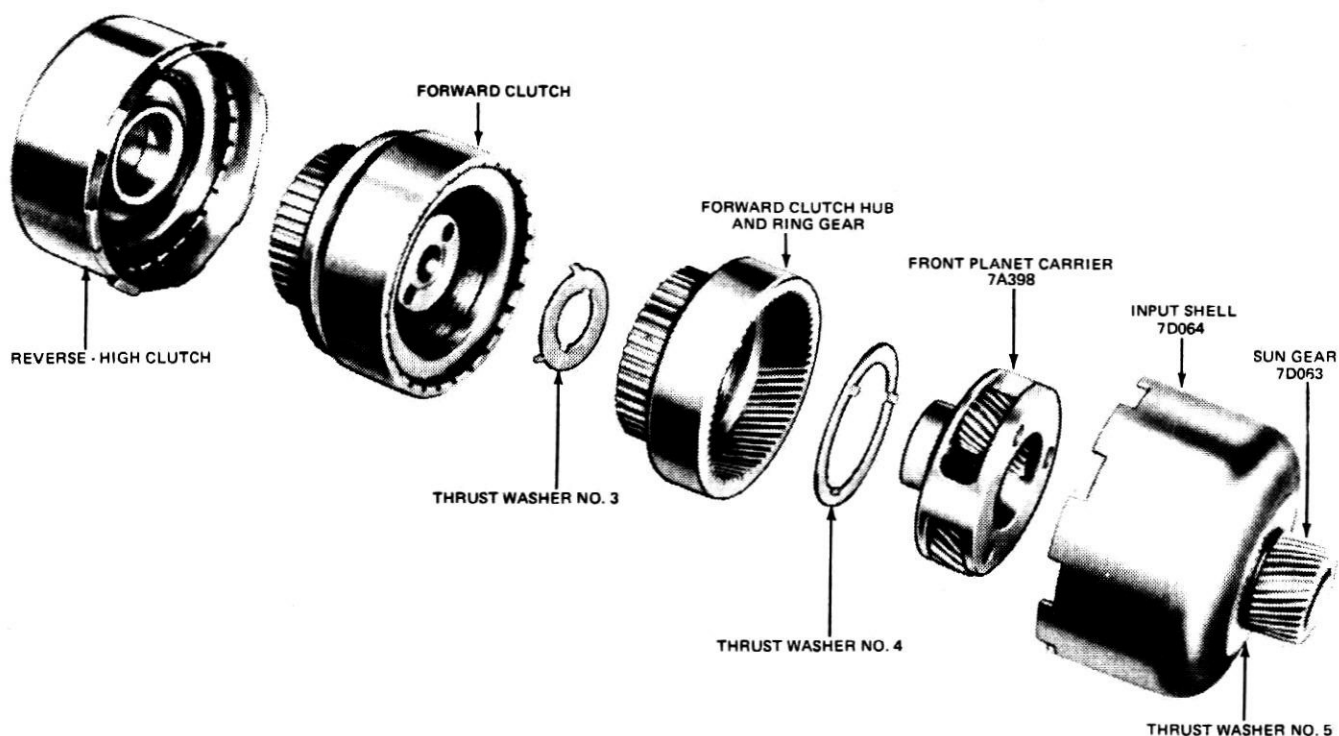
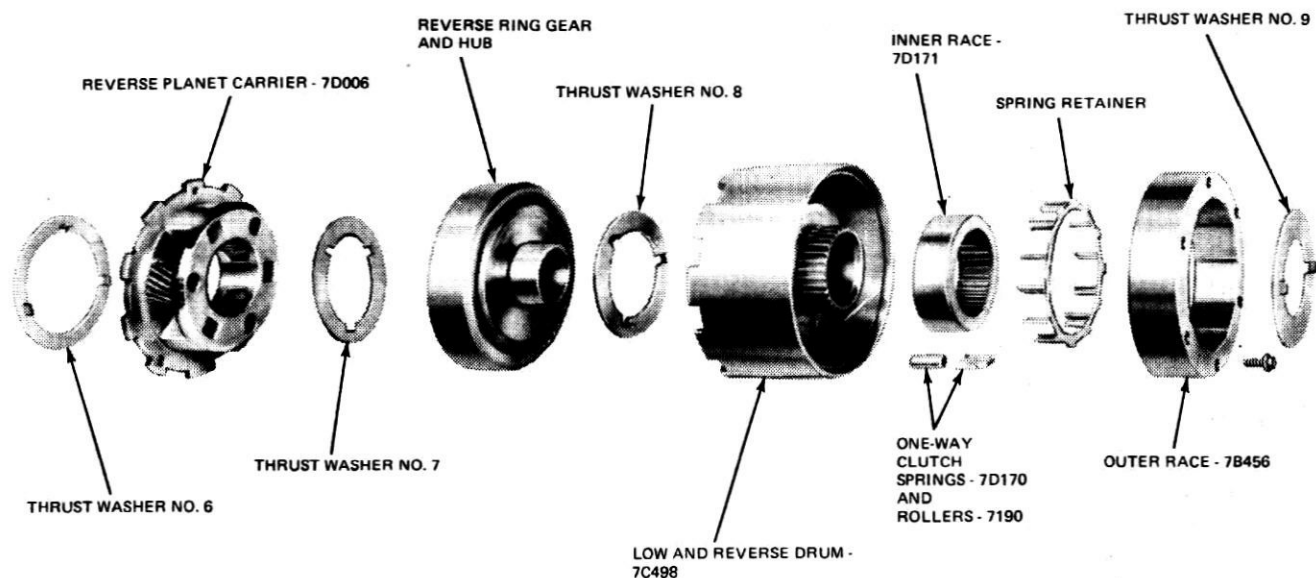




D1872-2A

FIG. 26 Forward Part of Gear Train Disassembled

D1394-2B

FIG. 27 Lower Part of Gear Train Disassembled

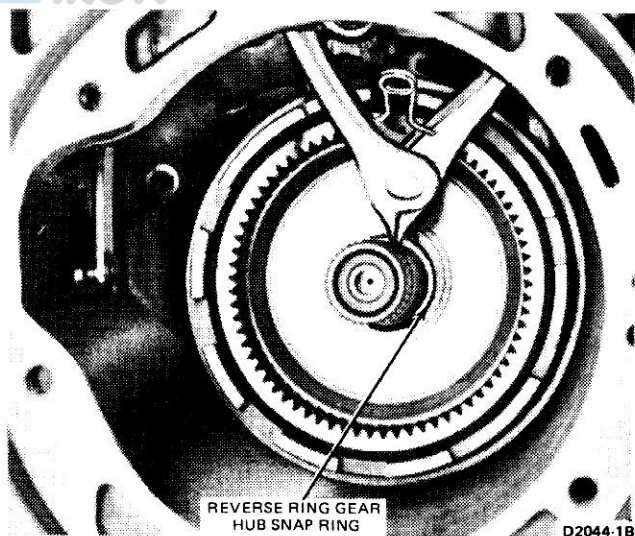


FIG. 28 Removing or Installing Reverse Ring Gear Hub Snap Ring

parking pawl on the case retaining pin, and the parking pawl return spring as shown in Fig. 38.

4. Install thrust washer No. 10 on the parking gear (Fig. 39). Place the gear and thrust washer on the back face of the case (Fig. 38).
5. Place the two distributor tubes in the governor distributor sleeve. Install the distributor sleeve on the case. As the distributor sleeve is installed, insert the tubes in the two holes in the case and insert the parking pawl retaining pin in the alignment hole in the distributor sleeve.
6. Install the four governor distributor sleeve-to-case attaching bolts and torque the bolts to specification, as listed at the end of this Part.
7. Install the governor distributor assembly on the output shaft. Install the distributor snap ring (Fig. 31).
8. Check the rings in the governor distributor, making sure the rings are fully inserted in the ring grooves

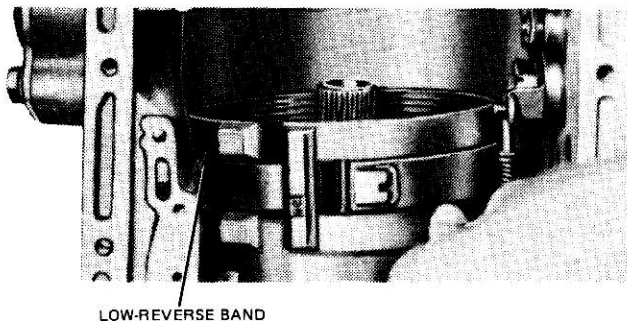


FIG. 29 Removing or Installing Low-Reverse Band

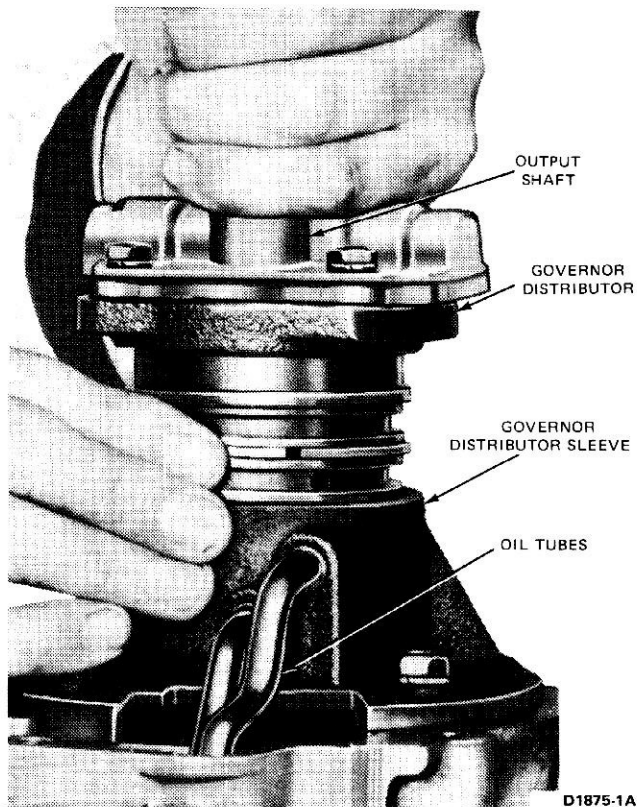


FIG. 30 Removing or Installing Output Shaft and Governor Distributor

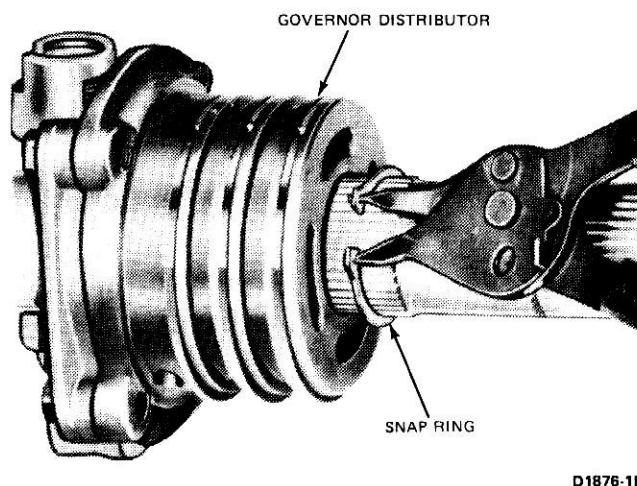


FIG. 31 Removing or Installing Governor Distributor Snap Ring

and rotate freely. Install the output shaft and governor distributor assembly in the distributor sleeve (Fig. 30).

9. Place a new extension housing gasket on the case. Install the extension housing, vacuum tube clip and the extension housing-to-case attaching bolts. Torque the bolts to specification, as listed at the end of this Part.
10. Place the transmission in the holding fixture. Rotate the holding fixture to put the transmission in a vertical position with the front pump mounting face

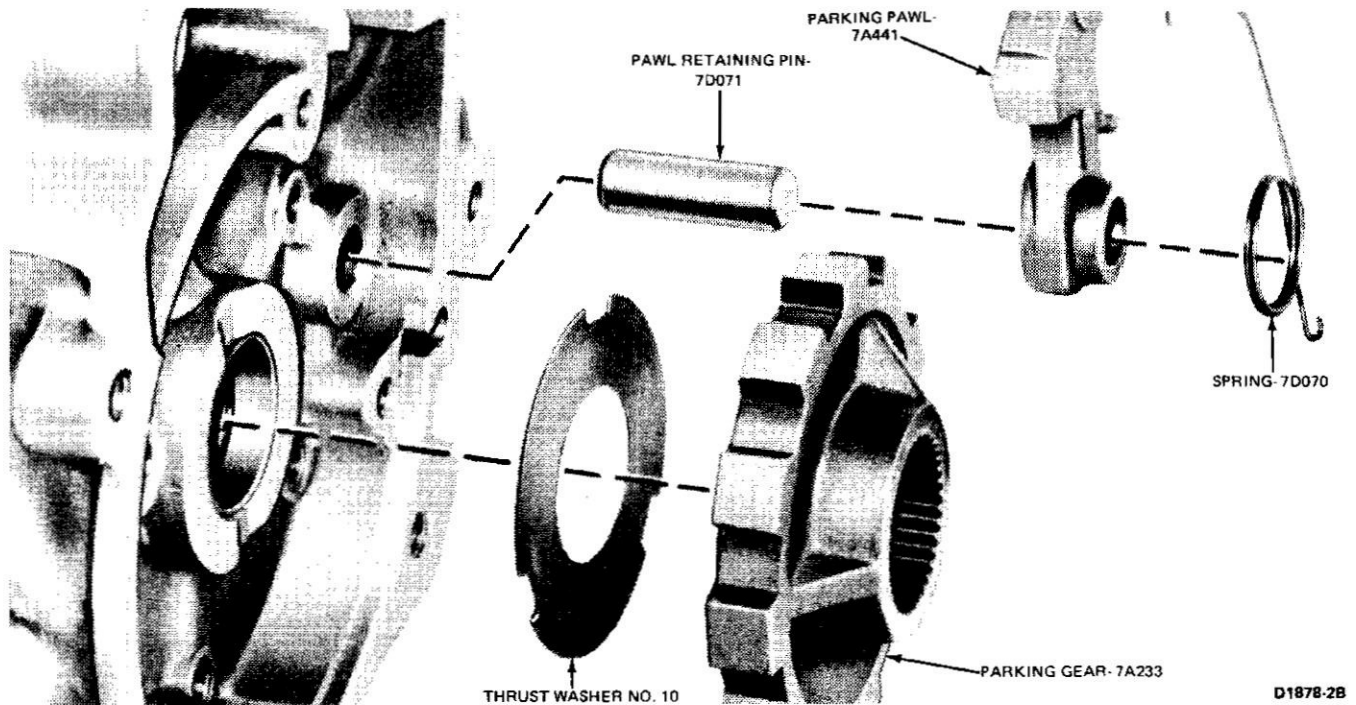


FIG. 32 Parking Pawl, Return Spring Retaining Pin and Gear

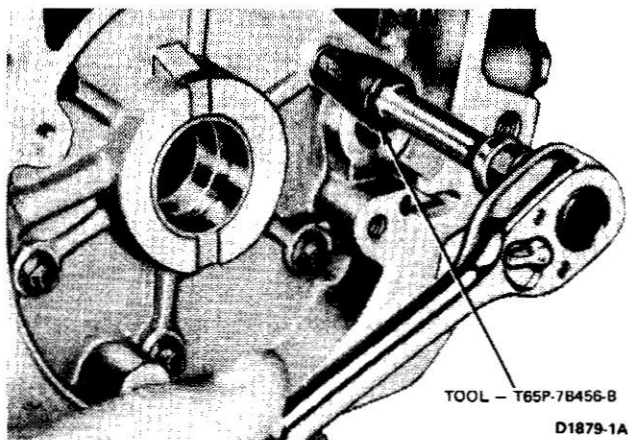


FIG. 33 Removing One-Way Clutch Outer Race Attaching Bolts

up. Make sure thrust washer No. 9 is still located at the bottom of the transmission (Fig. 36).

11. Install the one-way clutch spring retainer into the outer race (Fig. 40). Install the inner race inside of the spring retainer. **Be sure the face with the step is installed toward the rear of the case, mating with the thrust washer.**
12. Install the twelve springs between the inner and outer race as shown in Fig. 40. Install the twelve one-way clutch rollers by slightly compressing each spring and positioning the roller between the spring and the spring retainer. Rotate the inner race clockwise, after assembly, to center the rollers and springs.
13. Install the low and reverse drum (Fig. 27). The splines of the drum have to engage with the splines of the one-way clutch inner race. Check the one-way clutch operation by rotating the low and reverse drum. The drum should rotate clockwise but not rotate counterclockwise.

14. Install thrust washer No. 8 on top of the low and reverse drum (Fig. 41). Install the low-reverse band in the case, with the end of the band for the small strut toward the low-reverse servo (Fig. 29).
15. Install the reverse ring gear and hub on the output shaft. Move the output shaft forward and install the reverse ring gear hub-to-output shaft snap ring (Fig. 28).
16. Place thrust washers No. 6 and 7 on the reverse planet carrier (Fig. 42).
17. Install the planet carrier in the reverse ring gear and engage the tabs of the carrier with the slots in the low-reverse drum.
18. On the bench, install the forward clutch in the reverse-high clutch. Rotate the units to mesh the reverse-high clutch plates with the splines of the forward clutch (Fig. 43).
19. Using the recorded dial indicator readings obtained during transmission disassembly, determine which No. 2 steel-backed thrust washer is required and proceed as follows:
 - a. Position the stator support vertically on the work bench and install the correct No. 2 thrust washer, or combination of washer and spacer, as required to bring the end play within limits of 0.008 to 0.042 inch.
 - b. Install the reverse-high clutch and the forward clutch on the stator support.
 - c. Invert the complete unit making sure that the intermediate brake drum bushing is seated on the forward clutch mating surface.
 - d. Select the thickest plastic washer (No. 1) that can be inserted between the stator support and the intermediate brake drum thrust surfaces and still maintain a slight clearance. **Do not select a washer that must be forced between the stator support and intermediate brake drum.**