

O-Ringed Internal End Plug Kit

Part No.

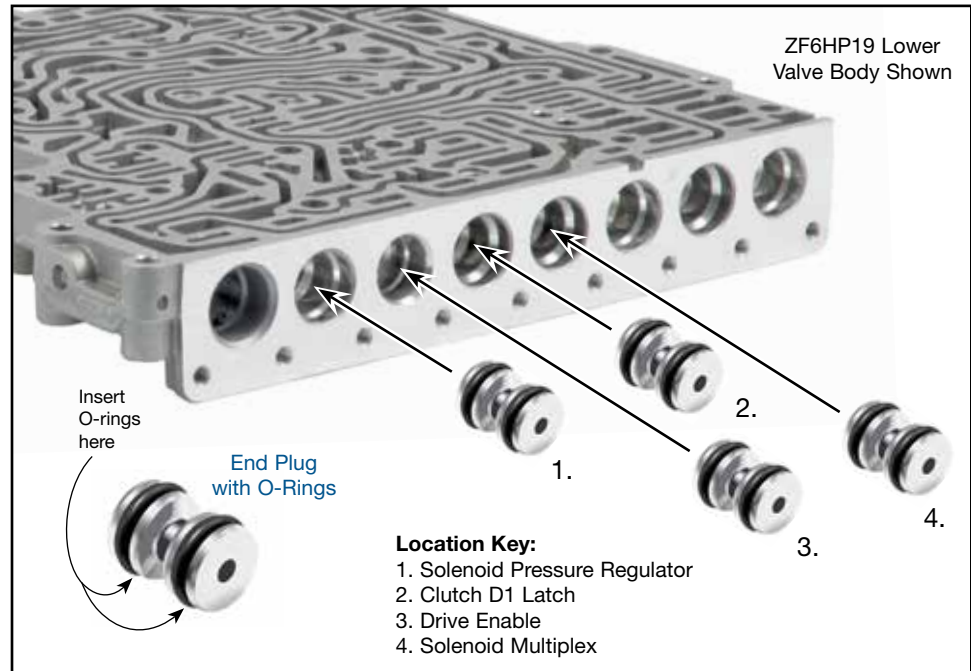
95740-25K

- End Plugs (4) 12mm Dia.
- O-Rings (11) 8 Needed, 3 extra



NOTE: Kit is NOT compatible with ZF6HP21/28/34 (Gen.2) units. To differentiate between Generation 1 and Generation 2 valve bodies, refer to ZF Identification Guide at www.sonnax.com.

Ford 6R60, 6R75, 6R80; ZF6HP19, ZF6HP26, ZF6HP32



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.
- Any sharp edge at the 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

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

3. Installation & Assembly

- Install two of the Sonnax O-rings on each of the 12mm internal end plugs into the shallow grooves (main image).
- Lubricate the mounted O-rings, end plugs and bores with a small amount of Transgel, Sonnax Slippery Stick **O-LUBE**, or new ATF/STP.
- Install the appropriate valve train into the selected bore.
- Insert the internal end plug with the hole facing outboard.

NOTE: Ease the end plugs into position. If the O-ring(s) resists entering the bore with direct applied pressure, alternately push and release the pressure on the end plug to allow the flexible O-ring material to squirm into place. When releasing the pressure, only allow the end plug to move outboard the slightest distance.

- If the O-ring is damaged during the installation, remove the end plug and mount one of the extra O-rings included in the kit.