

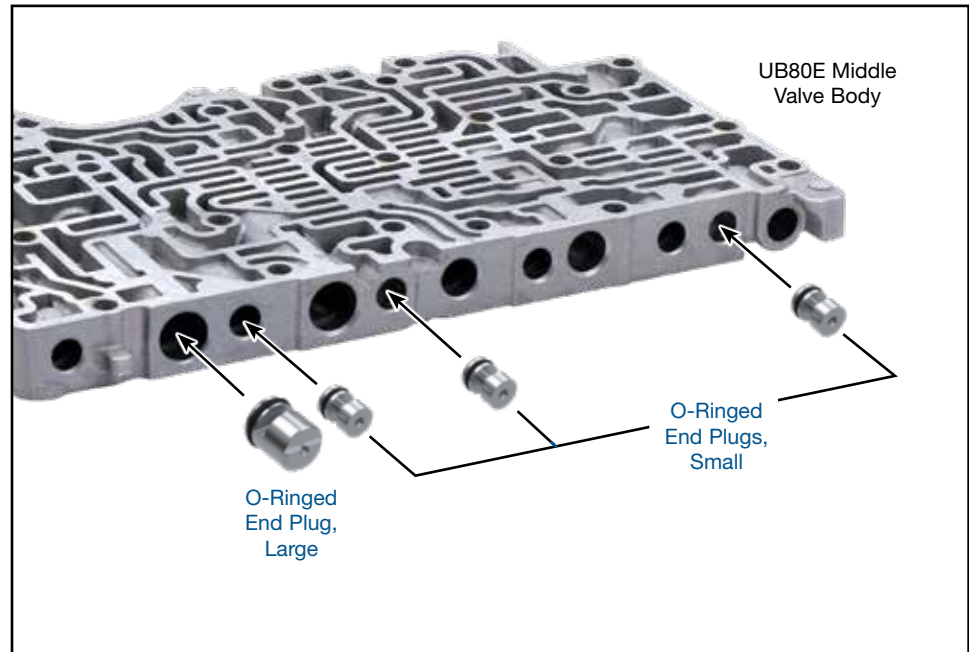
O-Ringed End Plug Kit

Part No.

168740-10K

- End Plug Large
- O-Rings (2) Large, 1 Extra
- End Plugs (3) Small
- O-Rings (6) Small, 3 Extra

Toyota/Lexus UA80E, UA80F, UB80E, UB80F



1. Disassembly

- a. Remove OE end plug retainers and save for reuse.
- b. Remove and discard the OE end plugs.

2. Installation & Assembly

- a. Thoroughly clean the valve body and valve bores prior to assembly.
- b. Install Sonnax O-rings on Sonnax end plugs in the shallow groove.
 - The small O-rings fit the small end plugs.
 - The large O-rings fit the large end plug.
- c. Install the appropriate valve train into the valve body bore.
- d. Lubricate O-rings with Sonnax Slippery Stick **O-LUBE**. Roll the O-ringed end plug on the bench to size O-ring into the groove.



NOTE: Use a twisting motion when installing the end plug to prevent the O-ring from being damaged.

- e. Insert Sonnax O-ringed end plugs into the bores with the O-ring seal oriented inboard.
- f. Reinstall the OE end plug retainers.

3. Final Testing

Vacuum testing at the port(s) indicated holds the recommended minimum 18 in-Hg.

