

**Oversized Bypass
Clutch Control
Valve Kit**



Part No.
95740-13K

- Valve
- Spring
- O-Ring
- End Plug

NOTE: Kit is NOT compatible with ZF6HP21/28/34 (Gen.2) units. To differentiate between Generation 1 and Generation 2 valve bodies, refer to ZF Identification Guide at www.sonnax.com.

Tool Kit

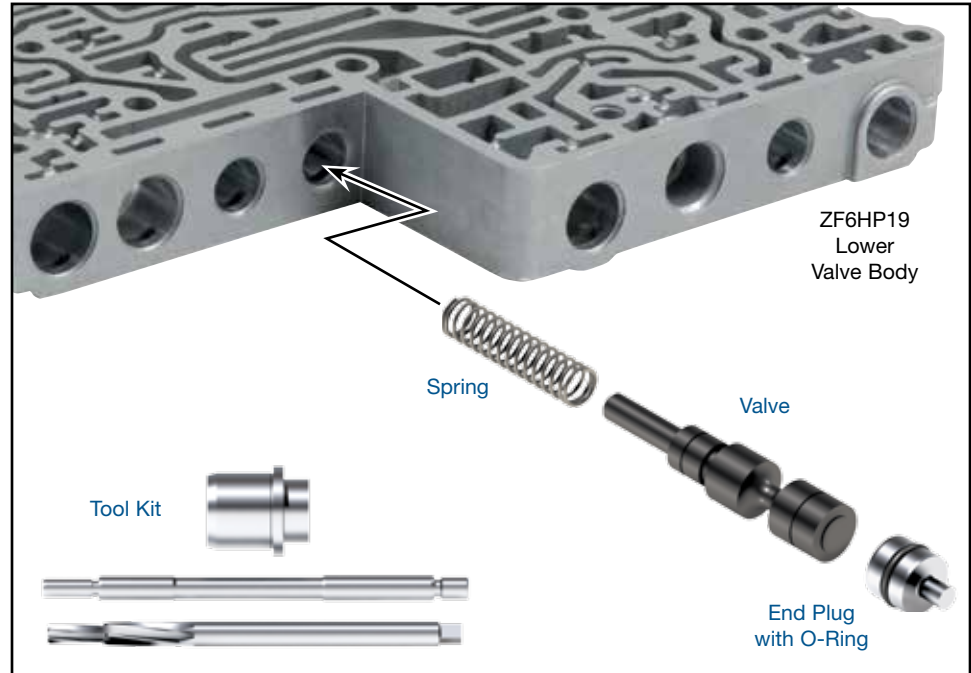


Part No.
F-95740-TL13

- 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.

Ford 6R60, 6R75, 6R80; ZF6HP19, ZF6HP26, ZF6HP32



1. Disassembly

- Remove and retain OE retaining clip and set aside for reuse.
- Remove and discard OE end plug, bypass clutch control valve and spring.

2. Bore Reaming

Ream bypass clutch control bore (for reaming instructions/reamer care, please visit www.sonnax.com). Sonnax reaming tool kit **F-95740-TL13** and **VB-FIX** are required for this operation.

3. Installation & Assembly

- Be certain all debris has been removed from the valve bore and valve body.
- Install Sonnax spring and oversized bypass clutch control valve, ensuring the spring I.D. goes over the valve nub.
- Install the O-ring into the groove on the Sonnax end plug and install the end plug followed by the OE retaining clip.

4. Final Testing

Vacuum testing at the port(s) indicated holds the recommended minimum 16 in-Hg.

