sonnax
TRANSMISSION PARTS

ZF6HP21/28/34 (Gen. 2)

O-Ringed End Plug Kit

Part No.
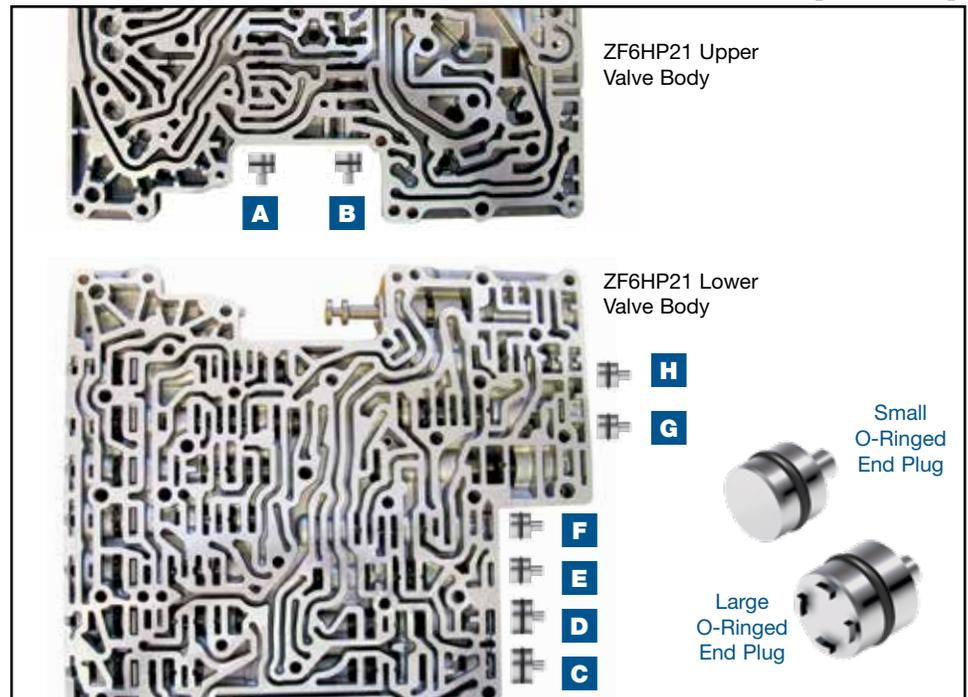## 95740-27K

- Large End Plugs (2)   15mm
- Large O-Rings (4)   2 Extra
- Small End Plugs (6)   13mm
- Small O-Rings (9)   3 Extra

NOTE: Kit is not compatible with ZF6HP19/26/32 (Gen. 1) units. To differentiate between Gen. 1 and Gen. 2 valve bodies, refer to ZF Identification Guide at www.sonnax.com.

Figure 1

ZF6HP21 Upper Valve Body

ZF6HP21 Lower Valve Body

Small O-Ringed End Plug

Large O-Ringed End Plug

ID	Valve Location	Dia.
Upper Valve Body		
A	Clutch D1 Brake Regulator	13mm
B	M-Shift = Shift Valve 3 E-Shift = Position Valve	13mm
Lower Valve Body		
C	Clutch A Control Pressure Regulator	15mm
D	Clutch E Control Pressure Regulator	15mm
E	Clutch Cooling	13mm
F	Bypass Clutch Control Regulator	13mm
G	Converter Release Regulator	13mm
H	Lubrication Control	13mm

Figure 2

ZF6HP21 Upper Valve Body

ZF6HP21 Lower Valve Body

16"-Hg

16"-Hg

1. Preparation

a. 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.

b. 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

a. When applicable, remove the solenoid retaining clip and solenoid.

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

c. Remove and discard the OE end plug.

3. Intallation & Assembly

a. Install Sonnax O-rings into the shallow groove on Sonnax end plugs. The 13mm end plugs use the smaller O-rings and the 15mm end plugs use the larger O-rings.

b. Lubricate the mounted O-rings, end plugs and bores with a small amount of TransJel™, Sonnax Slippery Stick **O-LUBE**, or new ATF/STP. Roll the O-ringed end plug on the bench to size O-ring into groove.

c. Install each end plug into appropriate bore (**Figure 1**).

4. Final Testing

Vacuum testing at the port(s) indicated holds the recommended minimum 16 in-Hg (**Figure 2**).

NOTE: Port configurations may change due to variations of casting channels between M and E shift, as well as make and model. The location that needs checking will be the first port inboard of the end plug.