sonnax®

TRANSMISSION PARTS

Instructions

Aisin Seiki AS69RC; Chrysler 45RFE, 545RFE, 65RFE, 66RFE, 68RFE, 845RE; ZF8HP45, ZF8HP70

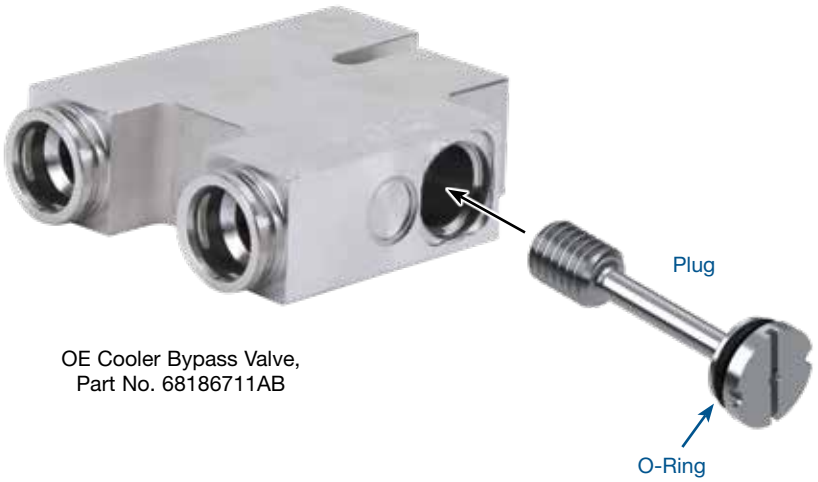
Thermal Bypass Eliminator Kit

Part No. 72760-01K

- Plug
- O-Ring

NOTE: For use in OE part numbers 52014762AA, 68186711AB, 68291739AA, and 68210018AA only. These part numbers are located on OE cooler bypass valve housing.

Patent Pending



OE Cooler Bypass Valve,
Part No. 68186711AB

1. Disassembly

a. Disconnect all fittings and remove cooler bypass valve from vehicle.

NOTE: In most applications, the housing is located towards front of vehicle in close proximity to where the cooler lines enter the case.

b. Remove larger diameter swaged cover retaining thermal valve train. The recommended process is to use an end mill to remove the swaged material. Set vertical zero on the top of the cap and mill around the cap. One pass around the cap should remove the swaging.

NOTE: Alternative cover removal methods referenced on page 2.

NOTE: Small diameter swaged cover is a pressure bypass valve train. Do not disturb or remove.

c. Remove and discard all components of thermal valve train.

d. Remove any burrs around the bore entry created during disassembly.

e. Thread lowest passage of thermal valve bore with 7/16"-14 tap.

f. Be certain to remove all chips and debris.

g. Remove any oil from the bore and the newly formed threads.

2. Installation & Assembly

a. Install Sonnax O-ring onto thermal bypass eliminator plug as shown.

b. Apply a thread locking compound on the bypass plug threads.

c. Lightly lube the O-ring with Sonnax Slippery Stick **O-LUBE**, Transgel or equivalent.

d. Thread Sonnax bypass plug into bore until the cap seats. Do not forcefully torque the bypass plug.

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2. Installation & Assembly (continued)

e. Wait for thread locking compound to set and reinstall cooler bypass valve onto vehicle.

f. Check for leaks.

NOTE: If you do not want to use thread locking compound, there are two small cut-outs in the cap of the plug that can be used to swage the plug with a small chisel or punch. The screwdriver slot in the cap can be used for the same purpose.

Alternative Suggestions for Removing OE Swaged Retaining Cap Cover

1. Drill through the center of the cap with a Ø.25" drill and yank the cap out with a slide hammer. This will leave a lot of raised material that will have to be cleaned up.
2. Use a large coarse hand file or a belt sander to remove the swaged material around the cap. This will cause some ugly damage to the exterior of the bypass block but should not affect its function.