

**Oversized Position Valve Kit**



**Part No.**  
**95740-75K**

- Spring
- Valve Long Stem
- Valve No Stem
- End Plug
- O-Rings (2) 1 Extra

**NOTE:** This kit fits E-shift versions only of the ZF6HP21/28/34 (Generation 2) and ZF6HP19/26/32 (Generation 1) valve bodies with an 053 separator plate. To differentiate between Gen. 1 and Gen. 2 valve bodies, refer to ZF Identification Guide at [www.sonnax.com](http://www.sonnax.com).

**Tool Kit**

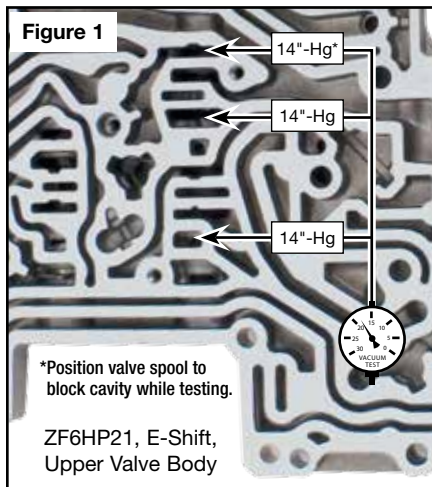
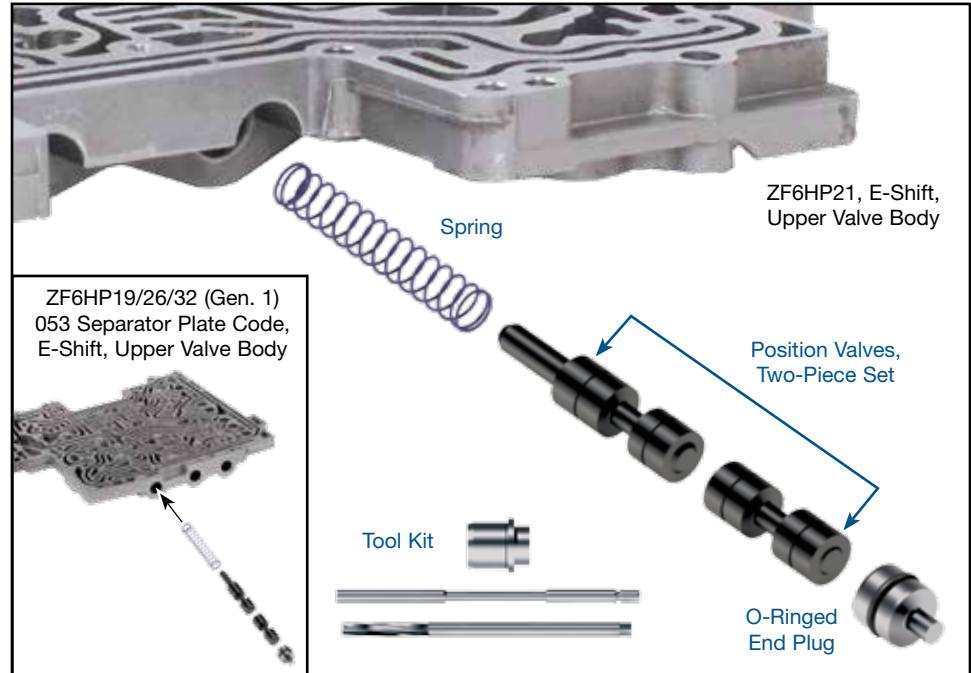


**Part No.**  
**F-95740-TL75**

- Reamer • Reamer Jig • Guide Pin

**NOTE:** Sonnax “F-Tool” kits designed to service a specific bore require the VB-FIX, a self-aligning valve body reaming fixture. More information and instructions can be found online at [www.sonnax.com](http://www.sonnax.com).

**ZF6HP19, ZF6HP21, ZF6HP26, ZF6HP28, ZF6HP32, ZF6HP34**

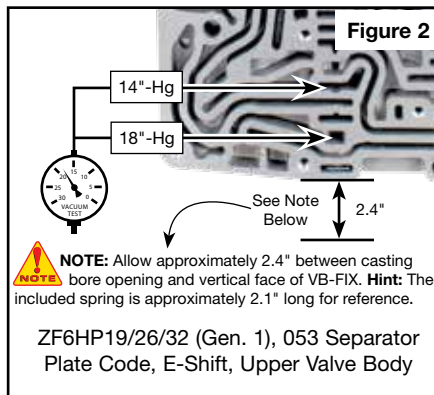


**1. Disassembly**

- a. Remove the OE retaining clip and save for reuse.
- b. Remove and discard the OE end plug, two position valves and spring.

**2. Bore Reaming**

Ream position valve bore (for reaming instructions/reamer care, please visit [www.sonnax.com](http://www.sonnax.com)). Sonnax reaming tool kit **F-95740-TL75** and **VB-FIX** are required for this operation.



**NOTE:** If reaming an 053 separator plate valve body casting, allow approximately 2.4" between casting bore opening and vertical face of VB-FIX. **HINT:** The included spring is approximately 2.1" long for reference.

**3. Installation & Assembly**

- a. Be certain all debris has been removed from the valve bore and valve body.
- b. Install the Sonnax spring into the bore.
- c. Install the first Sonnax valve with the long stem, inboard as shown.
- d. Install the second Sonnax valve (no stem).
- e. Install the Sonnax O-ring into the shallow groove on the Sonnax end plug.
- f. Lubricate the O-ring with Sonnax slippery stick O-LUBE, then install the end plug.
- g. Reinstall the OE retaining clip.

**4. Final Testing**

Vacuum testing at the port(s) indicated holds the recommended minimum 14 in-Hg or 18 in-Hg (**Figures 1 & 2**).