



FORD 6F50, 6F55 ZIP KIT®

PART NUMBER 6F50-ZIP

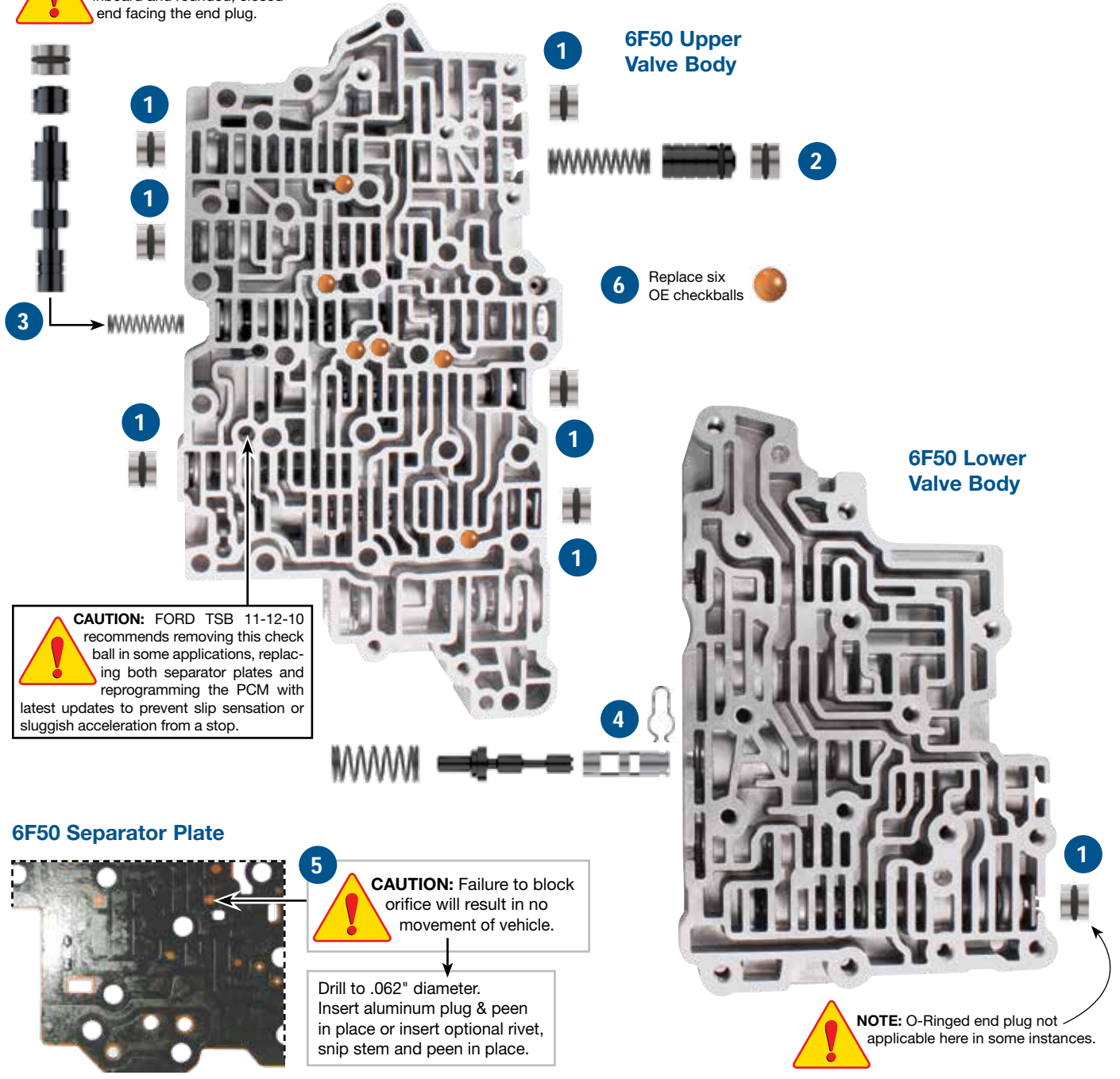
QUICK GUIDE

Parts are labeled here in order of installation. See other side of sheet for details on kit contents.

INSTALLATION DIAGRAM



CAUTION: Ensure shuttle valve is installed with blind bore facing inboard and rounded, closed end facing the end plug.



CAUTION: FORD TSB 11-12-10 recommends removing this check ball in some applications, replacing both separator plates and reprogramming the PCM with latest updates to prevent slip sensation or sluggish acceleration from a stop.



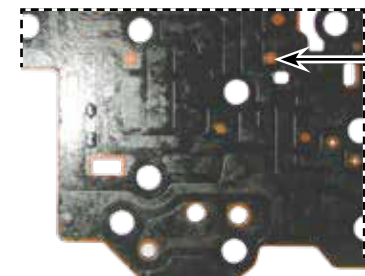
CAUTION: Failure to block orifice will result in no movement of vehicle.

Drill to .062" diameter. Insert aluminum plug &peen in place or insert optional rivet, snip stem and peen in place.



NOTE: O-Ringed end plug not applicable here in some instances.

6F50 Separator Plate



In addition to general rebuilding tips and technical information, the technical booklet included in this kit contains vacuum testing and additional repair options for higher mileage units or for repairing specific complaints which are beyond the scope of this kit.

Kit Contents & Installation Steps

Step 1 Replace Seven OE End Plugs



NOTE: O-Ringed end plug should not be used on later 6F50 applications without short shuttle valve, and that have long (approximately .940") end plugs. Reference page 6 for exploded view.

Place O-ring into end plug groove. Lubricate with Sonnax Slippery Stick **O-LUBE** and roll on bench to size.

Packaging Pocket 1

- End Plugs (7)
- O-Rings (11) 4 Extra

Step 2 Replace OE Isolator Valve & Spring

Remove and discard all OE components except the end clip. Save OE end clip for reuse. Place one O-ring into plug groove and one O-ring into isolator valve groove. Lubricate with Sonnax Slippery Stick **O-LUBE** and roll on bench to size.

Packaging Pocket 2

- End Plug
- Valve
- Spring
- O-Rings (3) 1 Extra

Step 3 Replace OE TCC Regulator Apply Valve Bore Lineup

Remove and discard all OE components except the end clip. Save OE end clip for reuse.



CAUTION: Ensure shuttle valve is installed with blind bore facing inboard and rounded, closed end facing the end plug.

Packaging Pocket 3

- TCC Regulator Valve
- Spring
- Shuttle Valve
- End Plug
- O-Rings (2) 1 Extra

Step 4 Replace OE Solenoid Pressure Regulator Valve Lineup

Remove and discard OE valve and spring. Keep outboard OE retainer for reuse. Install Sonnax sleeve and valve as illustrated. Secure sleeve into bore by installing Sonnax clip into sleeve groove at inboard port. Install Sonnax spring and secure all components into the bore with OE retainer.

Packaging Pocket 4

- Sleeve
- Valve
- Spring
- Clip

Step 5 Block Solenoid Pressure Regulator Balance Port

Drill indicated separator plate orifice with included .062" diameter drill bit. Remove any burrs. If using straight plug, insert into orifice andpeen on both sides of plate. If using optional small rivet, insert into orifice and using wire cutters, snip the stem end of the rivet if/as necessary to provide for a small head once peened in place. Peen the rivet in place on head side of plate also. After peening on both sides of the plate, ensure plate will still fit flush on mating surfaces.



CAUTION: Ensure supplied retainer clip is fully seated in AFL sleeve groove after installation.

Packaging Pocket 5

- Drill Bit, .062" dia.
- Aluminum Plugs (2) 1 Extra
- Rivets (2) 1 Extra

Step 6 Replace OE Checkballs



CAUTION: OE valve body may contain 7 checkballs. Reference Ford TSB 11-12-10 for recommended removal of one check ball and replacement of separator plates for some vehicles.

Packaging Pocket 6

- Checkballs (7) 1 Extra

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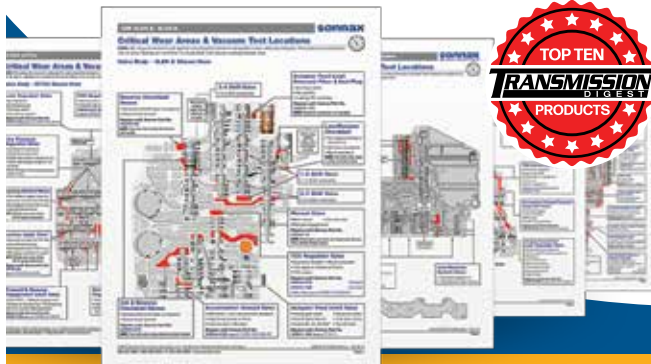
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