

Critical Wear Areas & Vacuum Test Locations

ZIP Drop-In Zip Valve™ Parts Available

6R80L-6R100-ZIP Zip Kit® Available

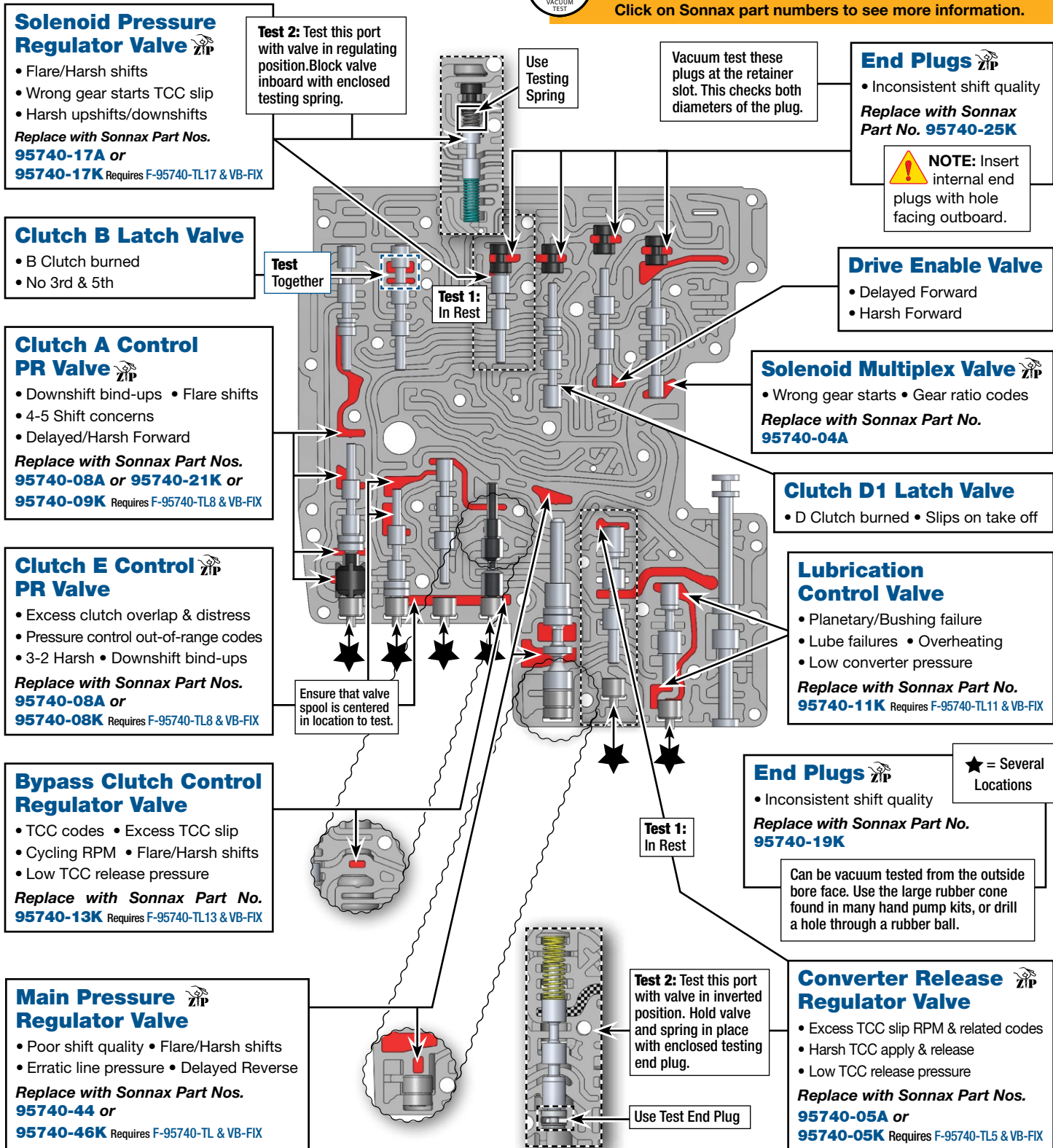
NOTE: OE valves are shown in rest position and should be tested in rest position unless otherwise indicated. Test locations are pointed to with an arrow. Springs are not shown for visual clarity. Low vacuum reading indicates wear and Sonnax parts are noted for replacement.

Lower Valve Body • 6R80 (2015-Later) Shown



For specific vacuum test information, refer to individual part instructions included in kits and available at www.sonnax.com.

Click on Sonnax part numbers to see more information.



Solenoid Pressure Regulator Valve

- Flare/Harsh shifts
- Wrong gear starts TCC slip
- Harsh upshifts/downshifts

Replace with Sonnax Part Nos. **95740-17A** or **95740-17K** Requires F-95740-TL17 & VB-FIX

Test 2: Test this port with valve in regulating position. Block valve inboard with enclosed testing spring.

Use Testing Spring

Vacuum test these plugs at the retainer slot. This checks both diameters of the plug.

End Plugs

- Inconsistent shift quality
- Replace with Sonnax Part No. **95740-25K**

NOTE: Insert internal end plugs with hole facing outboard.

Clutch B Latch Valve

- B Clutch burned
- No 3rd & 5th

Test Together

Test 1: In Rest

Drive Enable Valve

- Delayed Forward
- Harsh Forward

Clutch A Control PR Valve

- Downshift bind-ups • Flare shifts
- 4-5 Shift concerns
- Delayed/Harsh Forward

Replace with Sonnax Part Nos. **95740-08A** or **95740-21K** or **95740-09K** Requires F-95740-TL8 & VB-FIX

Solenoid Multiplex Valve

- Wrong gear starts • Gear ratio codes
- Replace with Sonnax Part No. **95740-04A**

Clutch D1 Latch Valve

- D Clutch burned • Slips on take off

Clutch E Control PR Valve

- Excess clutch overlap & distress
- Pressure control out-of-range codes
- 3-2 Harsh • Downshift bind-ups

Replace with Sonnax Part Nos. **95740-08A** or **95740-08K** Requires F-95740-TL8 & VB-FIX

Ensure that valve spool is centered in location to test.

Lubrication Control Valve

- Planetary/Bushing failure
- Lube failures • Overheating
- Low converter pressure

Replace with Sonnax Part No. **95740-11K** Requires F-95740-TL11 & VB-FIX

Bypass Clutch Control Regulator Valve

- TCC codes • Excess TCC slip
- Cycling RPM • Flare/Harsh shifts
- Low TCC release pressure

Replace with Sonnax Part No. **95740-13K** Requires F-95740-TL13 & VB-FIX

End Plugs

- Inconsistent shift quality
- Replace with Sonnax Part No. **95740-19K**

★ = Several Locations

Can be vacuum tested from the outside bore face. Use the large rubber cone found in many hand pump kits, or drill a hole through a rubber ball.

Main Pressure Regulator Valve

- Poor shift quality • Flare/Harsh shifts
- Erratic line pressure • Delayed Reverse

Replace with Sonnax Part Nos. **95740-44** or **95740-46K** Requires F-95740-TL & VB-FIX

Test 2: Test this port with valve in inverted position. Hold valve and spring in place with enclosed testing end plug.

Use Test End Plug

Converter Release Regulator Valve

- Excess TCC slip RPM & related codes
- Harsh TCC apply & release
- Low TCC release pressure

Replace with Sonnax Part Nos. **95740-05A** or **95740-05K** Requires F-95740-TL5 & VB-FIX

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Upper Valve Body • 6R80 (2015-Later) Shown



For specific vacuum test information, refer to individual part instructions included in kits and available at www.sonnax.com.

Click on Sonnax part numbers to see more information.

Accumulator Pistons

- Downshift clunk
- Firm shifts
- Erratic EDS solenoid control/EDS codes

Replace with **Sonnax Part No. 95740-15K**

OE accumulator pistons should be flush with or approximately .030" lower than the casting surface. It is common for the rubber insert to lose tension.

Each of these pistons can be vacuum tested from the exhaust hole on the opposite side of the casting.

End Plugs

- Inconsistent shift quality

Replace with **Sonnax Part No. 95740-19K**

Can be vacuum tested from the outside bore face. Use the large rubber cone found in many hand pump kits, or drill a hole through a rubber ball.

★ = Several Locations

Clutch C Regulator Valve

- 2nd & 6th Slip
- Clutch failure
- Poor shift quality
- Ratio errors

Replace with **Sonnax Part No. 95740-40K**

Requires F-95740-TL40 & VB-FIX

Clutch B Regulator Valve

- B Clutch burned
- 3rd & 5th Slips
- Slips in Reverse

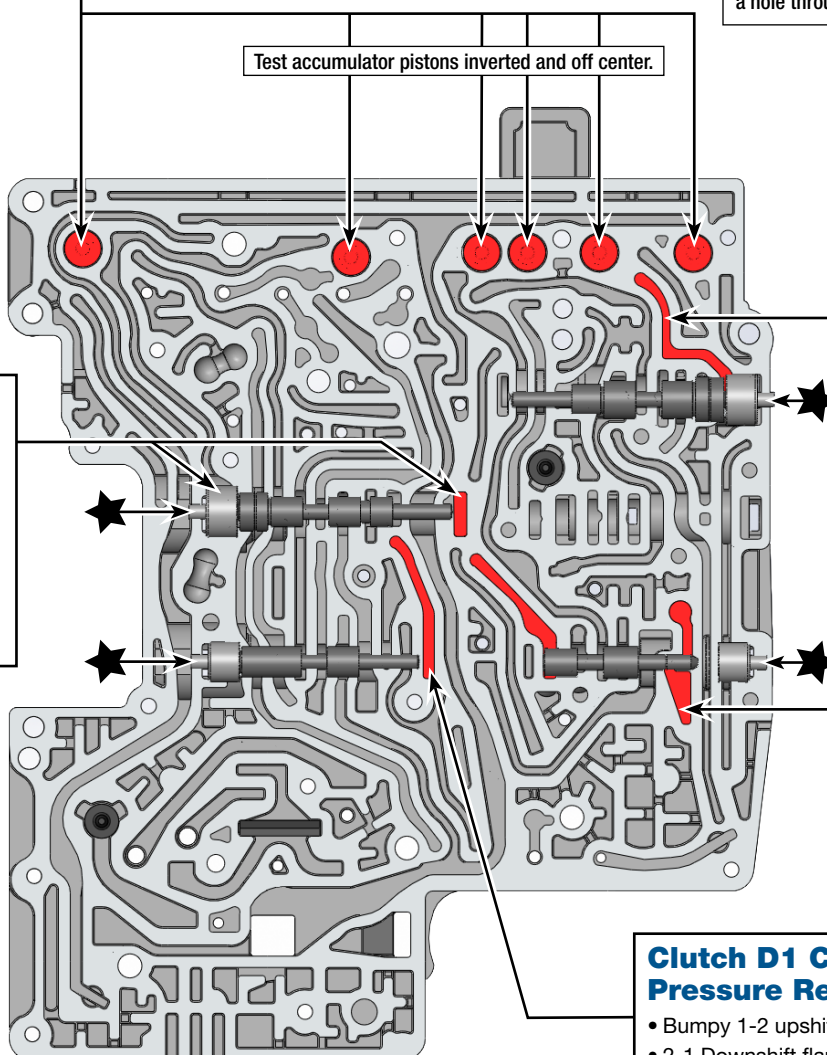
Clutch D2 Latch Valve

- Downshift clunk
- 1-2 Bind-up

Clutch D1 Control Pressure Regulator Valve

- Bumpy 1-2 upshift
- 2-1 Downshift flare or neutral
- EDS 3 control code

Replace with **Sonnax Part No. 95740-08A**

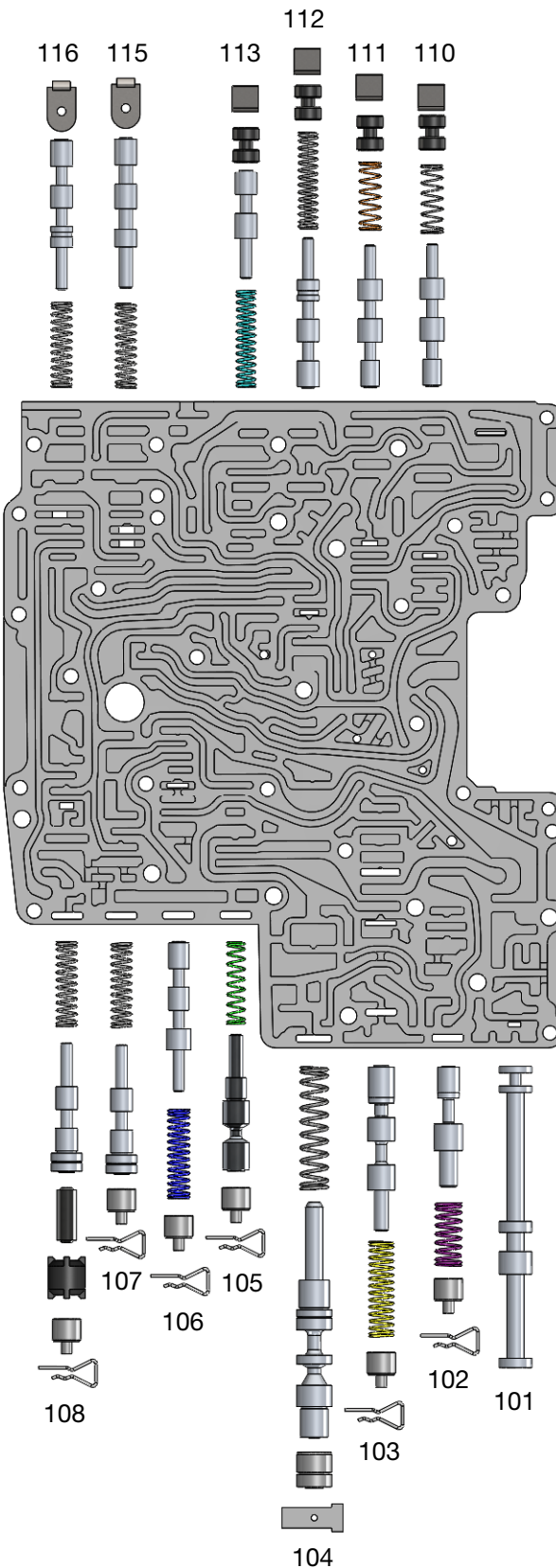


OE Exploded View

Lower Valve Body • 6R80 (2015-Later) Shown

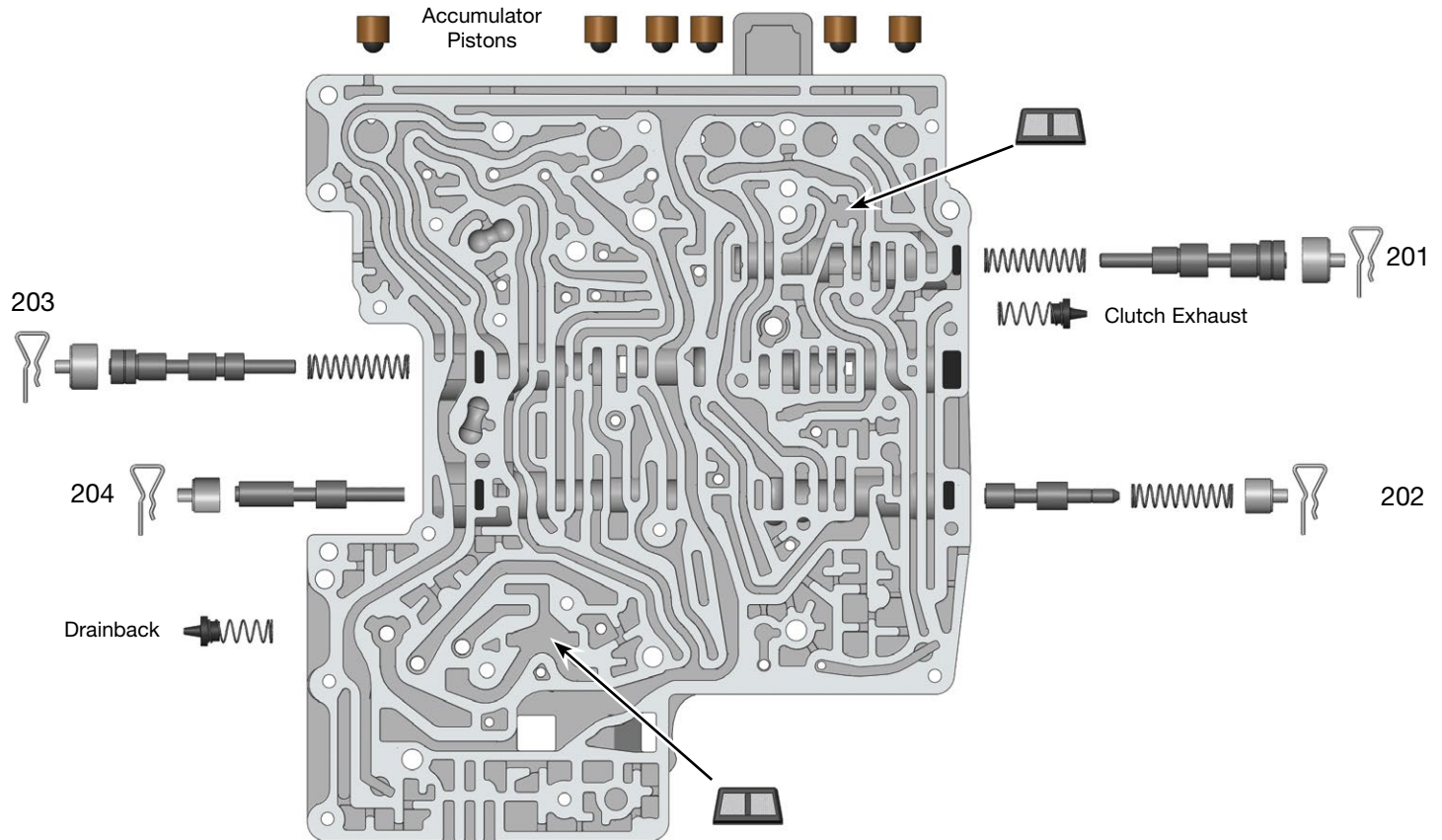
NOTE: Depending upon vehicle application, the OE springs shown may not be present.

Lower Valve Body Descriptions	
I.D. No.	Description
101	Manual Valve
102	Lubrication Control Valve
103	Converter Release Regulator Valve
104	Main Pressure Regulator Valve
105	Bypass Clutch Control Regulator Valve
106	Clutch E Latch Valve
107	Clutch E Control Pressure Regulator Valve
108	Clutch A Control Pressure Regulator Valve
110	Solenoid Multiplex Valve
111	Drive Enable Valve
112	Clutch D1 Latch Valve
113	Solenoid Pressure Regulator Valve
115	Clutch B Latch Valve
116	Clutch A Latch Valve



OE Exploded View

Upper Valve Body • 6R80 (2015-Later) Shown



Upper Valve Body Descriptions	
I.D. No.	Description
201	Clutch B Regulator Valve
202	Clutch D2 Latch Valve
203	Clutch C Regulator Valve
204	Clutch D1 Control Pressure Regulator Valve