

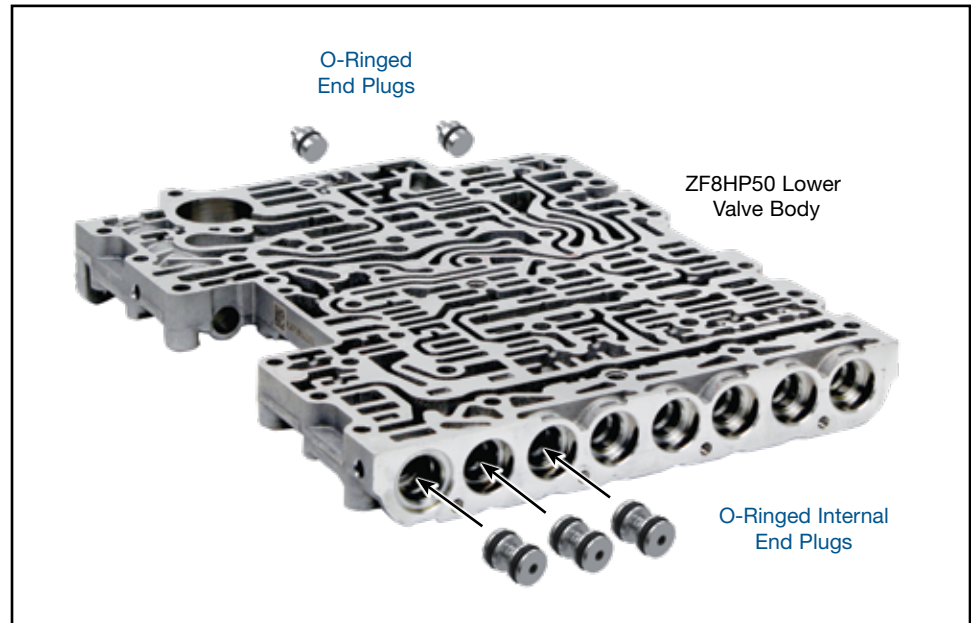
O-Ringed End Plug Kit

Part No.

35740-45K

- Internal End Plugs (3) 12mm Dia.
- End Plugs (2) 13mm Dia.
- O-Rings (12) 4 Extra

ZF8HP50, ZF8HP75, ZF8HP95



1. Preparation

- a. 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.
- b. 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

- a. When applicable, remove the solenoid retaining clips and solenoids.
- b. Remove OE end plug retaining clips and set aside for reuse.
- c. Remove and discard OE end plugs.

3. Installation & Assembly

- a. Install Sonnax O-Rings into grooves of Sonnax end plugs. Lubricate O-ringed end plugs with Sonnax Slippery Stick **O-LUBE**. Roll on bench to size O-Ring into grooves.
- b. Install each end plug into appropriate bore, followed by OE retaining clip.

4. Final Testing

Vacuum testing at the port(s) indicated holds the recommended minimum 16 in-Hg (**Figure 1**).

