

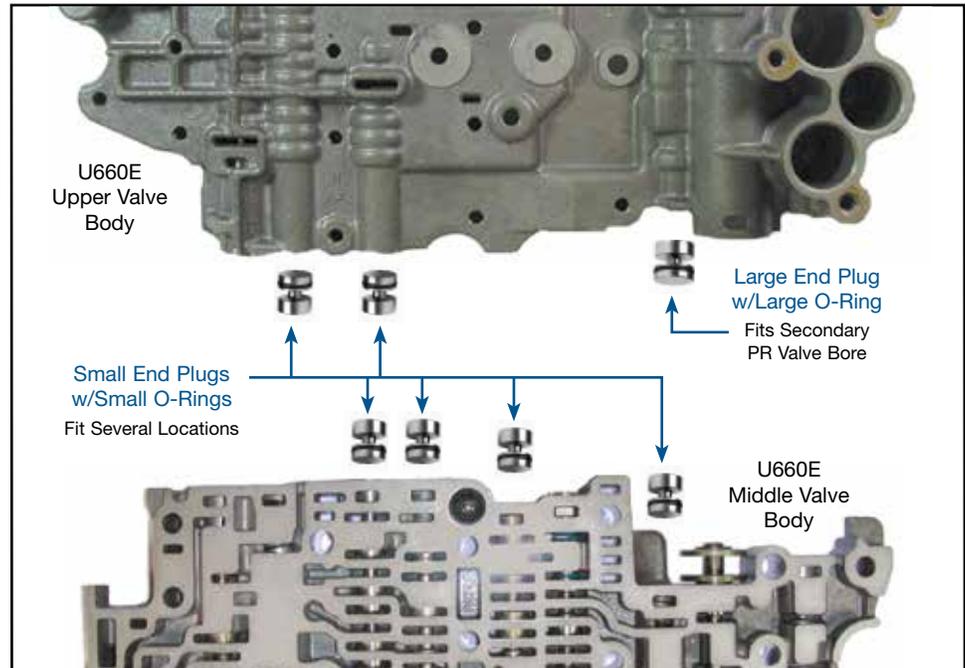
O-Ringed End Plug Kit

Part No.

47740-21K

- Small End Plugs (6)
- Small O-Rings (9) 3 Extra
- Large End Plug
- Large O-Rings (2) 1 Extra

Toyota/Lexus U660E, U660F, U760E, U760F



1. Disassembly

- a. Remove and discard OE end plugs.
- b. Save OE end plug retainers for reuse.

2. Small End Plug Installation & Assembly



NOTE: The large outer chamfer on the small end plug bores makes the outer bore too narrow for an O-ring to seal properly. The small Sonnax end plugs require the O-ring to seal at the bore inboard of the retainer port.

- a. Install Sonnax O-ring on Sonnax end plug in shallow groove.
- b. Lubricate the O-ringed plug with Sonnax Slippery Stick **O-LUBE** or equivalent. Roll the O-ringed plug on the bench to size the O-ring in the groove.
- c. To prevent O-ring shear during assembly, the sharp edge must be broken on the inboard retainer port edge. This can be done by inserting a narrow file or small screwdriver through the retainer port and reworking the edge.
- d. Carefully insert O-ringed plug into bore, O-ringed land inboard. A small, flat-bladed screwdriver inserted through the retainer port cavity may be used to help compress the O-ring into the bore.
- e. Carefully push O-ringed plug into the bore just far enough to reinstall the OE retainer.

3. Large End Plug Installation & Assembly

- a. Install O-ring on the end plug in the shallow groove.
- b. Lubricate the O-ringed end plug with Sonnax Slippery Stick™ O-LUBE or equivalent.
Roll the O-ringed plug on the bench to size the O-ring in the groove.
- c. Carefully insert O-ringed end plug into the bore, O-ringed land outboard.
- d. Carefully push O-ringed end plug into the bore just far enough to reinstall the OE retainer.

4. Final Testing

Vacuum testing at the port(s) indicated holds the recommended minimum 18 in-Hg.

