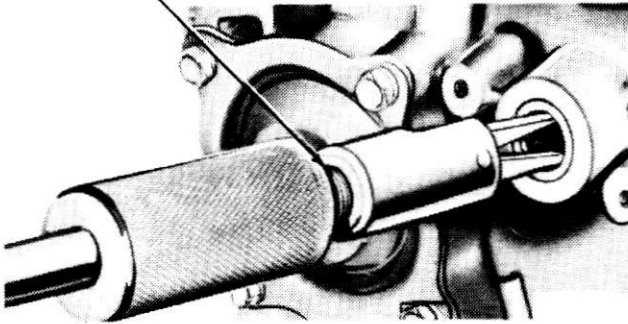


TOOL—T59L100-B or T58L-101-A



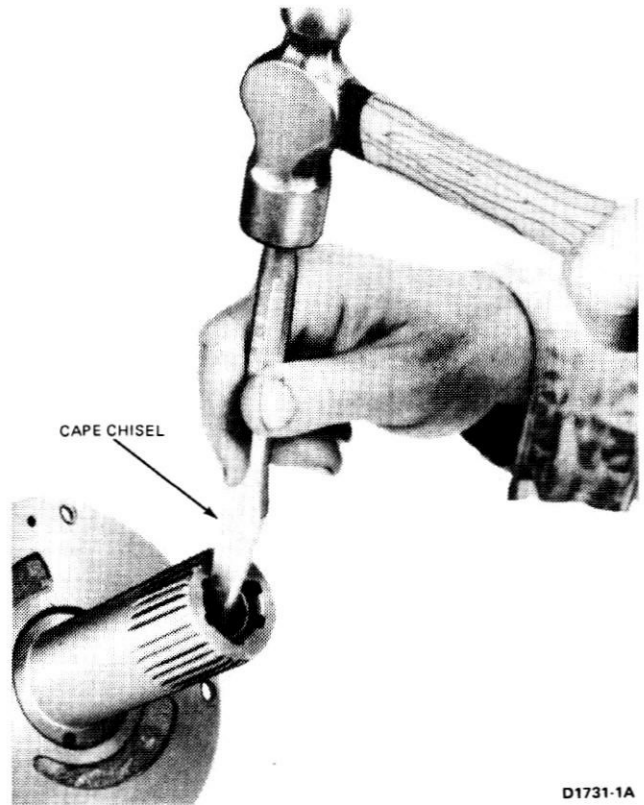
D1888-1B

FIG. 62 Removing Manual Lever Seal

Assembly

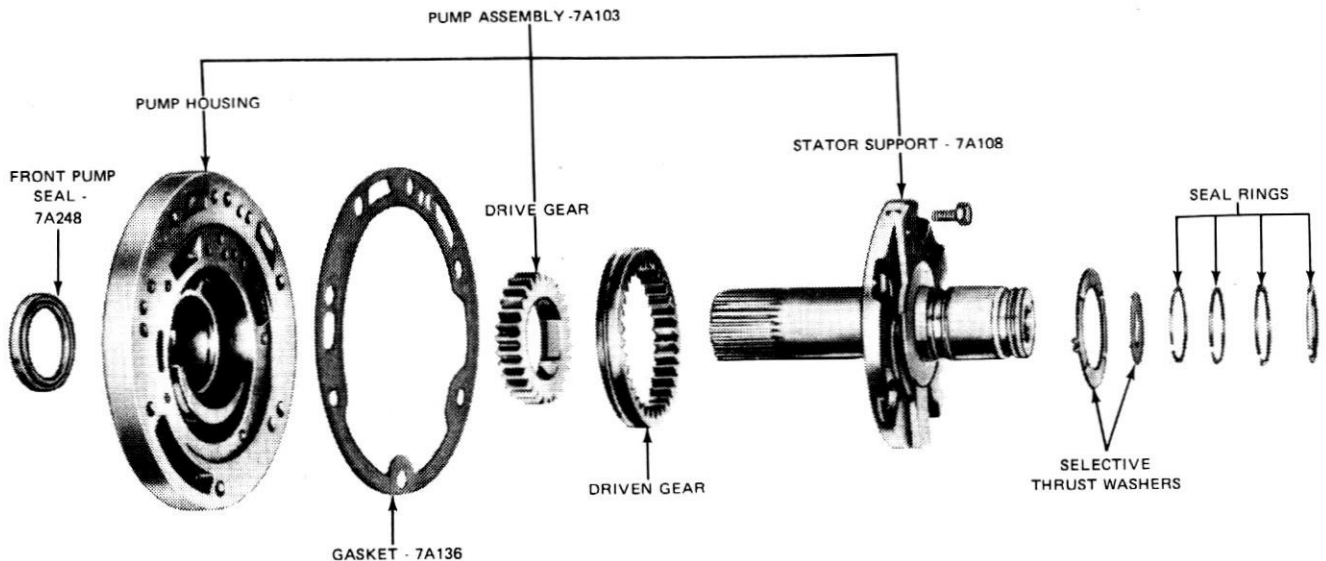
1. Install a new inner seal in the clutch drum and a new outer seal on the clutch piston. Lubricate the seals with clean transmission fluid and install the piston into the clutch drum.
2. Place the clutch piston spring into position on the clutch piston. Place the spring retainer on top of the spring, and install assembled parts in reverse-high clutch drum. To install the snap ring, use the tools shown in Fig. 71, and place assembled clutch drum in an arbor press.

As the press ram is moved downward, make sure the spring retainer is centered to clear the snap ring groove. Install the snap ring.



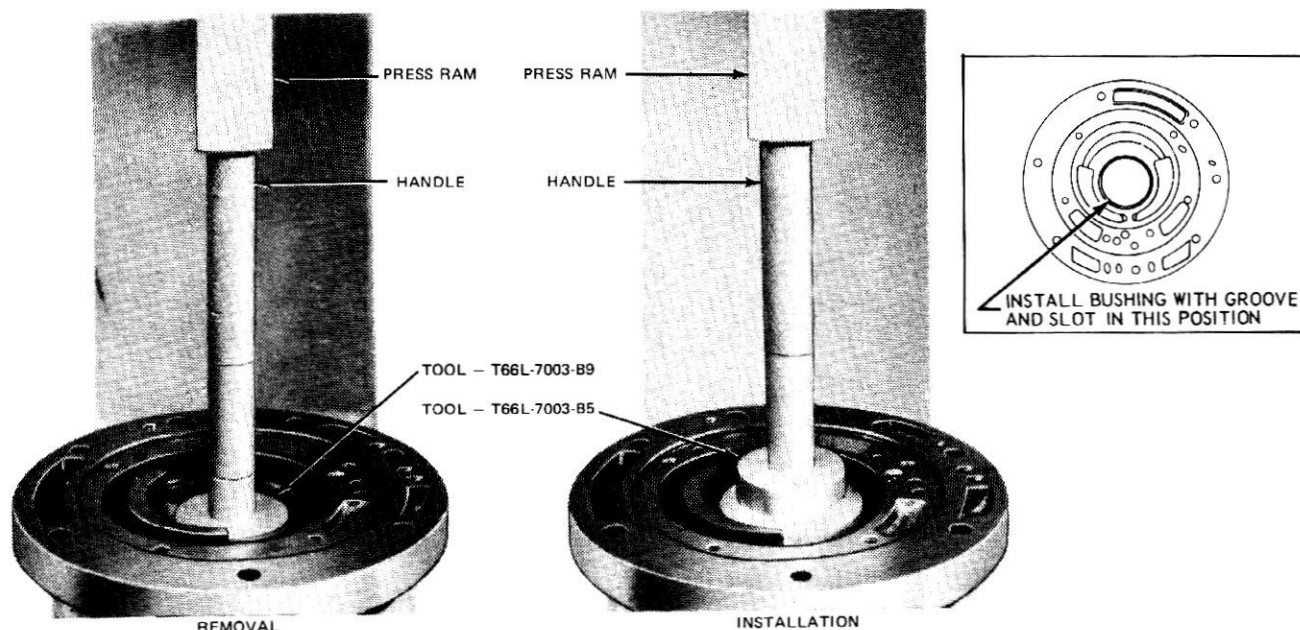
D1731-1A

FIG. 64 Removing Stator Support Bushing



D1894-2D

FIG. 63 Front Pump and Stator Support Disassembled



D1732-2C

FIG. 65 Replacing Front Pump Housing Bushing

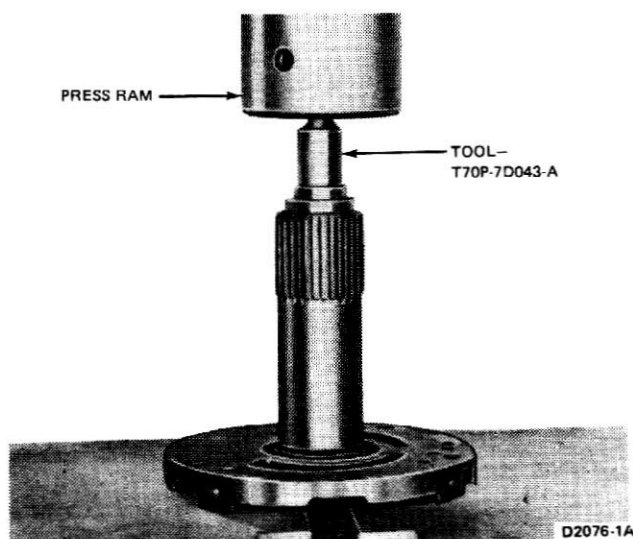


FIG. 66 Installing Stator Support Bushings

3. When new composition clutch plates are used, soak the plates in transmission fluid for fifteen minutes before installing them. Install the clutch plates alternately starting with a steel plate, then a non-metallic plate (Fig. 70). The last plate installed is the pressure plate. For the correct number of clutch plates required for each transmission model, refer to specifications at end of this Part.
4. Install the pressure plate snap ring (Fig. 70). Make sure the snap ring is fully seated in the snap ring groove of the clutch hub.

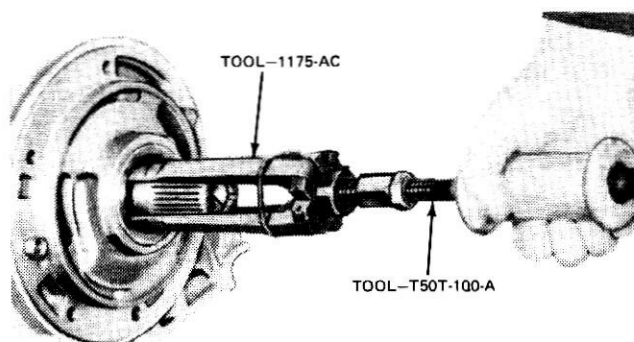


FIG. 67 Removing Front Pump Seal

5. With a feeler gauge, check the clearance between the snap ring and the pressure plate (Fig. 73).
6. The pressure plate should be held downward as the clearance is checked. The clearance should be 0.050 to 0.071 inch. If the clearance is not within limits, selective snap rings are available in the following thicknesses: 0.050 to 0.054, 0.064 to 0.068, 0.078 to 0.082 and 0.092 to 0.096 inch. Install the correct size snap ring and recheck the clearance.

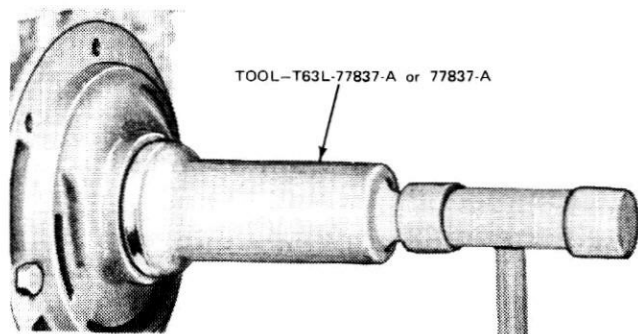


FIG. 68 Installing Front Pump Seal

FORWARD CLUTCH

Disassembly

1. Remove the clutch pressure plate snap ring (Fig. 74).
2. Remove the pressure plate, and the drive and driven clutch plates from the clutch hub (Fig. 75).
3. Remove the disc spring snap ring (Fig. 76).
4. Apply air pressure at the clutch piston pressure hole (Fig. 77) to remove the piston from the clutch hub.
5. Remove the clutch piston outer seal and the inner seal from the clutch hub (Fig. 75).

Assembly

1. Install new clutch piston seals on the clutch piston and drum. Lubricate the seals with clean transmission fluid.
2. Using a clutch piston seal protection (see Specification Section), install the clutch piston into the clutch hub. Install the disc spring and retaining snap ring (Fig. 75).
3. **Install the lower pressure plate with the flat side up and the radius side downward.**

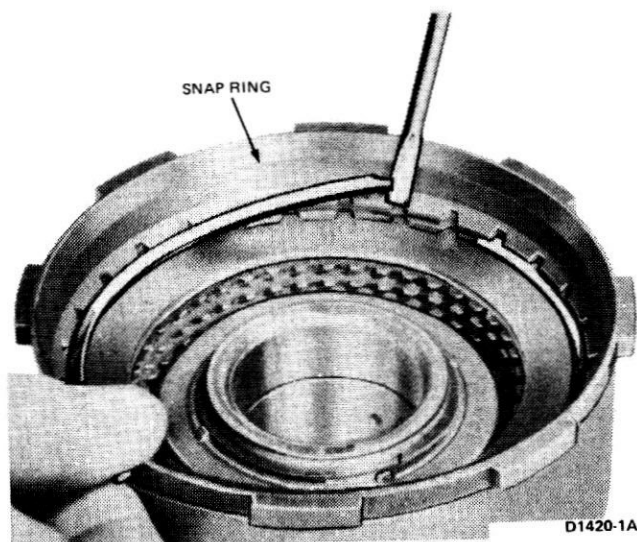


FIG. 69 Removing or Installing Reverse-High Pressure Plate Snap Ring

4. Install one non-metallic clutch plate and alternately install the drive and driven plates. Before installing new composition clutch plates, soak them in transmission fluid for fifteen minutes. The last plate installed will be the upper pressure plate. Refer to Specifications at end of this Part, for the correct number of clutch plates for the applicable model transmission.
5. Install the pressure plate snap ring (Fig. 75). Make sure the snap ring is fully seated in the ring groove of the clutch hub.
6. With a feeler gauge, check the clearance between the snap ring and the pressure plate (Fig. 78). Downward pressure on the plate should be used when making this check. The clearance should be 0.025 to 0.050 inch.
7. If the clearance is not within limits, selective snap rings are available in the following thicknesses: 0.050 to 0.054, 0.064 to 0.068, 0.078 to 0.082 and 0.092 to 0.096 inch. Insert the correct size snap ring and recheck the clearance.

FORWARD CLUTCH HUB AND RING GEAR

Disassembly

1. Remove the forward clutch hub snap ring (Fig. 79).
2. Remove the forward clutch hub from the ring gear.
3. Press the bushing from the clutch hub as shown in Fig. 80.

Assembly

1. Install a new bushing into the clutch hub as shown in Fig. 80.
2. Install the forward clutch hub in the ring gear. Make sure the hub is bottomed in the groove of the ring gear.
3. Install the front clutch hub snap ring. Make sure the snap ring is fully seated in the snap ring groove of the ring gear.

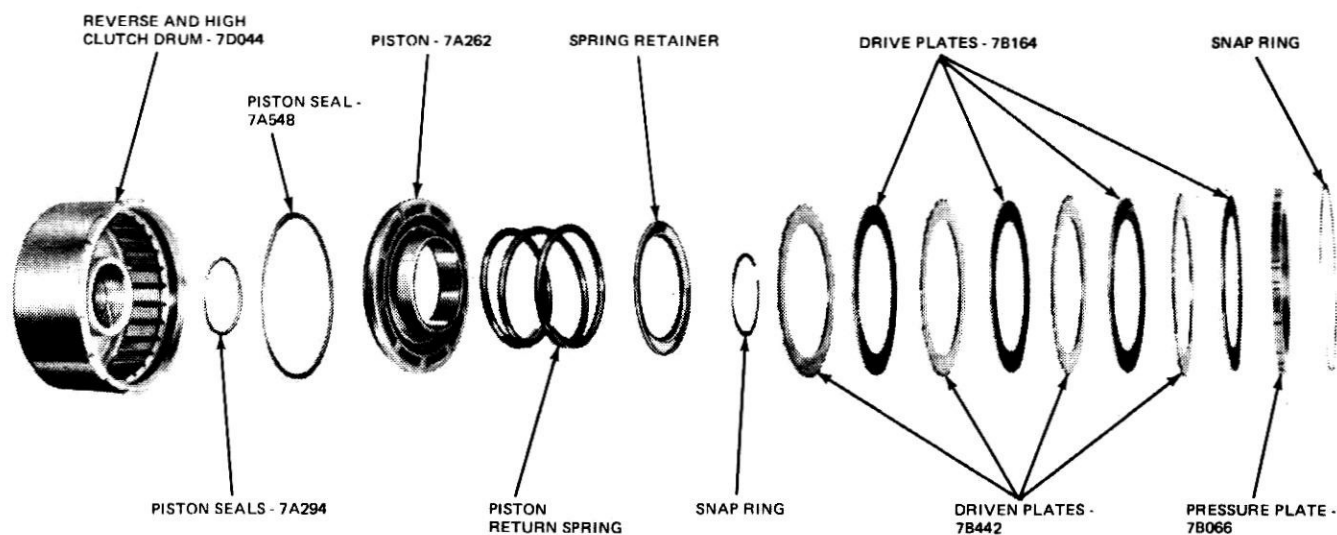
INPUT SHELL AND SUN GEAR

Disassembly

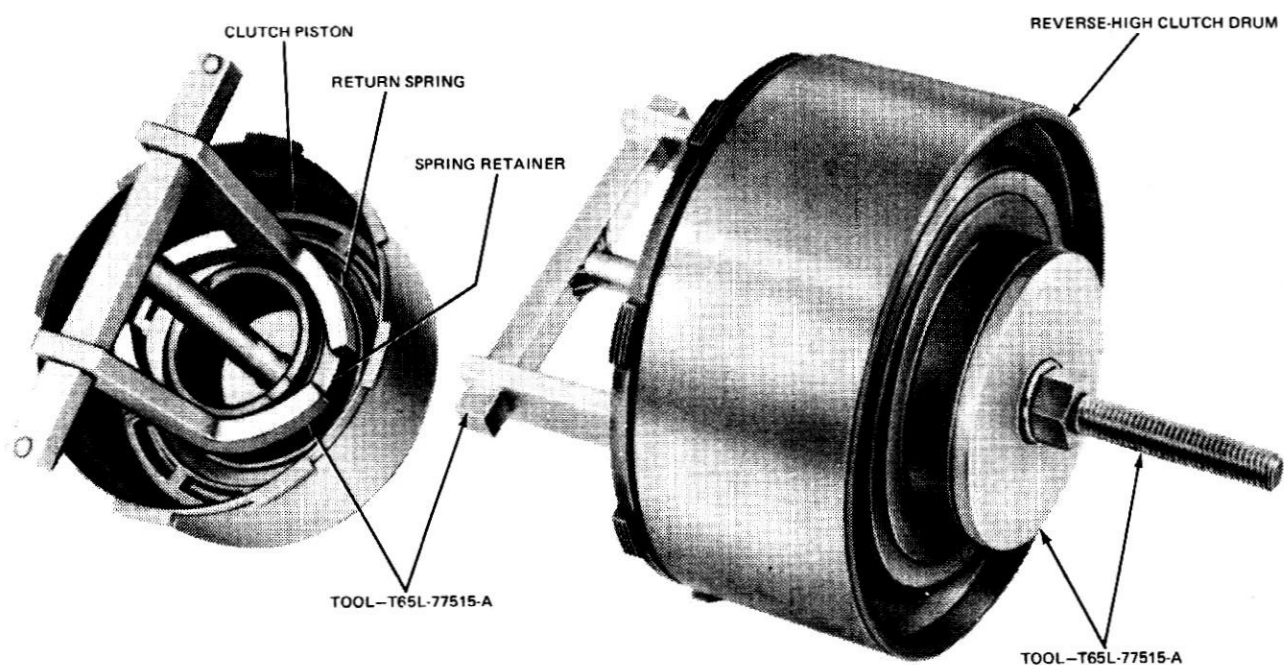
1. Remove the external snap ring from the sun gear (Fig. 81).
2. Remove thrust washer No. 5 from the input shell and sun gear (Fig. 82).
3. From inside the input shell, remove the sun gear. Remove the internal snap ring from the sun gear.
4. If the sun gear bushings are to be replaced, use the tool shown in Fig. 83 and press both bushings through the gear.

Assembly

1. Press a new bushing into each end of the sun gear with the tool shown in Fig. 83.
2. Install the internal snap ring in the sun gear. Install the sun gear in the input shell.
3. Install thrust washer No. 5 on the sun gear and input shell (Fig. 82).
4. Install the external snap ring on the sun gear (Fig. 81).



D1897-2D

FIG. 70 Reverse-High Clutch Disassembled Typical

D1591-2C

FIG. 71 Removing or Installing Reverse-High Clutch Piston Spring Snap Ring