

## Oversized Bypass Clutch Control Valve Kit



Part No.

**95740-13K**

- Valve
- Spring
- O-Ring
- End Plug

**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



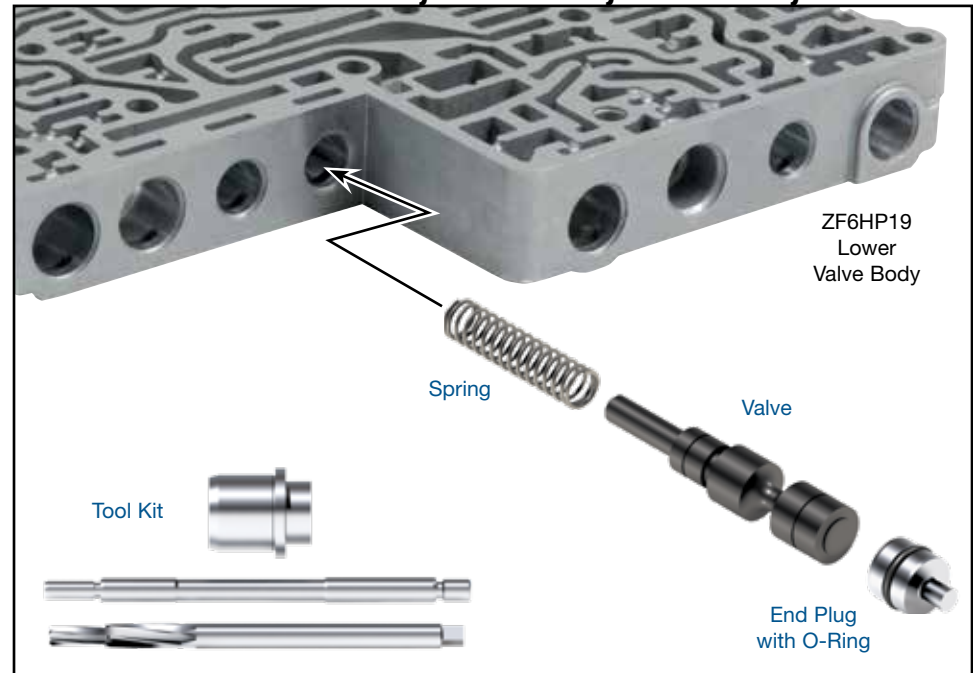
Part No.

**F-95740-TL13**

- 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).

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



### 1. Disassembly

- Remove and retain OE retaining clip and set aside for reuse.
- Remove and discard OE end plug, bypass clutch control valve and spring.

### 2. Bore Reaming

Ream bypass clutch control bore (for reaming instructions/reamer care, please visit [www.sonnax.com](http://www.sonnax.com)). Sonnax reaming tool kit **F-95740-TL13** and **VB-FIX** are required for this operation.

### 3. Installation & Assembly

- Be certain all debris has been removed from the valve bore and valve body.
- Install Sonnax spring and oversized bypass clutch control valve, ensuring the spring I.D. goes over the valve nub.
- Install the O-ring into the groove on the Sonnax end plug and install the end plug followed by the OE retaining clip.

### 4. Final Testing

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

