

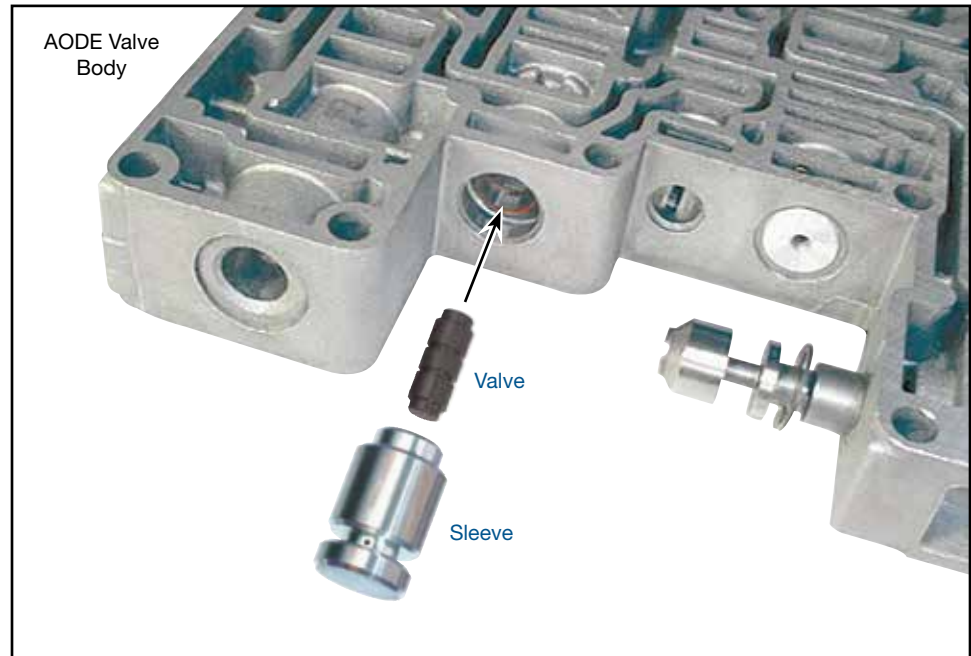
Bypass Clutch Control Plunger Valve Kit

Part No.

76948-04K

- Sleeve
- Valve

Ford 4R70E, 4R70W, 4R75E, 4R75W, AODE

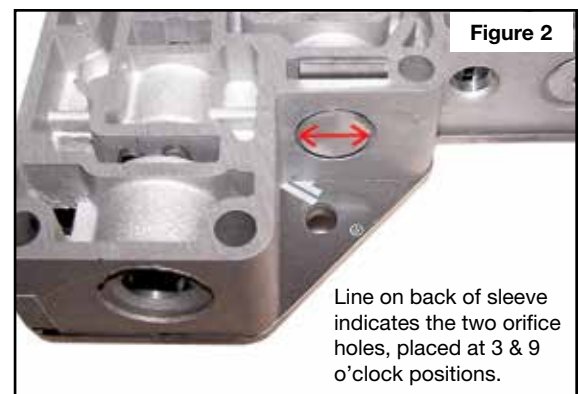
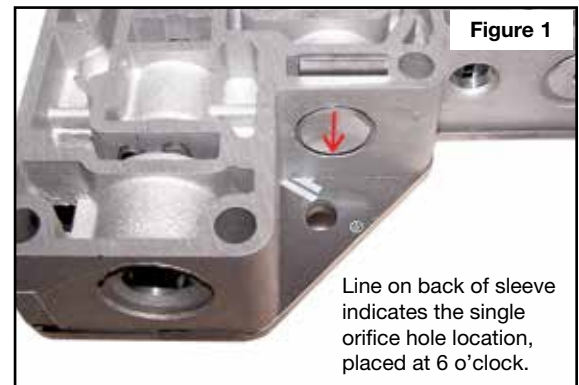


1. Disassembly

- Remove OE retainer and set aside for reuse.
- Remove OE bypass clutch control sleeve and plunger valve from valve body and discard.

2. Installation & Assembly

- Prepare Sonnax valve and sleeve as directed below:
 - **1995–Earlier:** For firmer quicker TCC apply, install Sonnax sleeve as is. For OE TCC apply feel, perform sleeve modification in step 3.
 - **1996–Later:** To prevent harsh TCC apply or engine lugging, drill through existing Sonnax sleeve orifice hole and out through the other side of the sleeve using a 1/16" drill bit.
- Install Sonnax valve and sleeve, securing with OE retaining clip, ensuring not to block sleeve orifice hole.
- Use a Sharpie® pen on the back of Sonnax sleeve and align the arrow head with the single orifice hole and place at 6 o'clock (**Figure 1**).
- If the modification in step 3 will be done, draw a line on the back of the sleeve indicating the two orifice hole locations and place sleeve at 3 and 9 o'clock positions (**Figure 2**).



3. Separator Plate Modifications

- Ensure bypass/TCC system has full control by drilling holes marked "A" and "B" to .062". Note that orifice "B" may already be enlarged in some applications (**Figure 3**).
- No need to alter hole marked "C" as Sonnax sleeve corrects improper orifice size (**Figure 3**).

4. Final Testing

Vacuum testing at the port(s) indicated holds the recommended minimum 18 in-Hg (**Figure 4**).

