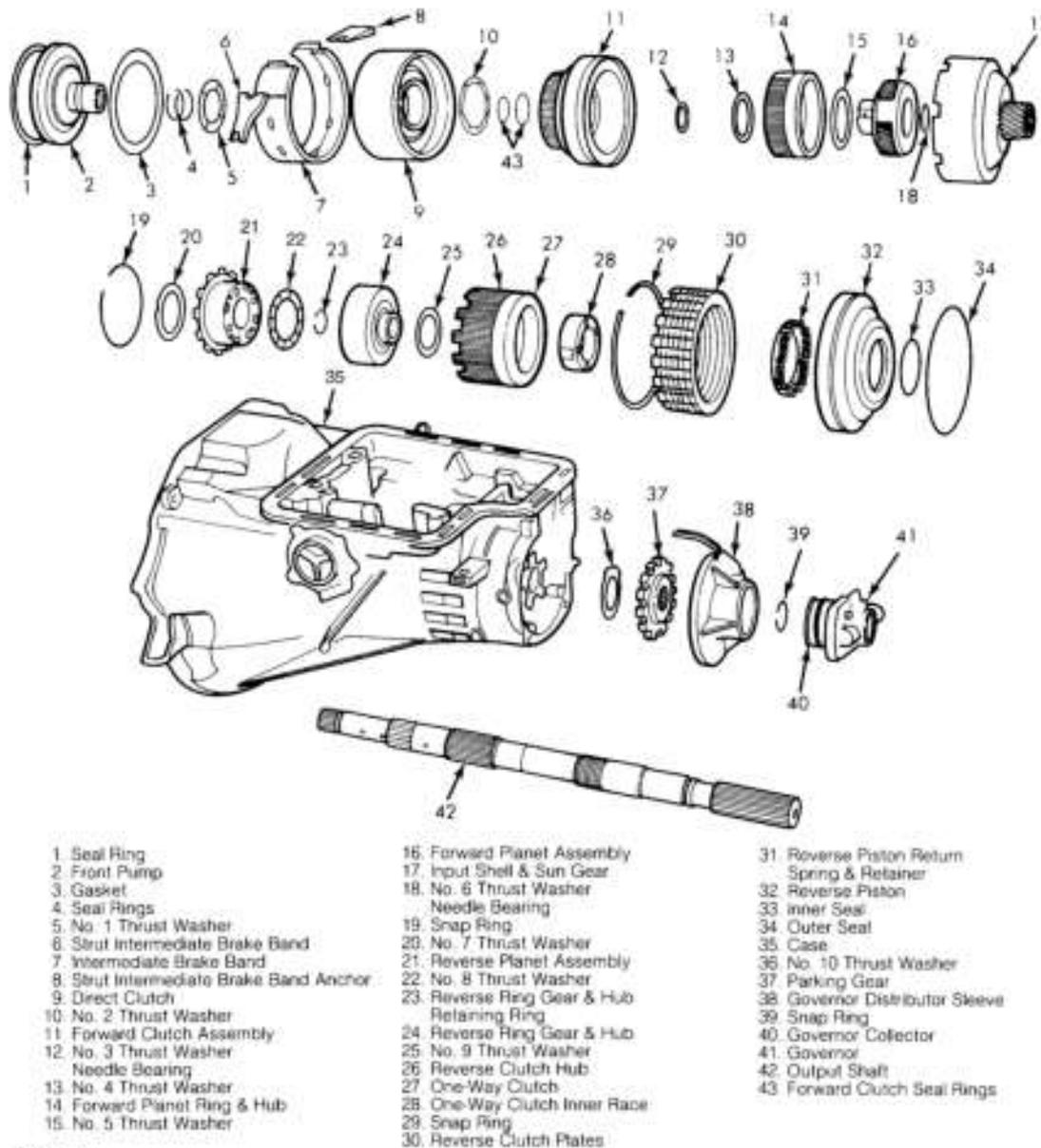


TRANSMISSION REASSEMBLY

1. With transmission mounted in fixture, tap low-reverse clutch piston into case using soft mallet. Install low-reverse clutch return spring and retainer assembly in clutch piston. Hold one-way clutch inner race in position, and install and tighten retaining bolts to specification. See **TORQUE SPECIFICATIONS.**
2. Place transmission case on bench with front end facing downward. Position parking gear thrust washer and gear on case. It is not necessary to restake thrust washer. Position oil distributor and tubes on rear of case.
3. Install and tighten retaining bolts. Install output shaft and governor as an assembly. See **Fig. 27.** Place a NEW gasket on rear of case. Install extension housing and retaining bolts. Tighten bolts to specification.



GR2H1494E

Fig. 27: Exploded View Of Transmission Case & Drive Train Assembly

Courtesy of FORD MOTOR CO.

4. Coat NEW servo cover gasket with petroleum jelly and position it on servo cover. Place servo spring on piston rod and install in case. Install retaining bolts. Ensure identification tag is under one of the cover bolts and tighten. Align low-reverse clutch hub and one-way clutch with inner race at rear of case.

NOTE: Soak friction plates in ATF for 15 minutes before installing.

5. Rotate low-reverse clutch hub clockwise while applying pressure to seat it on inner race. Install low-reverse clutch plates, starting with the waved plate next to the piston. Follow with a steel plate, and then a friction plate, until all plates are installed.
6. Retain plates with petroleum jelly. Install pressure plate and snap ring. Test operation of low-reverse clutch assembly by applying air pressure to low-reverse clutch pressure apply hole in case. See **Fig. 8**.
7. Install reverse planet ring gear thrust washer, ring gear and hub assembly. Install snap ring in groove of output shaft. Install front and rear thrust washers onto reverse planet assembly. Retain with petroleum jelly.
8. Install assembly into ring gear, and install snap ring. Place reverse-high clutch on bench with front end facing downward. Install thrust washer on rear end of assembly and retain washer with petroleum jelly.
9. Install splined end of forward clutch into open end of reverse-high clutch with splines engaging direct clutch plates. Install thrust washer on front end of forward planet ring gear and hub. Retain with petroleum jelly.
10. Install ring gear into forward clutch. Install thrust washer on front end of forward planet assembly and retain with petroleum jelly. Install assembly into ring gear. Install input shell and sun assembly. Install reverse-high clutch, forward clutch, forward planet assembly, input shell and sun gear as an assembly into case.
11. Install intermediate band around direct clutch drum. Install band struts and tighten band adjustment screw enough to retain band. Place selective bronze thrust washer on rear shoulder of stator support and retain with petroleum jelly. See **STATOR SUPPORT SELECTIVE THRUST WASHERS**.
12. If end play was not within specifications when disassembled, replace washer at this time with one of proper thickness. Ensure transmission end play is .008-.044" (.20-1.12mm)

STATOR SUPPORT SELECTIVE THRUST WASHERS

Color Code	Thickness In. (mm)
Blue	.056-.060 (1.42-1.52)
Natural (White)	.073-.077 (1.85-1.96)
Red	.088-.092 (2.24-2.34)

13. Using 5/16" x 3" bolts, make 2 alignment studs by cutting heads off and grinding a taper on cut end. Install studs opposite each other in case mounting holes.
14. Slide a NEW gasket onto studs. Position front pump on case, being careful not to damage seal on pump housing, and remove studs. Install 6 of the mounting bolts and tighten to specification.
15. Tighten intermediate band adjustment screw to specification. Back off screw 1 1/2 turns. Hold adjustment screw in this position and tighten lock nut to specification. See **TORQUE SPECIFICATIONS**.
16. Install input shaft with long splined end inserted into forward clutch assembly. Measure end play again to ensure correct assembly. Install control valve body into case, ensuring levers engage valves

properly.

17. Install primary throttle valve, rod and vacuum diaphragm in case. Install oil pan with NEW gasket. Install retaining bolts and tighten to specification. Install torque converter.