

## Pressure Switch Rebuild Kit

**Part No.**  
**144510-09K**

- O-Rings (4)
- D-Rings (4)
- Laminate Discs (4)
- Spacers (4) See Warning

Patent Pending



**WARNING:** Spacers should not be used on TEHCMs that have plastic fluid conduits; see page 2.

### 1. Disassembly

- Remove retaining screws and detach solenoid body cover plate (**Figure 1**).

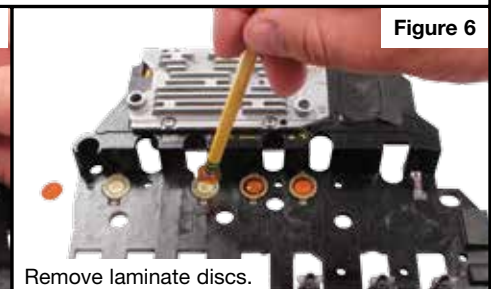
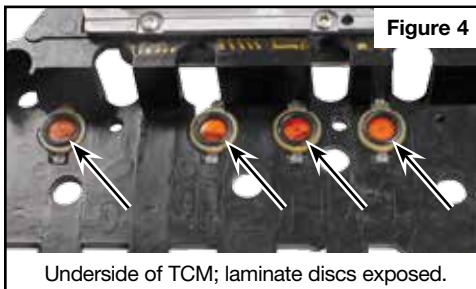
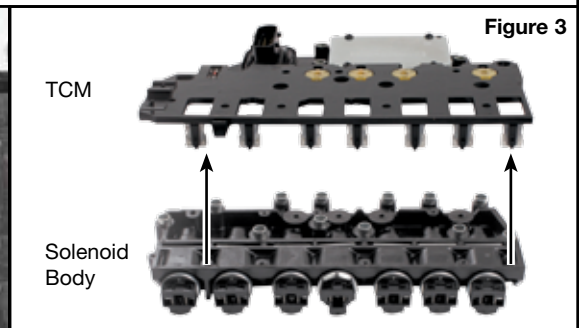
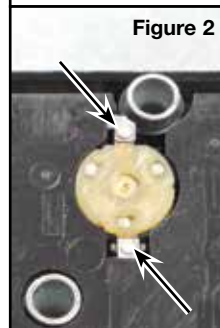
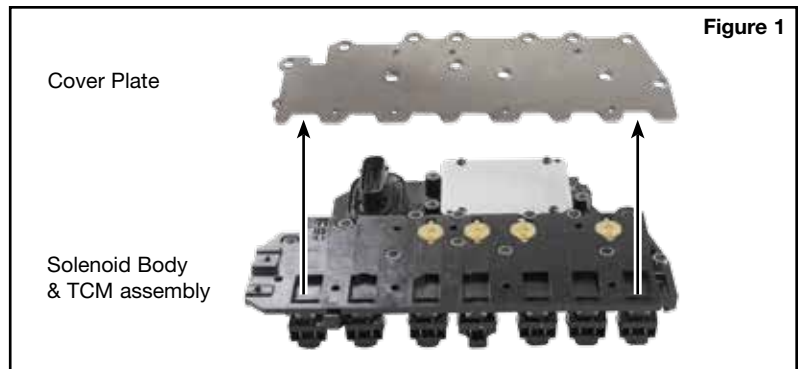
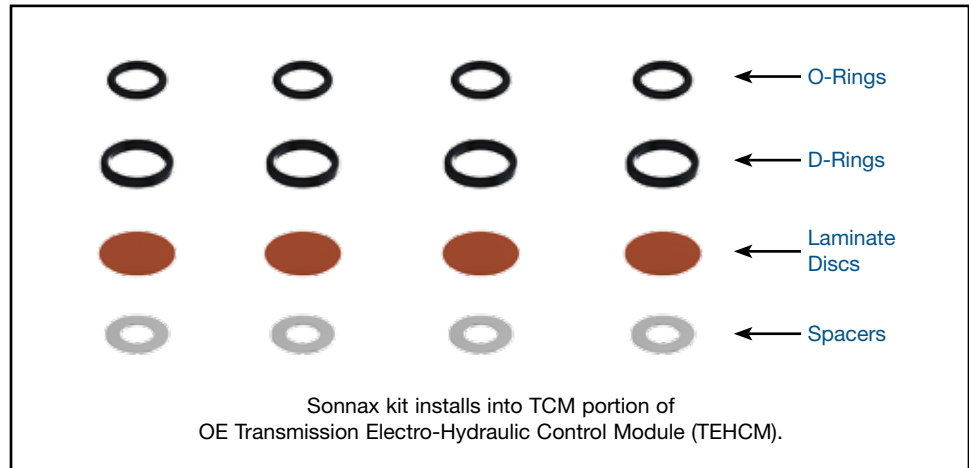


**NOTE:** Before installing Sonnax pressure switch rebuild kit, test switches to verify proper electrical operation.

Place ohmmeter leads on each side of pressure switch, outside of the rivet (**Figure 2**). Switches are normally closed and should read from about .5 to 10 ohms in their non-operated state. Pressing on the switch opens the contacts and should result in O.L. reading. If these tests fail, test resistance again at the switch side, before the rivet; loose rivets can cause circuit interruption. If testing is successful, proceed with installation of Sonnax kit.

- Separate solenoid body from TCM (**Figure 3**). Four pressure switch laminate discs are now exposed on underside of TCM (**Figure 4**).
- Remove D-rings from switches and discard (**Figure 5**).
- Using a pencil eraser dabbed with assembly gel, remove OE laminate discs from switches and discard (**Figure 6**).

## GM 6T40 (Gen. 1), 6T45 (Gen. 1), 6T50 (Gen. 1)



### 2. Installation & Assembly

- Ensure any dirt or debris is cleaned from switches before proceeding.
- Place Sonnax laminate discs on switches.
- Install Sonnax D-rings over laminate discs, flat side facing down. D-rings have slight interference fit; ensure they fit snugly into switch (**Figure 7**).

**NOTE:** Some solenoid bodies are equipped with plastic fluid conduits (**Figure 8**). If so equipped, remove conduits to expose O-rings (**Figure 9**). Replace O-rings with Sonnax O-rings and reinstall conduits.

- Reinstall solenoid body to TCM (**Figure 10**).

**WARNING:** Steps "e" and "f" apply only to units that DO NOT have plastic fluid conduits.

- With TCM still separated from the solenoid body, place Sonnax spacers over switches. A dab of assembly lube will help keep them in place during reassembly (**Figure 11**). These spacers assist in keeping appropriate support on switches with over-flexed terminals, which is vital to maintaining proper switch function.

**NOTE:** Use 6-32 screws and nut (not included) in eight locations to securely attach cover plate to TCM housing (**Figure 12**). Check for continuity of each pressure switch at the terminals. Remove spacers from any switches indicating too much preload (outside the .5 to 10 ohms range).

**WARNING:** Do NOT install Sonnax spacers into units equipped with plastic fluid conduits!

- Reinstall solenoid body cover plate and secure with retaining screws (**Figure 1**).

