

Ford 6R60, 6R75, 6R80, 6R80 (2009-2014), 6R80 (2015-Later), 6R100; ZF6HP19/26/32 (Gen. 1)

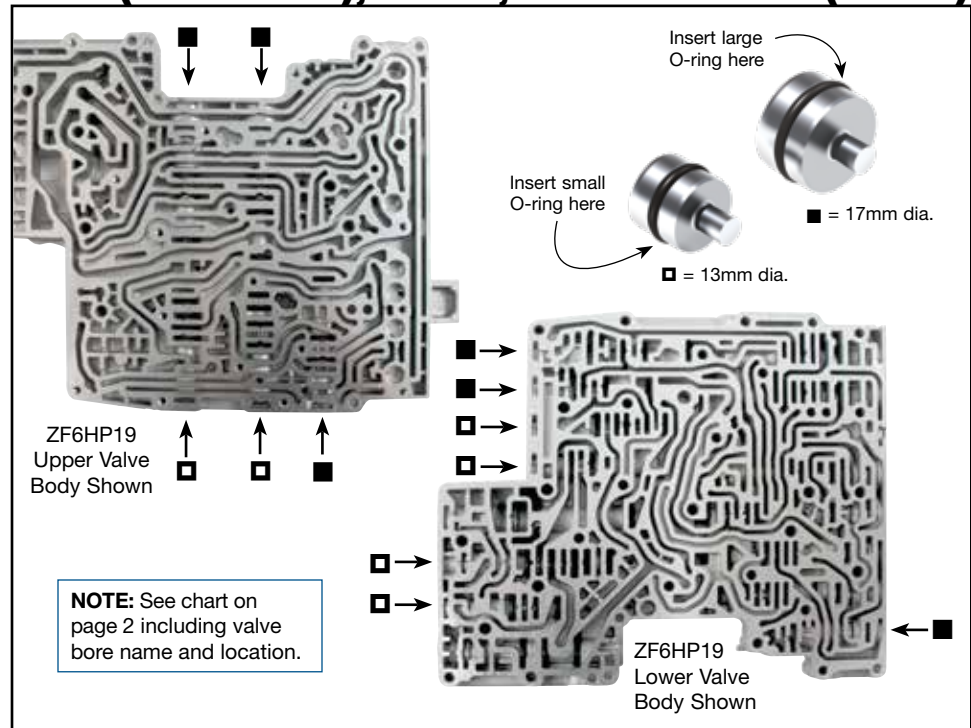
O-Ringed End Plug Kit

Part No.

95740-19K

- End Plugs, Large (6) 17mm dia.
- O-Rings, Large (9) 3 Extra
- End Plugs, Small (6) 13mm dia.
- O-Rings, Small (9) 3 Extra

NOTE: Fits ZF6HP19/26/32 (Gen. 1) units without 053 separator plate code. 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.



NOTE: See chart on page 2 including valve bore name and location.

1. Preparation

- Thoroughly clean valve body before and after disassembly as dirt and debris can damage the bore surface finish when extracting solenoids, end plugs and valves.
- Any sharp edge at the bore entrance or at the second wall should be dressed or chamfered to reduce the possibility of O-ring damage during end plug installation.

2. Disassembly

- Remove the OE end plug retaining clip and set aside for reuse.
- Remove and discard the OE end plug.

3. Installation & Assembly

- Install the Sonnax O-rings into the shallow grooves of Sonnax end plugs (**main image**).
- Lubricate the mounted O-rings, end plugs and bores with a small amount of Transgel, Sonnax Slippery Stick **O-LUBE**, or new ATF/STP.
- Install the appropriate valve train into the selected bore.
- Insert the end plug with the O-ringed spool inboard. The O-ring will seal on the second wall. The second wall is just inboard of the cavity that receives the end plug retaining pin.

NOTE: Ease the end plugs into position. If the O-ring(s) resists entering the bore with direct applied pressure, alternately push and release the pressure on the end plug to allow the flexible O-ring material to work into place. When releasing the pressure, only allow the end plug to move outboard the slightest distance.

- If the O-ring is damaged during the installation, remove the end plug and mount one of the extra O-rings included in the kit.

O-Ringed End Plug Location Key			
Sonnax Kit	Valve	Location	End Plug Dia.
95740-19K	Clutch A Control Pressure Regulator	Lower Valve Body	17mm
	Clutch E Control Pressure Regulator		17mm
	Clutch E Latch		13mm
	Bypass Clutch Control Regulator		13mm
	Converter Release Regulator		13mm
	Lubrication Control		13mm
	Delay Accumulator		17mm
	Clutch D1 Control Pressure Regulator	Upper Valve Body	17mm
	Clutch C Regulator		17mm
	Clutch D2 Latch		13mm
	Clutch D2 Regulator		13mm
	Clutch B Regulator		17mm