

## O-Ringed Internal End Plug Kit

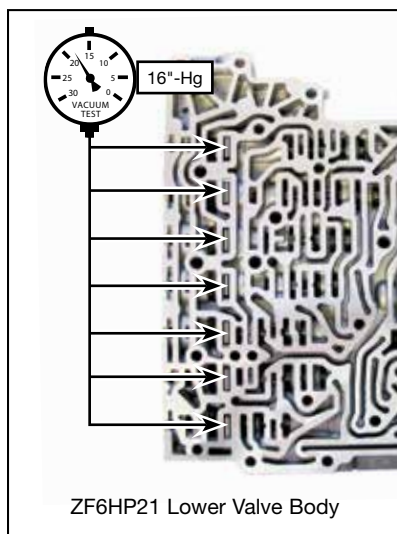
### Part No.

# 95740-30K

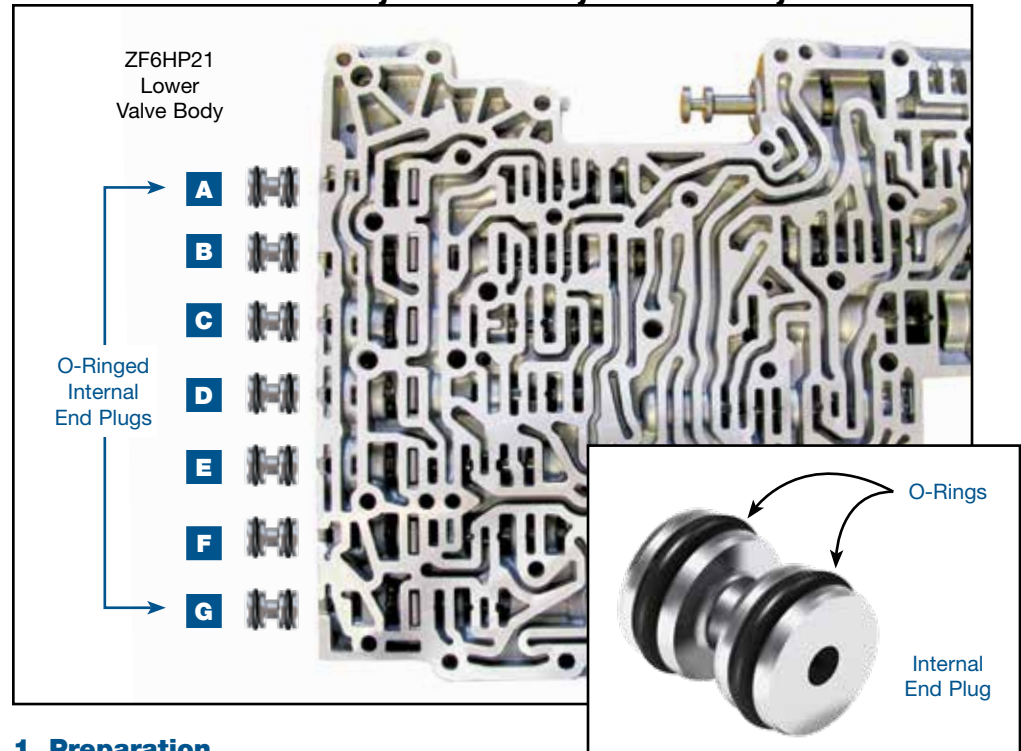
- End Plugs (7) 12mm
- O-Rings (20) 6 Extra

**NOTE:** Kit is compatible with all ZF6HP21/28/34 (Gen. 2) units, and only ZF6HP19/26/32 (Gen. 1) units with an 053 separator plate code. To differentiate between Generation 1 and Generation 2 valve bodies, refer to ZF Identification Guide at [www.sonnax.com](http://www.sonnax.com).

ID	Valve Location	Dia.
<b>Lower Valve Body</b>		
A	Solenoid Pressure Regulator	12mm
B	Clutch D1 Latch	12mm
C	Drive Enable	12mm
D	Solenoid Multiplex	12mm
E	Clutch C Latch Valve	12mm
F	Clutch B Latch Valve	12mm
G	Clutch A Latch Valve	12mm



## ZF6HP19, ZF6HP21, ZF6HP26, ZF6HP28, ZF6HP32, ZF6HP34



### 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

- When applicable, remove the solenoid retaining clip and solenoid.
- Remove the OE end plug retaining clip and set aside for reuse.
- Remove and discard the OE end plug.

### 3. Installation & Assembly

- Install two of the Sonnax O-rings into the shallow grooves on each of the Sonnax end plugs.
- 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.
- Install the appropriate valve train into the selected bore.
- Insert the internal end plug with the hole facing outboard.

### 4. Final Testing

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

**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 port with the retaining clip.