

O-Ringed End Plug Kit

15741-35K

5 Small End Plugs 9mm
7 Small O-Rings

15741-36K

5 Large End Plugs 11mm
7 Large O-Rings

Note: Fits Opel (AF40); Volvo (AM6); Peugeot (TF80) Saab (AF40/6); Land Rover (TF80); Mazda (AW6A-EL); Ford (AF21); BMW (6F21WA); VW/Audi (09G, 09K, 09M).

Also Available

OR-59947A-25

25 Small O-Rings 9mm

OR-59947B-25

25 Large O-Rings 11mm

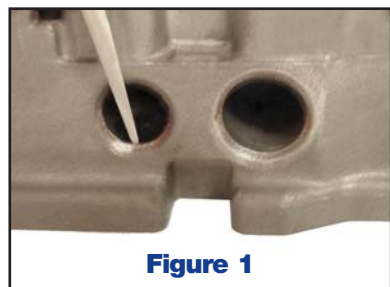
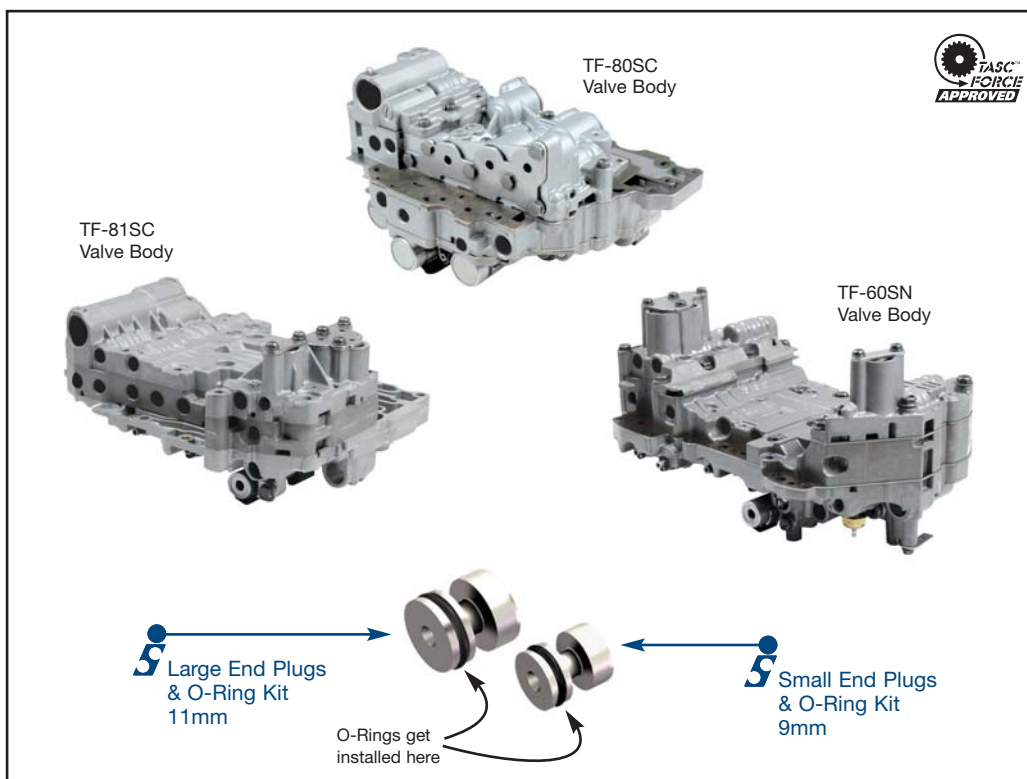


Figure 1

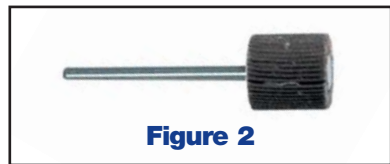


Figure 2

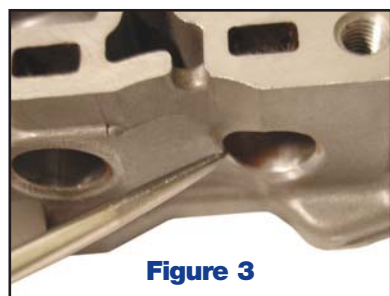


Figure 3

Disassembly Steps:

Remove and discard the OEM end plugs. Keep the OEM plug retainer for re-use with the new end plug.

Preparing the valve body for O-ring end plug installation.

1. Inspect the bore entry surface for a ridge, just inboard of the end or chamfer. The ridge is difficult to see with the naked eye but can be felt by carefully dragging a sharp pick out the bore and down the chamfer (see Figure 1).
2. Ridges must be removed. Use a 3/8" diameter flap wheel (see Figure 2) chucked in a miniature die grinder to smooth the transition from the chamfer into the bore.
3. Use de-burring tool or bearing scraper to complete the .020" to .030" wide chamfer all the way around the bore edge where the valve body contour may have caused the factory chamfer to be less than a full circle (see Figure 3).
4. Thoroughly clean the valve body prior to assembly.

Installation/Assembly Steps:

1. Install the appropriate valve train into the

valve body bore.

2. Install the o-ring into the shallow groove that is close to one end of the plug (see main photo).
3. Use a small amount of P-80 Temporary Rubber Lube, O-LUBE™, Trans-lube™, or new ATF / STP mix to lubricate the o-ring, end plug and valve body chamfer.
4. Start the end plug into the bore with the o-ring outboard. In all the bores, the o-ring seals on the first land just inside the bore opening.
 - Use a small flat bladed screwdriver, inserted through the retainer post cavity, to control the movement of the end plug as the o-ring compresses into the bore.
 - Do not allow the o-ring to travel beyond the first segment of the bore, as the o-ring will be destroyed by the sharp edges of the intersecting retaining post cavity.
 - Using a brass or wood drift carefully press the end plug into the bore, working in slow incremental steps that will allow the o-ring to enter and advance into the contour without damage.
5. Install the retainer post.