

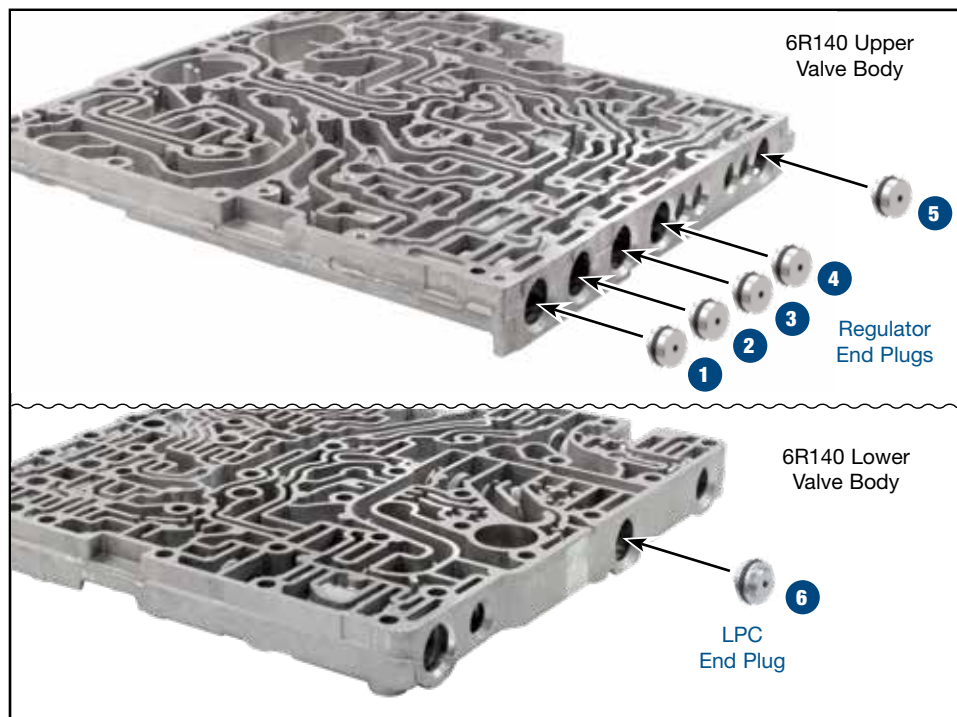
O-Ringed End Plug Kit

Part No.

126740-09K

- End Plugs, Regulator (5) 18mm
- O-Rings (8) 18mm, 3 Extra
- End Plug, LPC 20mm
- O-Rings (2) 20mm, 1 Extra

Ford 6R140



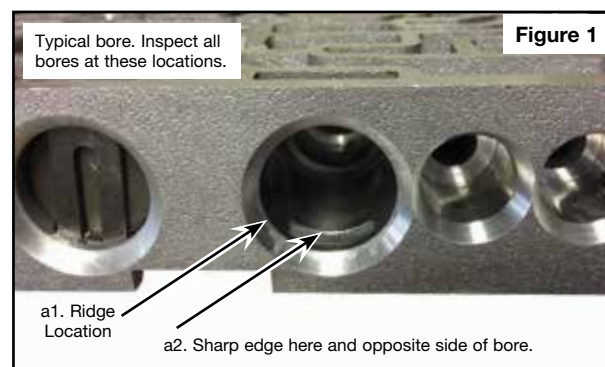
1. Disassembly

- Remove and discard OE end plugs for the five regulator valve bores in upper casting and line pressure control (LPC) valve bore in bottom casting.
- Set aside OE retainers for reuse.

2. Preparation

- Inspect each bore that will receive an O-ringed end plug for sharp edges. There are two locations where an O-ring may be damaged during installation (**Figure 1**):
 - Many valve bodies will have a small sharp ridge at bore entry. The ridge is difficult to see but can be located by carefully dragging a pick down the chamfer into the entry.
 - The inboard edges of the two openings (top and bottom) just inside the bores where the end plug retainers install are often sharp.
- Remove valve train to facilitate bore cleaning after ridge removal and breaking of sharp edges.
- Recommend using 3/8" diameter flap wheel chucked in miniature die grinder, but any method that removes ridges and breaks sharp edges without damaging bore is acceptable.

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Item #	Valve Bore	Location	Dia.
1	OD 4-5-6 Clutch Regulator	Upper Valve Body	18mm
2	INT 2-6 Clutch Regulator		
3	FWD 1-2-3-4 Clutch Regulator		
4	DIR 3-4-R Clutch Regulator		
5	L/R Clutch Regulator		
6	Line Pressure Control (LPC)	Lower Valve Body	20mm



WARNING: If ridge and sharp edges are not eliminated, O-ring will be damaged upon insertion into bore.

3. Installation & Assembly

- a. Clean bore thoroughly after using flap wheel. Reinstall valve train.



NOTE: Large O-rings fit 20mm LPC end plug; Small O-rings fit 18mm regulator end plugs.

- b. Lubricate O-ring with Sonnax Slippery-Stick **O-LUBE**. Roll O-ringed end plug on clean bench to size O-ring into groove.
- c. Position end plug in bore with tapped hole oriented outboard.
- d. Press and rotate end plug into bore in small incremental steps. This action allows O-ring to squeeze into place as it compresses in bore. Alternately, a small flat-bladed screwdriver inserted through the retainer port cavity may be used to help squeeze O-ring into bore.
- e. Install OE retainer. If end plug advanced beyond seating position in bore, carefully lever plug back until retaining clip contacts outboard face of plug.