

## Oversized Clutch D1/E Control Valve Kit

Part No.

**95740-08K**



- Valve
- End Plug
- O-Ring

**NOTE:** Valve can be used in either location.

**NOTE:** Kit is NOT compatible with ZF6HP19/26/32 (Gen.1) units with an 053 separator plate.

**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](http://www.sonnax.com).

## Tool Kit

Part No.

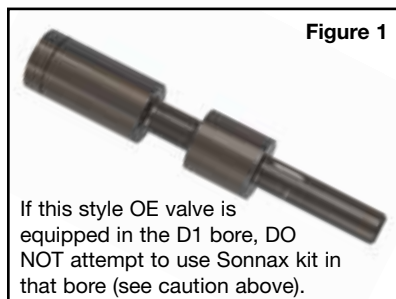
**F-95740-TL8**



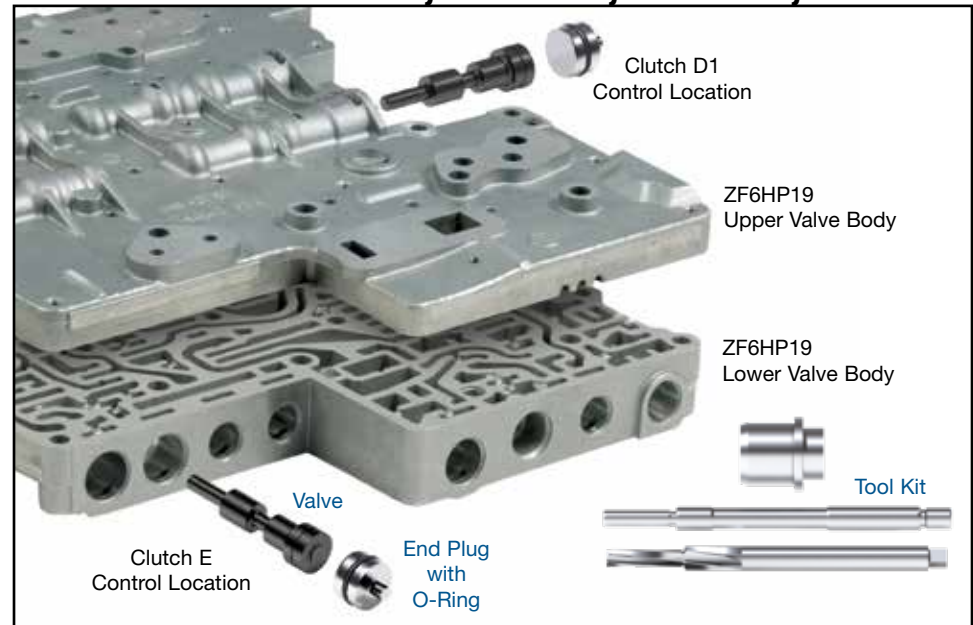
- Reamer
- Reamer Jig
- Guide Pin

**NOTE:** Sonnax "F-Tool" kits designed to service a specific bore require the VB-FIX, a self-aligning valve body reaming fixture. More information and instructions can be found online at [www.sonnax.com](http://www.sonnax.com).

**F-95740-TL8:** can also be used to install Sonnax oversized clutch A control valve kit **95740-09K**.



## Ford 6R60, 6R75, 6R80 (2009-2014), 6R80 (2015-Later), 6R100; ZF6HP19, ZF6HP26, ZF6HP32



**CAUTION:** Sonnax kit is NOT compatible with '12-later 6R80 applications that contain an OE "D1" valve with two equal diameter spools (**Figure 1**). Valve bodies with separator plate AL3P-7Z490-BA contain this incompatible OE valve. Note, however, this Sonnax kit can still be used in "E" bore for these applications.

### 1. Disassembly

- Remove OE retaining clip and save for reuse.
- Remove and discard OE end plug and clutch control valve.
- Remove and save OE spring for reuse (where applicable).

### 2. Bore Reaming

Ream clutch D1 and/or clutch E control bore (for reaming instructions/reamer care, please visit [www.sonnax.com](http://www.sonnax.com)). Sonnax reaming tool kit **F-95740-TL8** and **VB-FIX** are required for this operation.

### 3. Installation & Assembly

- Ensure all debris has been removed from valve bore(s) and valve body.
- Reinstall OE spring, followed by Sonnax valve, ensuring the spring I.D. seats over the valve nub.
- Lubricate O-ring and install on Sonnax end plug. Roll on clean flat surface to size O-ring into groove.
- Install end plug with nub facing outward, then secure with OE retainer.

### 4. Final Testing

Vacuum testing at the port(s) indicated holds the recommended minimum 12 and 18 in-Hg (**Figures 2 & 3**).

