

O-Ringed End Plug Kit

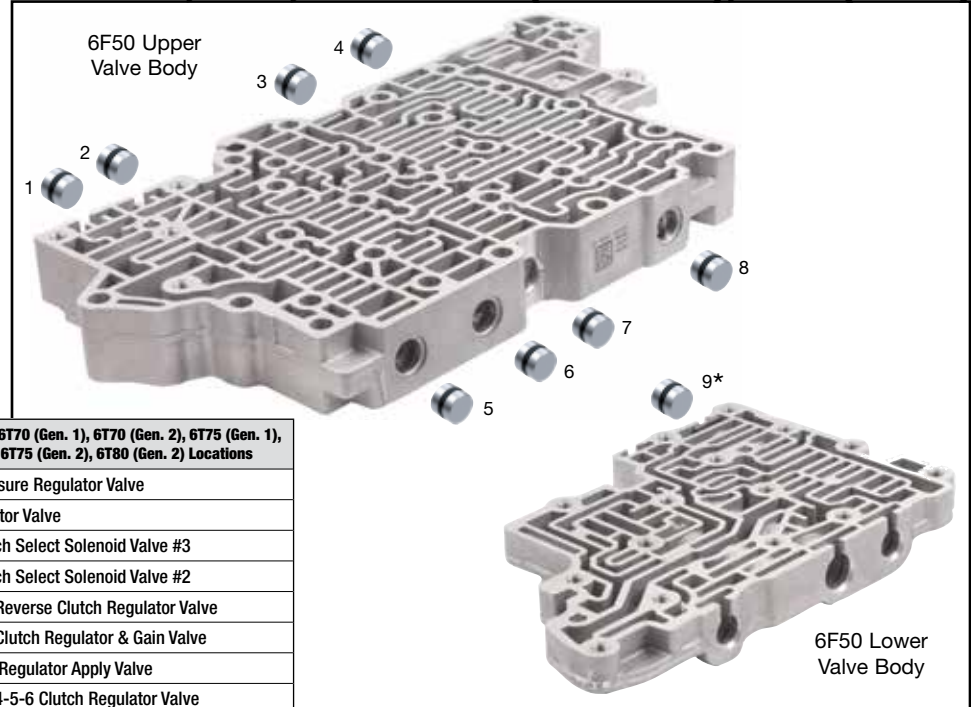
Part No.

124740-02K

- End Plugs (9)
- O-Rings (14)

5 Extra

Ford 6F50, 6F55; GM 6T70/75 (Gen. 1 & 2), 6T80 (Gen. 2)



ID	Ford 6F50, 6F55 Locations	GM 6T70 (Gen. 1), 6T70 (Gen. 2), 6T75 (Gen. 1), 6T75 (Gen. 2), 6T80 (Gen. 2) Locations
1	Pressure Regulator Valve	Pressure Regulator Valve
2	Isolator Valve	Isolator Valve
3	Multiplex Manual Valve	Clutch Select Solenoid Valve #3
4	Multiplex Shift Valve	Clutch Select Solenoid Valve #2
5	Direct Clutch Regulator Valve	3-5 Reverse Clutch Regulator Valve
6	Intermediate Clutch Regulator & Gain Valve	2-6 Clutch Regulator & Gain Valve
7	TCC Regulator Apply Valve	TCC Regulator Apply Valve
8	L/R Overdrive Clutch Regulator Valve	L/R 4-5-6 Clutch Regulator Valve
9*	Forward Clutch Regulator Valve	1-2-3-4 Clutch Regulator Valve

NOTE: 9* O-Ringed end plug should NOT be used on later 6F50/6F55 applications without short shuttle valve, and that has long (approximately .940") end plug.

1. Disassembly

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

2. Installation & Assembly

- Install Sonnax O-ring on the end plug as illustrated.
- Lubricate O-ring with Sonnax Slippery Stick **O-LUBE**. Roll the O-ringed plug on bench to size O-ring into the groove.
- 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 massage O-ring into the bore.

3. Final Testing

- Vacuum test six locations (marked with rectangles) while placing thumb over bore opening to seal. These ports should hold 18 in-Hg or more.
- Vacuum test three locations (marked with ovals) at the ports indicated. These ports should hold 18 in-Hg or more.

