

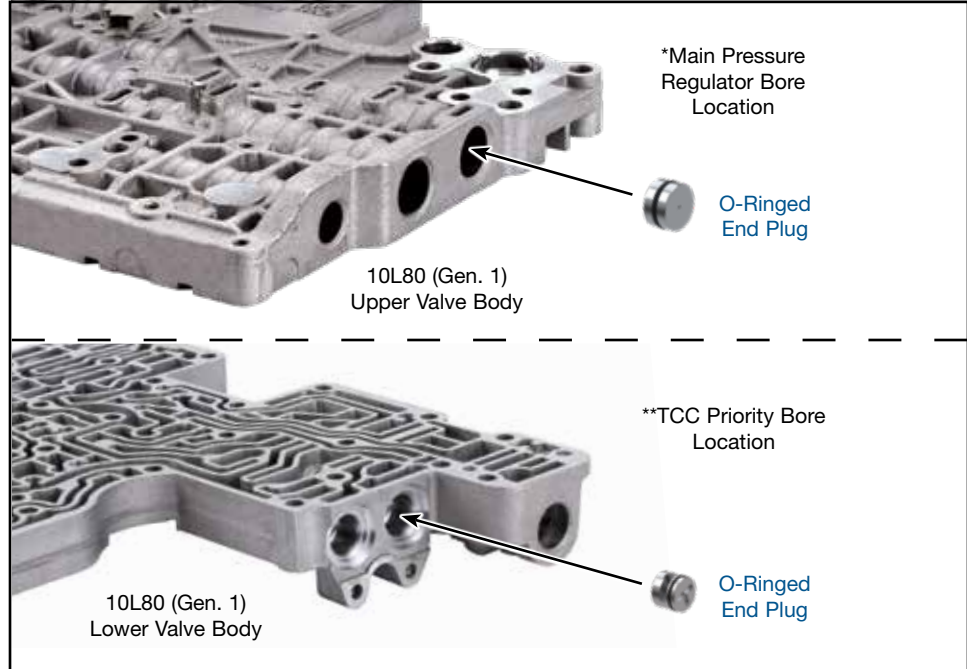
## O-Ringed End Plug Kit

### Part No.

# 105740-13K

- End Plug\* Large
- End Plug\*\* Small
- O-Rings\* (3) Large, 2 Extra
- O-Rings\*\* (3) Small, 2 Extra

## Ford 10R60, 10R80, 10R90; GM 10L60 (Gen. 1), 10L80 (Gen. 1), 10L90 (Gen. 1)

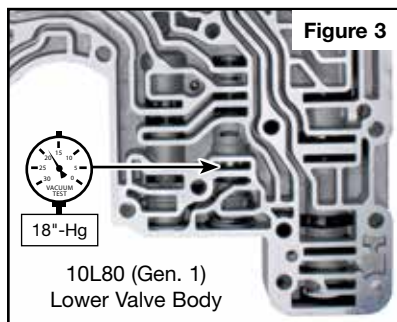
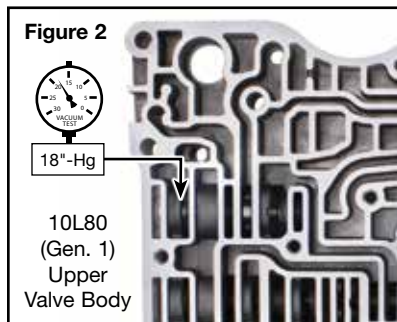
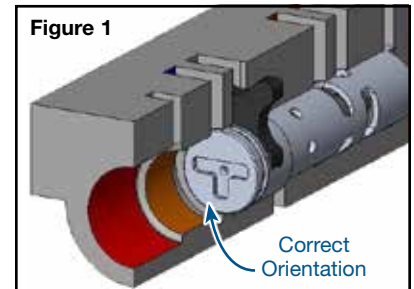


### 1. Disassembly

- a. Remove OE retaining clips and set aside for reuse.
- b. Remove and discard OE end plugs.

### 2. Installation & Assembly

- a. Be certain all debris has been removed from the valve bores and valve body.
- b. Install Sonnax O-rings into shallow groove of Sonnax end plugs. The large end plug uses the large O-ring, the small end plug uses the small O-ring. Lubricate with Sonnax Slippery Stick **O-LUBE** and roll on bench to size the O-ring into the groove.
- c. **Main Pressure Regulator Valve Bore:** Carefully insert Sonnax large end plug into the bore just far enough to reinstall the OE retainer.
- d. **TCC Priority Valve Bore:** Carefully insert Sonnax small end plug into the bore just far enough to reinstall the OE retainer. Use a flat-head screw driver to rotate the end plug so the T-groove resembles an upright capitol "T" (**Figure 1**).



### 3. Final Testing

Vacuum testing at the port(s) indicated holds the recommended minimum 18 in-Hg (**Figures 2 & 3**).

**NOTE:** For main pressure regulator bore, cover back exhaust ports when conducting vacuum testing.