

O-Ringed End Plug Kit

Part No.

95740-81K

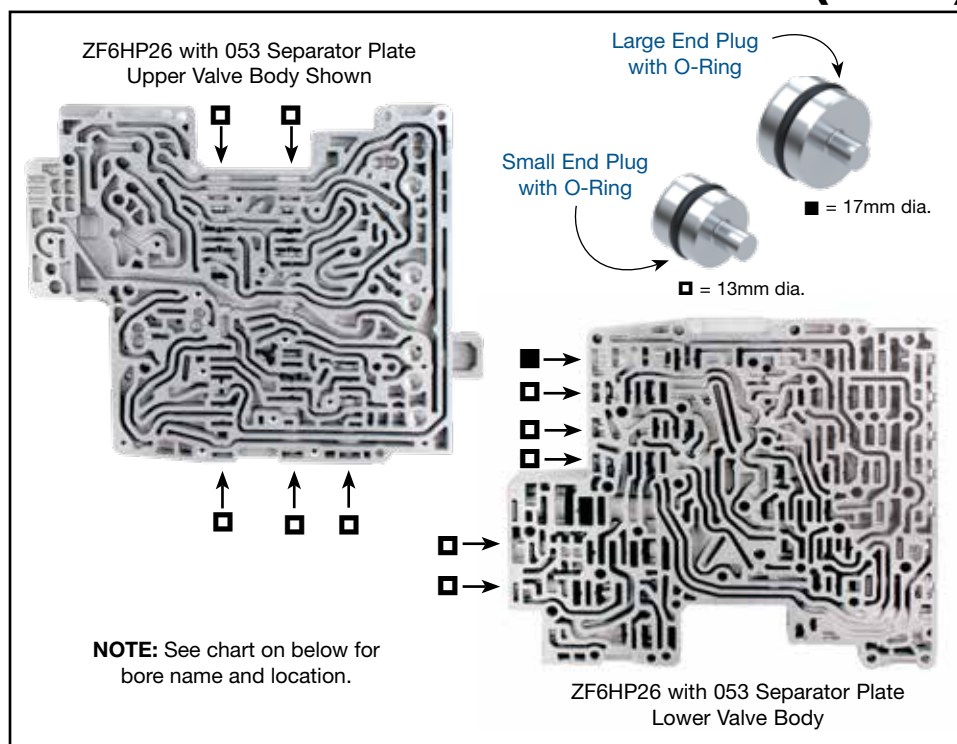
- Large End Plug 17mm
- Large O-Rings (2) 1 Extra
- Small End Plugs (10) 13mm
- Small O-Rings (15) 5 Extra



NOTE: Fits ZF6HP19/26/32 (Gen. 1) units with 053 separator plate code only.

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.

ZF6HP19/26/32 (Gen. 1)



O-Ringed End Plug Kit for ZF6HP19/26/32 (Gen. 1) with 053 Separator Plate Code Only		
Valve Location		Dia.
Clutch A Control Pressure Regulator	Lower Valve Body	17mm
Clutch E Control Pressure Regulator		13mm
Clutch E Latch		13mm
Bypass Clutch Control Regulator		13mm
Converter Release Regulator		13mm
Lubrication Control		13mm
Clutch D1 Control Pressure Regulator	Upper Valve Body	13mm
Clutch C Regulator		13mm
Clutch D2 Latch		13mm
Clutch D2 Regulator		13mm
Position Valve D		13mm

1. Preparation

- Thoroughly clean valve body before and after disassembly as dirt and debris can damage the bore surface finish when extracting solenoids, end plugs and valves.
- Any sharp edge at the bore entrance or at the second wall should be dressed or chamfered to reduce the possibility of O-ring damage during end plug installation.

2. Disassembly

- Remove the OE end plug retaining clip and set aside for reuse.
- Remove and discard the OE end plug.

3. Installation & Assembly

- Install the Sonnax O-rings into the shallow grooves of Sonnax end plugs.
- Lubricate the mounted O-rings, end plugs and bores with a small amount of Transgel, Sonnax Slippery Stick **O-LUBE**, or new ATF/STP.
- Install the appropriate valve train into the selected bore.
- Insert the end plug with the O-ringed spool inboard. The O-ring will seal on the second wall. The second wall is just inboard of the cavity that receives the end plug retaining pin.

NOTE: Ease end plugs into position. If O-ring(s) resist entering bore with direct applied pressure, alternately push and release pressure on end plug to allow flexible O-ring material to squirm into place. When releasing pressure, only allow end plug to move outboard the slightest distance.

- If the O-ring is damaged during the installation, remove the end plug and mount one of the extra O-rings included in the kit.