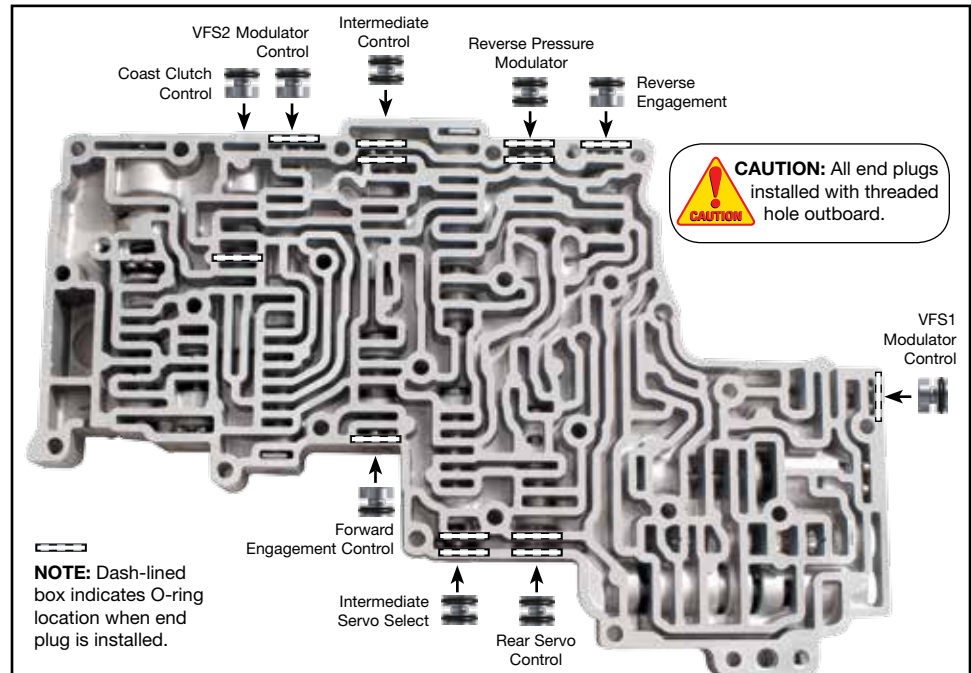


**O-Ringed
End Plug Kit**

**Part No.
56947J-66K**

- Single O-Ringed End Plugs (5)
- Double O-Ringed End Plugs (4)
- O-Rings (15) 6 extra

Ford 5R55W/S



Bore Location	Single O-Ring	Double O-Ring
Coast Clutch Control	X	
VFS2 Modulator Control	X	
Intermediate Control		X
Reverse Pressure Modulator		X
Reverse Engagement	X	
VFS1 Modulator Control	X	
Forward Engagement Control	X	
Intermediate Servo Select		X
Rear Servo Control		X

1. Disassembly

- a. Use chart to determine if a single or double O-ring end plug is required for each bore.
- b. Remove and discard OE end plugs.
- c. Keep OE plug retainers for reuse.

2. Preparation

Install a Sonnax O-ring into each shallow groove on the Sonnax end plugs.

NOTE: Five end plugs have one shallow groove and the other four end plugs have two shallow grooves (see chart). Extra O-rings are included in case any are damaged during installation into the bore.

3. Installation

- a. Use a small amount of Sonnax Slippery Stick™ O-LUBE or equivalent to lubricate the O-ring, end plug and bore.
- b. Position the end plug into the bore with the threaded hole oriented outboard.

NOTE: Use a #8-32 bolt, about three inches long, threaded into the tapped hole in the end plug face to control the movement of the end plug as the O-ring(s) are introduced into the bore.

- c. Press and rotate the end plug into the bore in small incremental steps. Apply pressure as you rotate the end plug, then ease off the pressure while preventing the end plug from moving backwards. This action allows the O-ring to squirm into place as it compresses into the bore.
- d. Reinstall OE plug retainers.