

Ford 4R70E, 4R70W, 4R75E, 4R75W

Valve Body Retainer Plate Kit

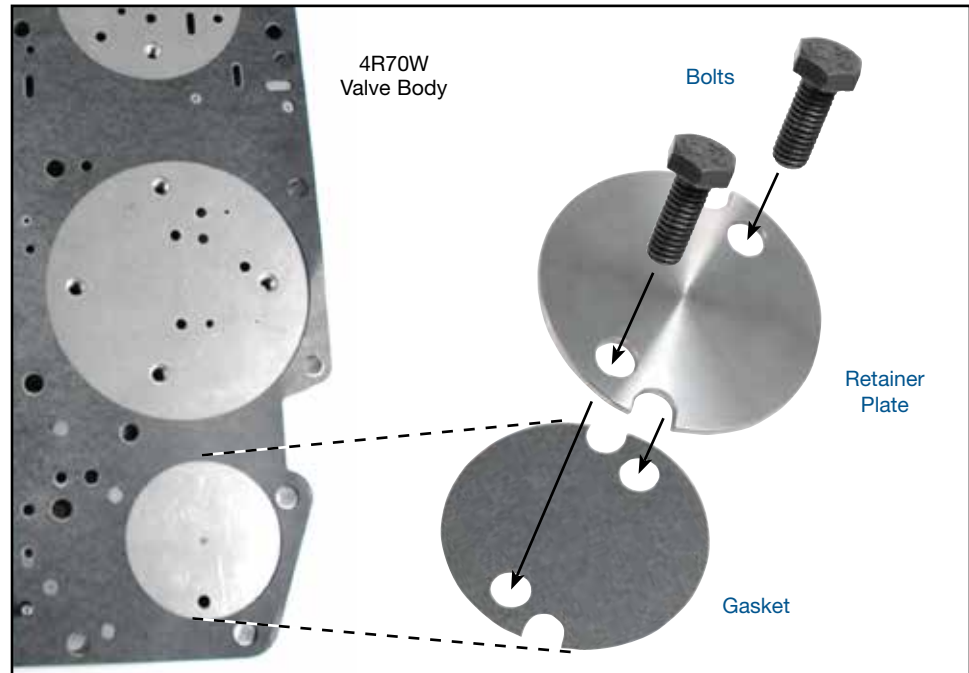
Part No.

76507F-01K

- Plate
- Gasket
- Bolts (2)

REQUIRED TOOLS:

- 13/64" or #9 Drill bits (sharp)
- 1/4" Drill bit
- 5/16" Drill bit
- 6.0mm x 1.0mm Thread tap



1. Preparation

- Install the separator plate onto the valve body and align the plate with the original alignment bolts.
- Locate the two cast in-place bolt hole locations on underside of valve body (**Figure 2**).
- In a drill press use $\frac{5}{16}$ " drill bit to clean up the cast in-place bolt hole locations and establish a true center for drilling further with the $\frac{13}{64}$ " or #9 drill.



WARNING: Do NOT drill deeper than $\frac{1}{16}$ " with the $\frac{5}{16}$ " drill bit (**Figure 3**).

- After true center is established, use a $\frac{13}{64}$ " or #9 drill to drill all the way through the valve body and the separator plate with a piece of wood underneath to prevent the plate from deforming as the drill bit cuts through.
- Remove the separator plate and enlarge the two drilled holes in the separator plate by re-drilling with a $\frac{1}{4}$ " drill bit. De-burr the new holes in the separator plate.
- With a 6.0 x 1.0mm thread tap, cut new threads in the drilled holes in the valve body. Deburr the gasket surface, making sure there are no high spots from the drilling/tapping operations.

2. Installation & Assembly

- Assemble valve body, lower valve body gasket, separator plate using normal procedures.
- Install Sonnax gasket, valve body retainer plate and two screws. Tighten screws to 80-100 in-lb (9-11 Nm).

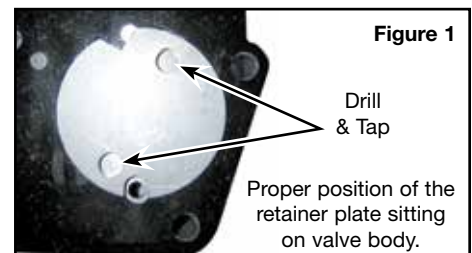


Figure 1

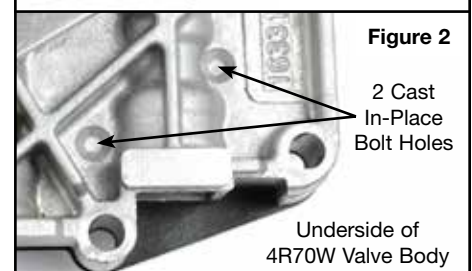


Figure 2

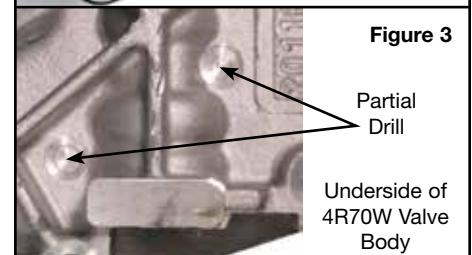


Figure 3