

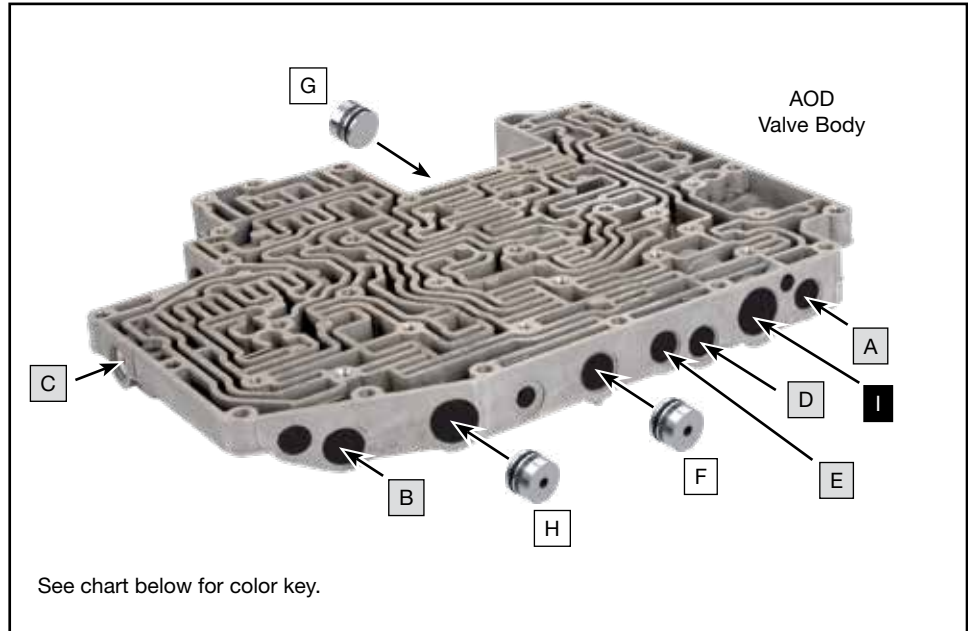
O-Ringed End Plug Kit

Part No.

76999-MED

- End Plugs (3) Medium
- O-Rings (6) 3 Extra

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



AOD Valve Body - End Plug Usage Chart

ID	Bore Location	End Plug Size
A	1-2 Capacity Modulator	Small O-Ringed End Plug
B	Orifice Control	
C	2-3 Back-out (optional)	
D	3-4 Shuttle (optional)	
E	OD Servo Regulator	
F	1-2 Shift	Medium O-Ringed End Plug
G	2-3 Shift	
H	3-4 Shift*	
I	1-2 Accumulator	Large O-Ringed End Plug

*NOTE: For mid '83-later unit applications use valve and sleeve included in Sonnax kit 76999-05K in this location.

1. Wet Air Test Verification Before and/or After Installation

Each plug can be individually tested in its bore when isolated with a rag or plate. The most effective method is with the valve body assembled to the case, then wet air tested through the output shaft governor feed holes. There is always minimal leakage across the shaft sealing rings. There should be no cross-leakage between the governor and direct clutch circuits.

2. Disassembly

- a. If OE valve is not going to be removed, hold/wedge valve inward with small flat blade screwdriver to keep the valve in place.
- b. Remove OE retaining clip and save for reuse.
- c. Remove OE end plug from the valve body and discard.

3. Assembly

- a. Install Sonnax O-ring into outer groove of Sonnax end plug and lubricate.
- b. With threaded hole facing out, rotate the end plug during installation and push into valve body bore just enough to replace the OE retaining clip.



NOTE: The 8-32 UNC threaded hole may be used to assist in end plug installation and removal.