

## O-Ringed End Plug Kit

### Part No.

# 85740-01K

- End Plugs (4) 13mm dia.
- O-Rings (6) Small, 2 Extra
- Internal End Plugs (2) 13.75mm dia.
- O-Rings (6) Large, 2 Extra

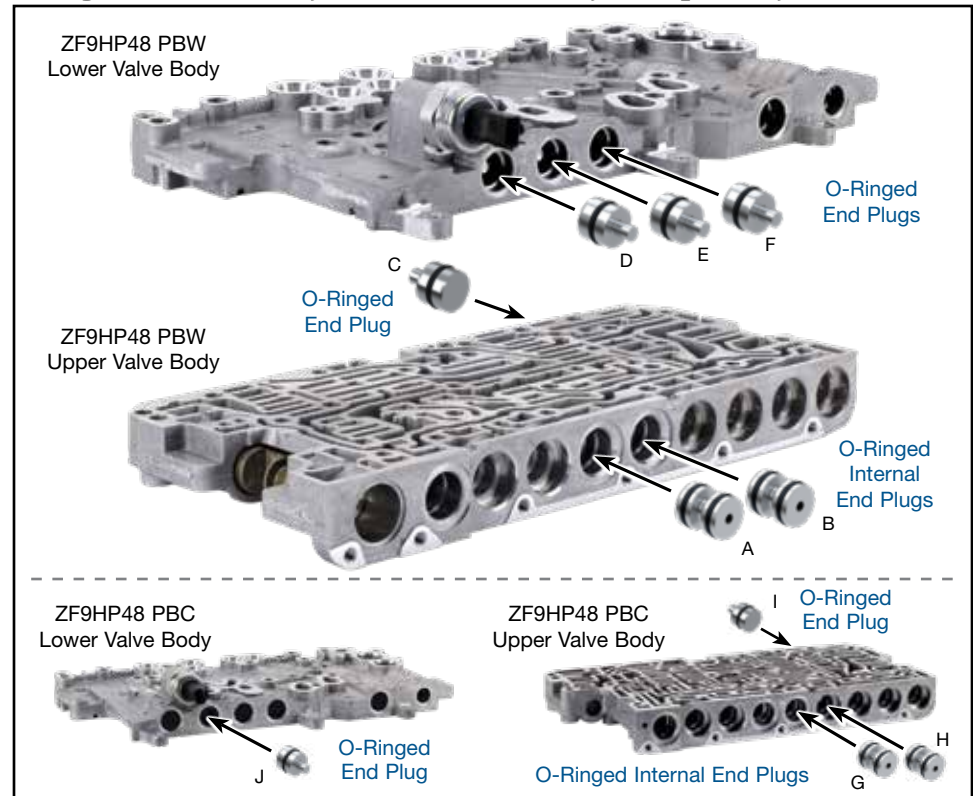


**NOTE:** Port configurations may change due to variations of casting channels.

**NOTE:** Services complete PBW (Park by Wire) valve body or PBC (Park by Cable) valve body with 1 extra internal and 1 external end plug.

**NOTE:** Sonnax O-ringed end plug kit does NOT fit early-style ZF bore plugs with flat metal retainers.

## Chrysler 948TE; Honda/Acura, 9-Speed; ZF9HP48



### Chrysler 948TE, ZF9HP48 PBW

ID	Valve Location	Dia.
<b>Upper Valve Body</b>		
A	E Clutch Apply Valve	13.75mm
B	B Clutch Apply Valve	13.75mm
C	Lubrication Valve	13mm
<b>Lower Valve Body</b>		
D	C Clutch Regulator Valve	13mm
E	D Clutch Regulator Valve	13mm
F	TCC Regulator Valve	13mm

### Chrysler 948TE PBC

ID	Valve Location	Dia.
<b>Upper Valve Body</b>		
G	E Clutch Regulator Valve	13.75mm
H	TCC Regulator Valve	13.75mm
<b>Lower Valve Body</b>		
I	Lube Regulator Valve	13mm
J	C Clutch Regulator Valve	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.
- Sharp edges at 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

- When applicable, remove the solenoid retaining clip and solenoid.
- Remove OE end plug retaining clip and set aside for reuse.
- Remove and discard OE end plug.

### 3. Installation & Assembly

- Install Sonnax O-rings into shallow groove(s) on Sonnax end plugs.
- Lubricate with Sonnax Slippery Stick **O-LUBE** and roll on bench to size the O-ring in the groove.
- Install each end plug into appropriate bore (**See Charts & Main Photo**).

### 4. Final Testing

Vacuum testing at the port(s) indicated holds the recommended minimum 16 in-Hg (**See Figures 1–4, page 2**).

