the bore, as the O-ring will be destroyed by the sharp edges of the intersecting retaining post cavity.
  - Use a brass or wood drift to press the end plug into the bore. Use a hammer on the back of the drift and tap repeatedly to ease the O-ring into the bore. Do not seat the end plug with one mighty whack or damage will occur to the O-ring.
- d. Reinstall OE retainer.

### O-Ringed End Plugs for AW 55-50SN & 55-51SN

Valve Location	Valve Body Section	End Plug Dia.
Forward Clutch Control	Front Control Valve Body	9mm Small
2nd Coast Clutch Control	Front Control Valve Body	9mm Small
Neutral Relay	Front Control Valve Body	9mm Small
M1 Shift	Middle Control Valve Body	9mm Small
3rd Gear Band Release	Middle Control Valve Body	11mm Large