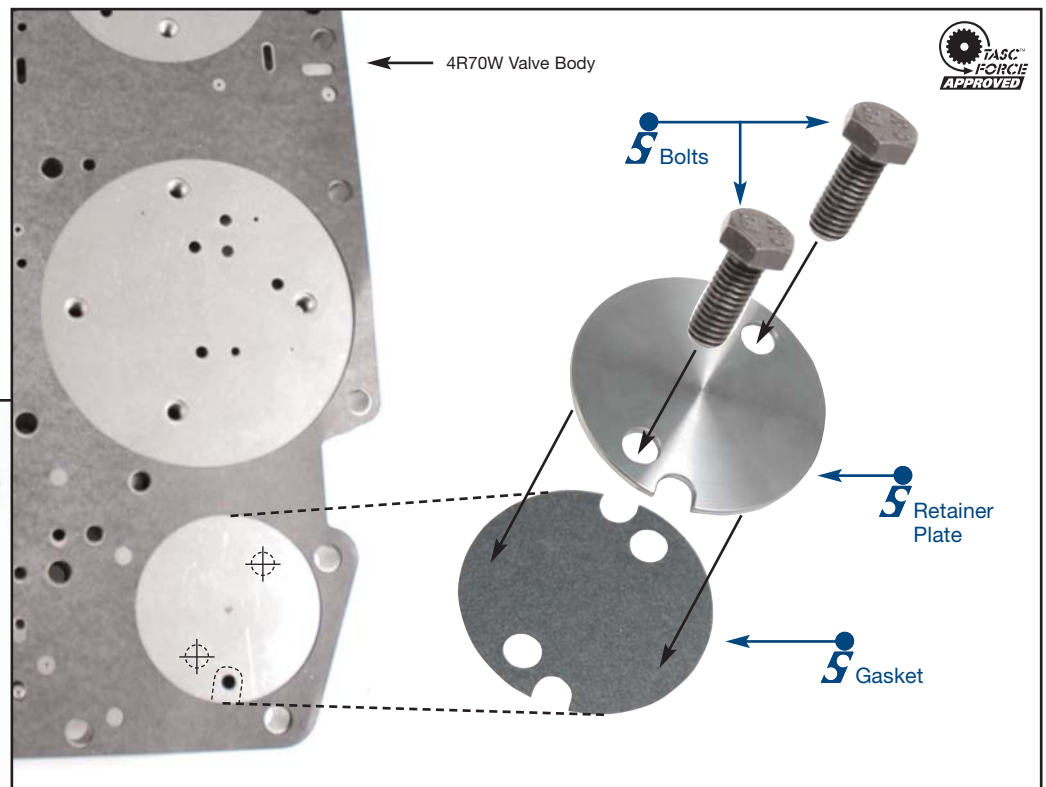
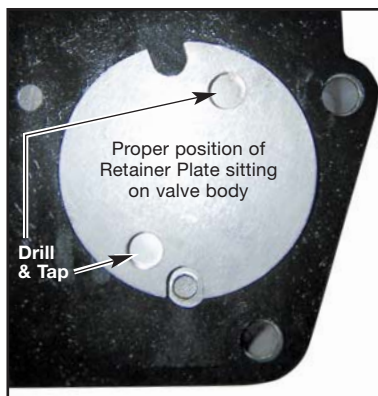


## Valve Body Retainer Plate

### 76507F-01K

1 Retainer Plate  
1 Gasket  
2 Bolts



### Installation and Assembly Steps

#### Tools Required:

$\frac{13}{64}$ " or #9 drill bits (sharp),  $\frac{1}{4}$ " drill bit,  $\frac{5}{16}$ " drill bit, 6.0mm x 1.0mm thread tap.

#### Preparation:

1. Install the separator plate onto the valve body & align the plate with the original alignment bolts.
2. Locate the two cast in-place bolt hole locations on underside of valve body (see Figure 1).
3. In a drill press use  $\frac{5}{16}$ " drill bit to clean up the cast in-place bolt hole locations and establish a true center for drilling further with the  $\frac{13}{64}$ " or #9 drill.

**Warning:** Do NOT drill deeper than  $\frac{1}{16}$ " with the  $\frac{5}{16}$ " drill bit! (see Figure 2).

4. After true center is established, use a  $\frac{13}{64}$ " or #9 drill to drill all the way through the valve body AND the separator plate with a piece of wood underneath to prevent the plate from deforming as the drill bit cuts through.
3. Remove the separator plate and enlarge the two drilled holes in the separator plate by re-drilling with a  $\frac{1}{4}$ " drill bit. De-burr the new holes in the separator plate.
4. With a 6.0 x 1.0mm thread tap, cut new threads in the drilled holes in the valve body. De-burr the gasket surface, making sure there are no high spots from the drilling/tapping operations.

#### Installation:

1. Assemble the valve body, lower valve body gasket, separator plate using normal procedures.
2. Install the Sonnax gasket, valve body retainer plate and two screws. Tighten screws to 80-100 lb-in (9-11 Nm).

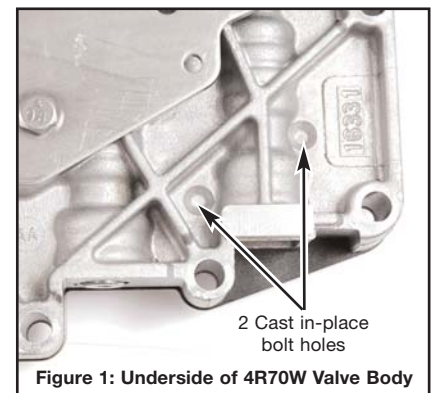


Figure 1: Underside of 4R70W Valve Body

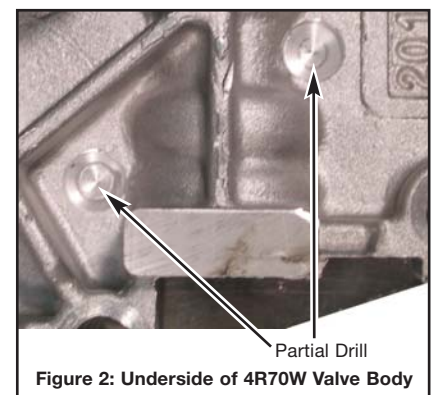


Figure 2: Underside of 4R70W Valve Body