

# Critical Wear Areas & Vacuum Test Locations

**ZIP** Drop-In Zip Valve™  
Parts Available

**E40D-4R100-ZIP**  
Zip Kit® Available

**NOTE:** OE valves are shown in rest position and should be tested in rest position unless otherwise indicated. Test locations are pointed to with an arrow. Springs are not shown for visual clarity. Low vacuum reading indicates wear and Sonnax parts are noted for replacement.

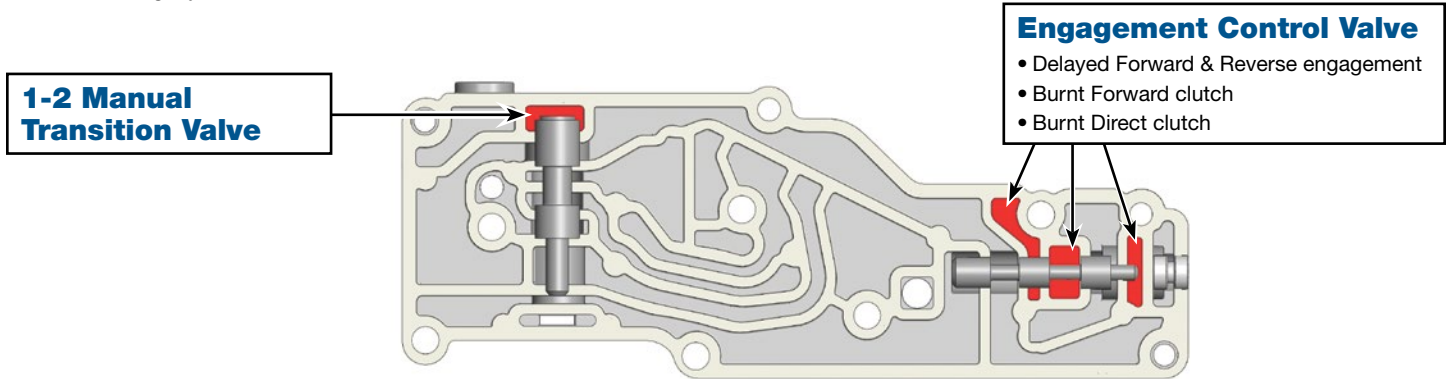
## Lower Control Body • 4R100 Non-PTO Shown

**NOTE:** Worm tracks and test locations same for '96-'98 E40D.  
Worm tracks and test locations different for '89-'95 E40D.  
Worm tracks slightly different for PTO 4R100, test locations are the same.



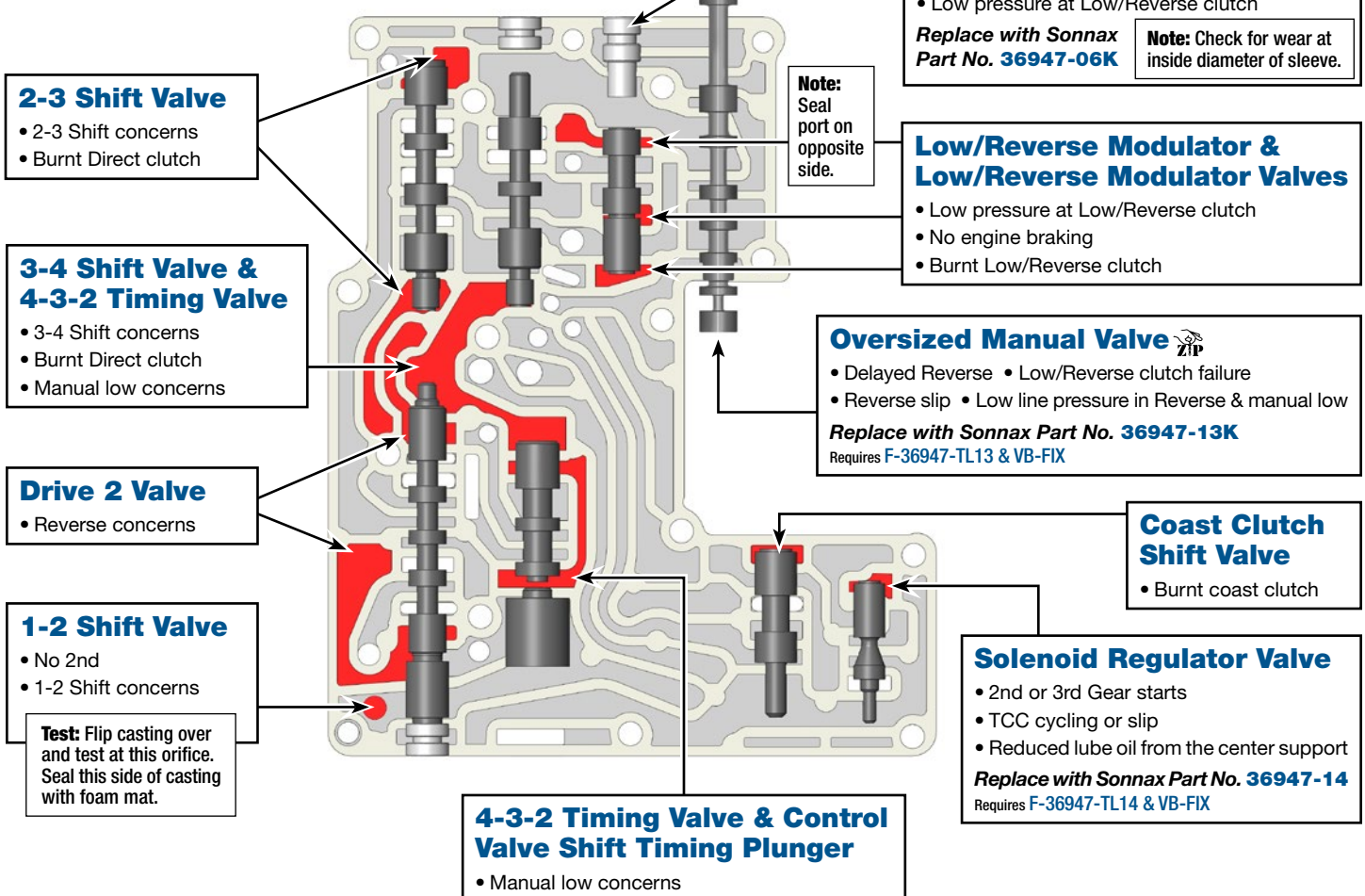
For specific vacuum test information, refer to individual part instructions included in kits and available at [www.sonnax.com](http://www.sonnax.com).

Click on Sonnax part numbers to see more information.



## Upper Control Body • 4R100 Non-PTO Shown

**NOTE:** Worm tracks and test locations same for '96-'98 E40D.  
Worm tracks and test locations different for '89-'95 E40D.  
Worm tracks slightly different for PTO 4R100, test locations are the same.



# Critical Wear Areas & Vacuum Test Locations

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Parts Available

**E40D-4R100-ZIP**  
Zip Kit® Available

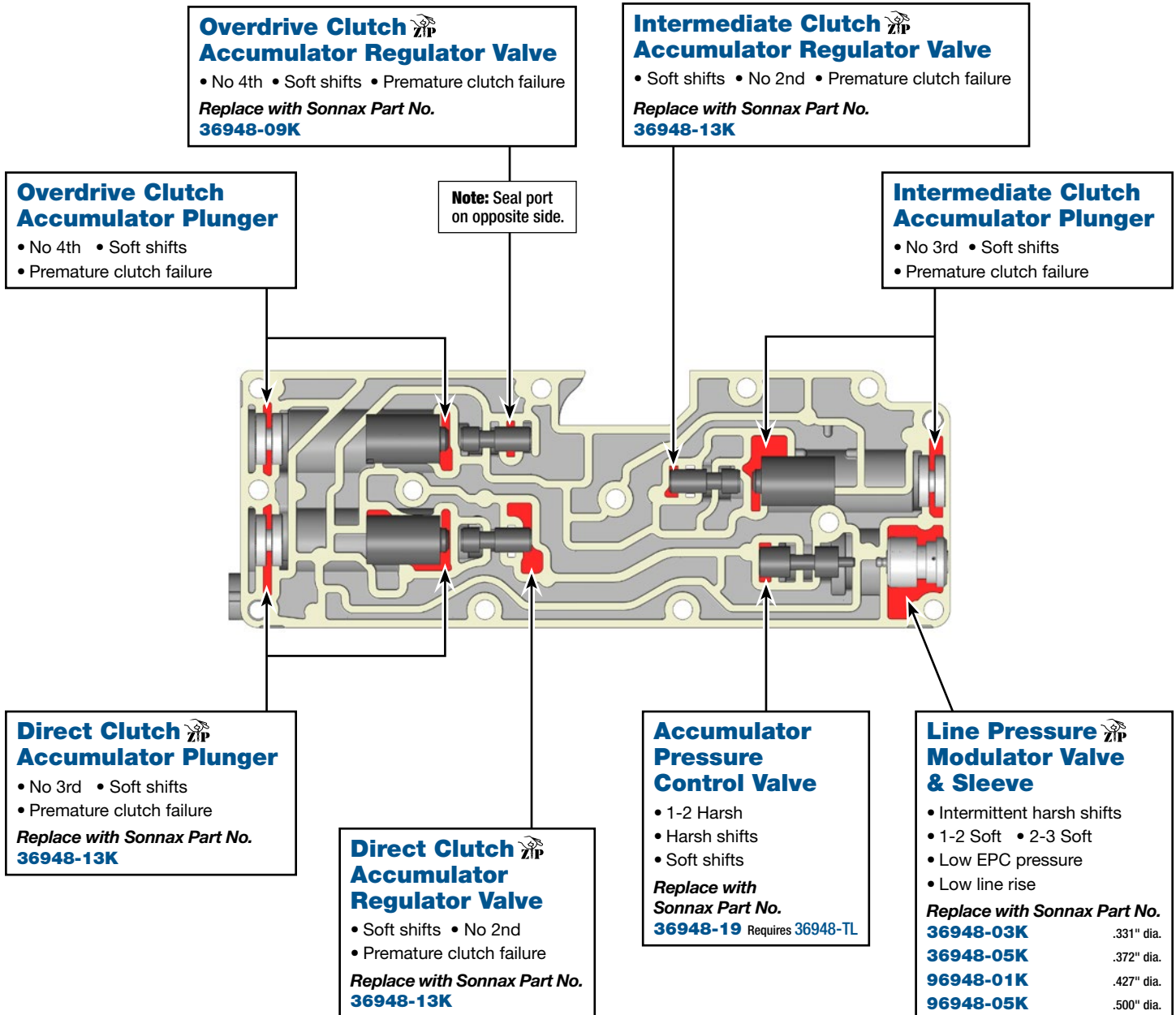
**NOTE:** OE valves are shown in rest position and should be tested in rest position unless otherwise indicated. Test locations are pointed to with an arrow. Springs are not shown for visual clarity. Low vacuum reading indicates wear and Sonnax parts are noted for replacement.

## Accumulator Control Body • 4R100 Non-PTO Shown



For specific vacuum test information, refer to individual part instructions included in kits and available at [www.sonnax.com](http://www.sonnax.com).

Click on Sonnax part numbers to see more information.



# Critical Wear Areas & Vacuum Test Locations

**ZIP** Drop-In Zip Valve™  
Parts Available

**E4OD-4R100-ZIP**  
Zip Kit® Available

**NOTE:** OE valves are shown in rest position and should be tested in rest position unless otherwise indicated. Test locations are pointed to with an arrow. Springs are not shown for visual clarity. Low vacuum reading indicates wear and Sonnax parts are noted for replacement.



For specific vacuum test information, refer to individual part instructions included in kits and available at [www.sonnax.com](http://www.sonnax.com).

Click on Sonnax part numbers to see more information.

## Pump Body • E4OD Shown

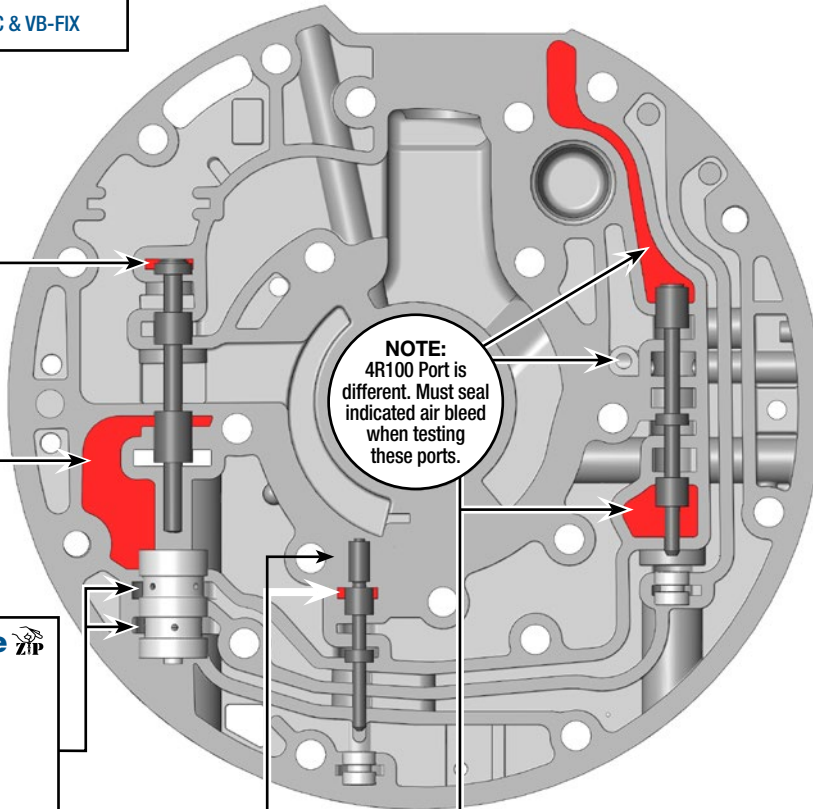
**NOTE:** Test ports on 4R100 slightly different.

### Main Regulator Valve (Inboard)

- Code 62, 628, 1744
- Engine stall on engagement in Reverse
- Engine stumble on engagement in Reverse
- High line pressure
- Overheated converter

Replace with Sonnax Part Nos.

**36424-04K** or  
**36424-16K** Requires F-36424-TL16C & VB-FIX



**NOTE:**  
4R100 Port is  
different. Must seal  
indicated air bleed  
when testing  
these ports.

### Main Regulator Valve & Sleeve (Outboard)

- Soft shifts
- Delayed Reverse
- Low line rise

Replace with Sonnax Part Nos.

**36424-03K** Factory Style, No O-Rings or  
**36424-01K** O-Ring Style

**Note:** Seal holes  
on opposite side.

### Converter Regulator Valve

- Internal converter damage
- Excess converter pressure
- Low converter & converter clutch apply pressure

### Converter Clutch Control Valve

- Lockup shudder
- TCC cycling

Replace with Sonnax Part Nos.

**36424-08K** 4R100 PWM Only or  
**36424-15K** 4R100 PWM Only, Requires F-36424-TL15C & VB-FIX

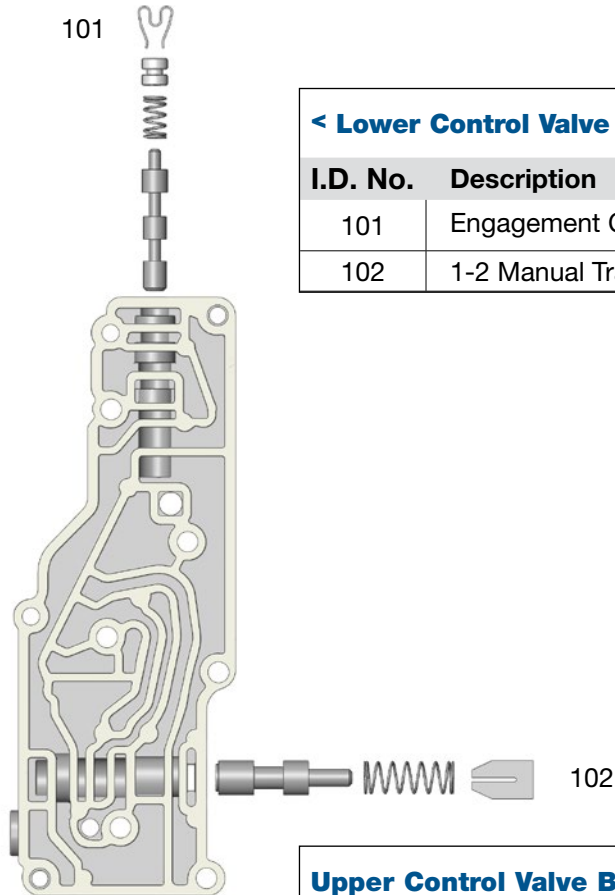
# OE Exploded View

## Lower Control Body 4R100 Non-PTO Shown

NOTE: E40D is the same.

## Upper Control Body 4R100 Non-PTO Shown

NOTE: E40D Worm tracks and valves vary slightly.

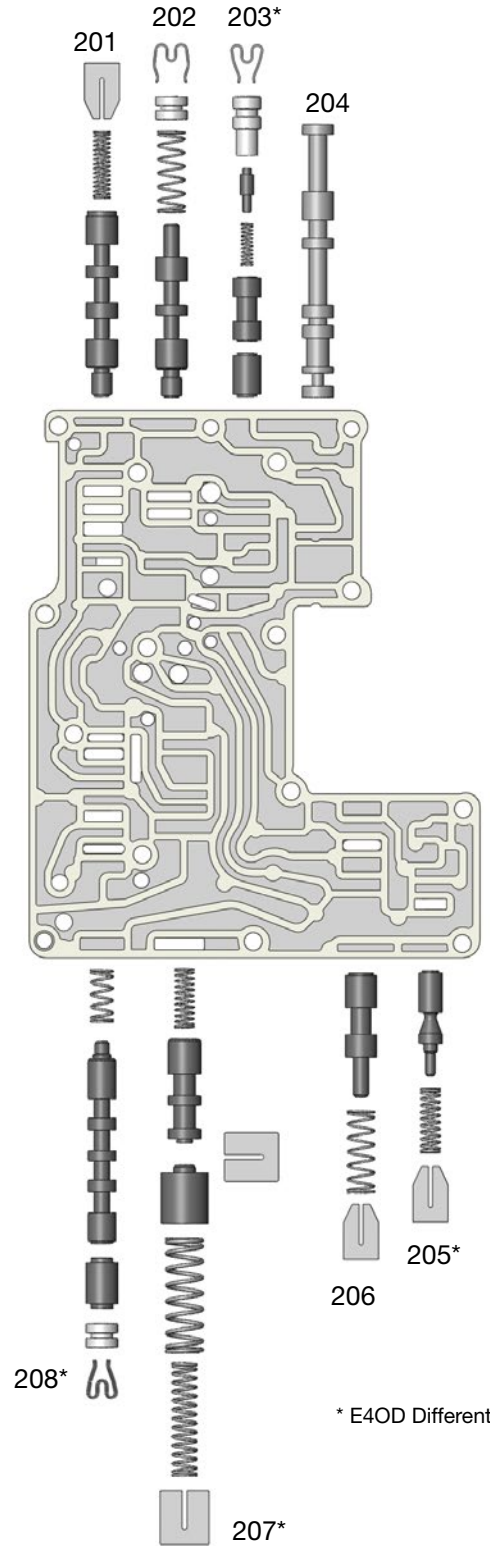


**< Lower Control Valve Body Descriptions**

I.D. No.	Description
101	Engagement Control Valve
102	1-2 Manual Transition Valve

**Upper Control Valve Body Descriptions >**

I.D. No.	Description
201	2-3 Shift Valve
202	3-4 Shift Valve
203*	Low/Reverse Modulator Valve (Inboard)
	Low/Reverse Modulator Valve (Center)
	Low/Reverse Modulator Valve Plunger & Sleeve (Outboard)
204	Manual Control Valve
205*	Solenoid Regulator Valve
206	Coast Clutch Shift Valve
207*	4-3-2 Timing Valve (Inboard)
	Control Valve Shift Timing Plunger (Outboard)
208*	Drive 2 Valve (Inboard)
	1-2 Shift Valve (Outboard)

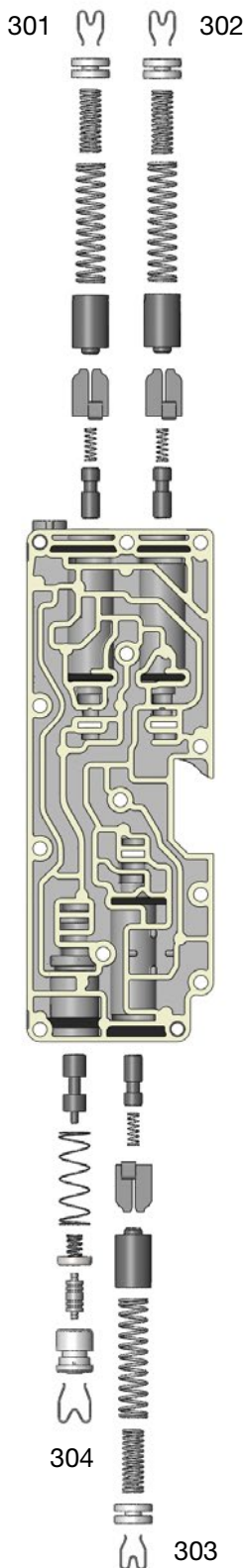


\* E40D Different

# OE Exploded View

## Accumulator Control Body 4R100 Non-PTO Shown

## Pump Body E4OD Pump Body Shown



**< Accumulator Control Body Descriptions**

I.D. No.	Description
301	Direct Clutch Accumulator Regulator Valve (Inboard)
	Direct Clutch Accumulator Plunger (Outboard)
302	Overdrive Clutch Accumulator Regulator Valve (Inboard)
	Overdrive Clutch Accumulator Plunger (Outboard)
303	Intermediate Clutch Accumulator Regulator Valve (Inboard)
	Intermediate Clutch Accumulator Plunger (Outboard)
304	Line Pressure Modulator Valve (Inboard)
	Line Pressure Modulator Plunger Valve & Sleeve (Outboard)

**Pump Body Descriptions >**

I.D. No.	Description
401	Main Regulator Valve (Inboard)
	Main Regulator Valve & Sleeve (Outboard)
402	Converter Regulator Valve
403A	E4OD Converter Clutch Control Valve
403B	4R100 Non-PWM Converter Clutch Control Valve
403C	4R100 PWM Converter Clutch Control Valve (Inboard)
	Converter Clutch Control Plunger Valve & Sleeve (Outboard)

