

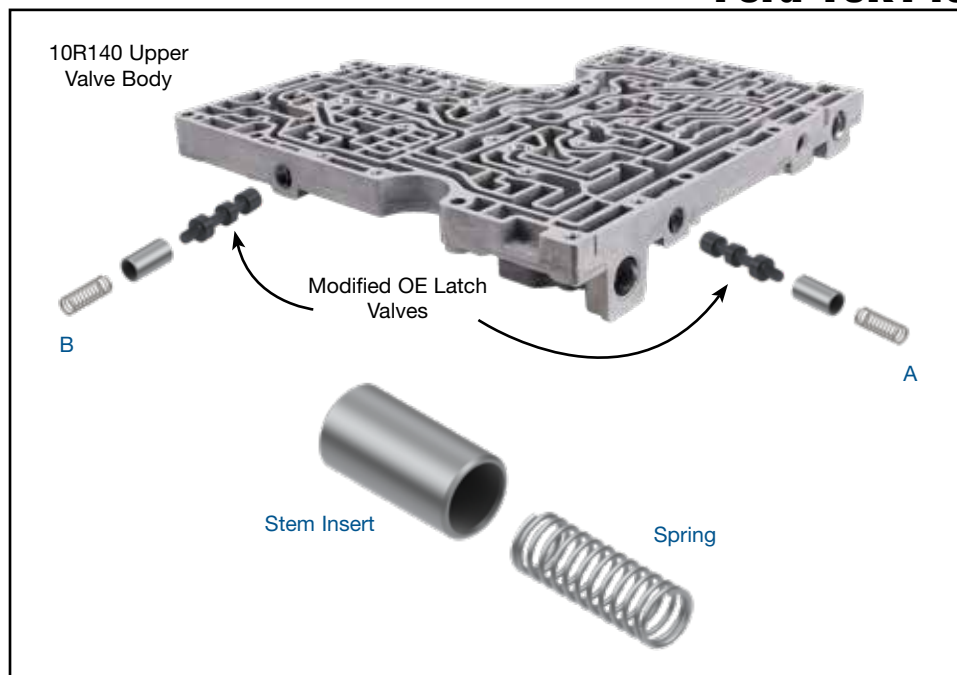
Latch Valve Stem Repair Kit

Part No.

105740-50K

- Stem Inserts (2)
- A & B Springs (2)

Ford 10R140



1. Disassembly

- Remove OE retaining clips and set aside for reuse.
- Remove OE springs and discard.
- Remove OE valves and set aside for maintenance.

2. Modify OE Latch Valves

- Measure between 0.65– 0.75" (cutting zone) from the base of the valve stem (**Figure 1**).
- Using a pair of needle nose pliers/vice grips, grip the valve on the spring stem at the base of the critical spool (**Figure 2**).



NOTE: Gripping the valve anywhere else during the modifying process can result in a bent valve or raised burrs/edges.

- Cut and/or grind the valve stem in the cutting zone.
- Grind a chamfer/edge break on the new edge of the valve stem to remove any burrs or sharp edges.
- Clean debris from the valve.

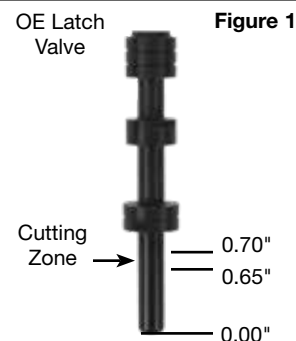


Figure 1

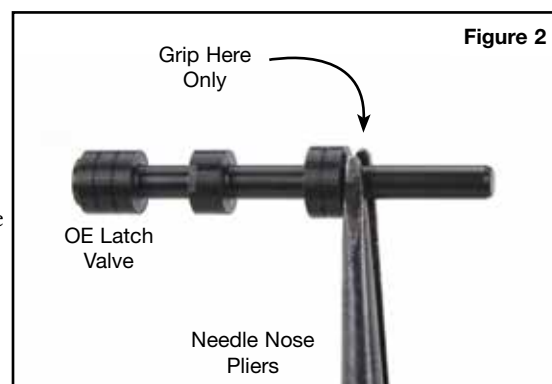


Figure 2

2. Modify OE Latch Valves (*continued*)

- f. Verify that the flat face of the plug contacts the flat face of the critical spool of the valve. If they don't contact, valve stem is still too long and will need to be shortened (**Figure 3**).

3. Installation & Assembly

- Install one OE modified valve into each bore.
- Install one Sonnax stem insert into each bore.
- Install a Sonnax spring into each bore and reinstall OE retaining clips.

