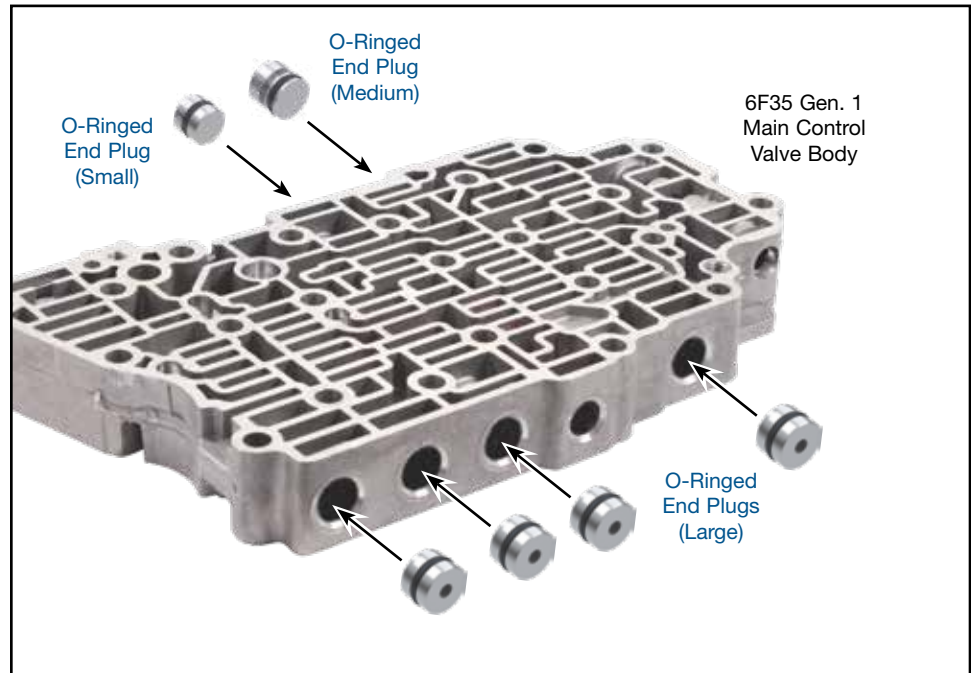


O-Ringed End Plug Kit

Part No.
144740-03K

- End Plugs (4) Large
- End Plug Medium
- End Plug Small
- O-Rings (8) Large, 3 Extra
- O-Rings (2) Small, 1 Extra

Ford 6F35 (Gen. 1, 2 & 3)



1. Disassembly

- a. Remove OE end plug retainers and save for reuse.
- b. Remove and discard OE end plugs.

2. Installation & Assembly

- a. Install Sonnax O-rings on end plugs as illustrated. Four large end plugs get a large O-ring, Medium end plug gets a large O-ring, installed on outer groove. Small end plug gets a small O-ring.
- b. Lubricate O-ring with Sonnax Slippery Stick™ O-LUBE. Roll the O-ringed plug on the bench to size O-ring into the groove.



NOTE: Ensure large end plugs are installed with threaded side facing out. Ensure medium end plug is installed with O-ring on inboard end as illustrated.

- c. Carefully insert Sonnax O-ringed end plug into bore, just far enough to allow reinstallation of OE retainer. A small, flat-bladed screwdriver inserted through the retainer port cavity may be used to help squeeze the O-ring into the bore.

3. Final Testing

- a. Vacuum test five locations (marked with rectangles) while placing thumb over bore opening to seal. These ports should hold the recommended minimum 18 in-Hg.
- b. Vacuum test the sixth location (marked with oval) at the port indicated. This port should hold the recommended minimum 18 in-Hg.

