

O-Ringed End Plug Kit

Part No.

184740-03K

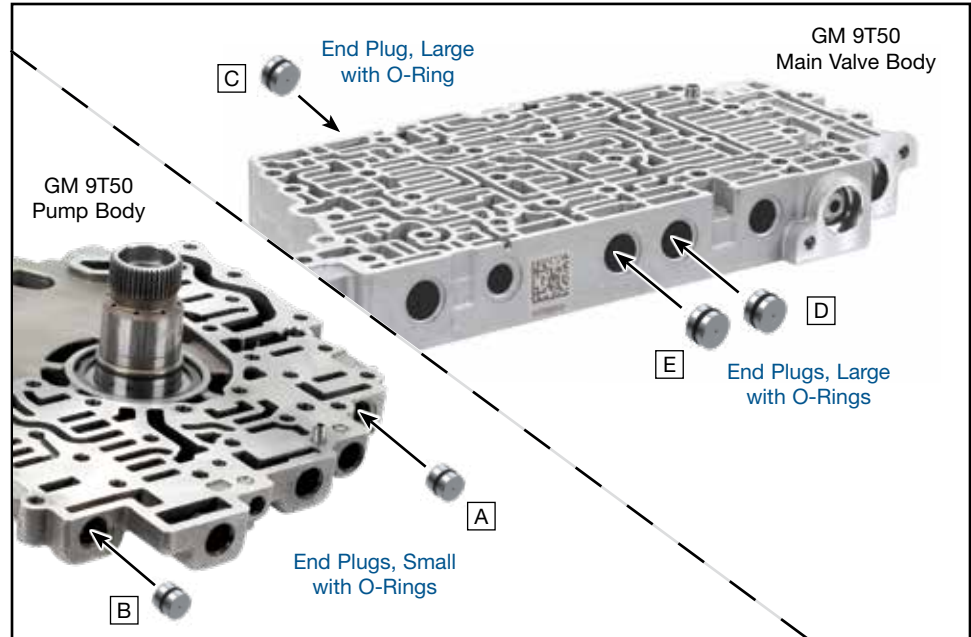
- End Plugs, Small (2) 14mm
- O-Rings, Small (4) 12mm, 2 Extra
- End Plugs, Large (3) 15.25mm
- O-Rings, Large (5) 13mm, 2 Extra



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

This O-ringed kit fits both ETRS and non-ETRS valve bodies.

GM 9T45, 9T50, 9T60, 9T65



ID	Valve Location	Dia.
Pump		
A	Pressure Reg. Valve	14mm
B	TCC Reg. Apply Valve	14mm
Main Valve Body		
C	Clutch Selector Valve	15.25mm
D	3-8 Clutch Reg. Valve	15.25mm
E	4th Clutch Reg. Valve	15.25mm

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

3. Installation & Assembly

- Be certain all debris has been removed from the valve bore and valve body.
- 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 O-ring in end plug groove.
- Install end plugs into appropriate bores (**See Chart & Photo**).
- Reinstall OE retaining clips.

4. Final Testing

Vacuum testing at the port(s) indicated holds the recommended minimum 16 and 18 in-Hg (**Figures 1 & 2**).

