

Transmission Type .. 5R55N

Rebuilder's Kwik
Reference Guide



Clutch Clearances

Adjusted By:

Forward Clutch 051-.079" Snap Ring
Intermediate Clutch No Specs Given Not Adjustable
Direct Clutch051-.079" Snap Ring
Overrun Clutch051-.079" Snap Ring

Torque Specifications

Pump Halves 18 Ft. Lbs.
Pump To Case 18 Ft. Lbs.
Solenoid Body 71 In. Lbs
Valve Body To Case 89 In. Lbs.
Pan 8 Ft. Lbs.
Center Support 8 Ft. Lbs.
Extension Housing 19 Ft. Lbs.
Low/Reverse Servo 8 Ft. Lbs.
Bellhousing To Main Case 27-39 Ft. Lbs.
Output Shaft Flange Nut 97 Ft. Lbs.
Center Support Bolt 8 Ft. Lbs.

Band Adjustment

Overdrive Band.....10 Ft. Lbs.1-1/2 Turns

Unit Endplays

Location

Selective

Front Unit .008-.021" Pump Thrust Washer
Rear Unit .012-.022" Center Support Thrust Bearing

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Clutch & Band /Solenoid Application Charts

Selector Position	Gear	Overdrive Band	Low/Reverse Band	Coast Clutch	Direct Clutch	Forward Clutch	Intermediate Clutch	Overdrive One-Way Clutch	Intermediate One-Way Clutch	Low/Reverse One-Way Clutch
R	R		X		X			X		
D	1					X		X		X
	2	X				X				X
	3					X	X	X	X	
	4				X	X	X	X		
	5	X			X	X	X			
	M 4TH			X	X	X	X	X		
3	M 3RD			X		X	X	X	X	
2	M 2ND	X	X			X				X
1	M 1ST		X	X		X		X		X

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Clutch & Band /Solenoid Application Charts

Optional Shifter

Selector Position	Gear	Shift Solenoid A	Shift Solenoid B	Shift Solenoid C	Shift Solenoid D	PC A	PC B	PC C
P or N	P or N	On	Off	Off	On	L	R	L
R	R	On	Off	Off	On	L	H	H
D5	1	On	Off	Off	On	R	L	L
	2	On	Off	On	On	L	R	L
	3	On	On	Off	On	R	L	L
	4	Off	Off	Off	On	R	L	H
	5	Off	Off	On	On	R	R	H
D5 with +/- control	1	On	Off	Off	Off	H	H	L
	2	On	Off	On	Off	H	H	L
	3	On	On	Off	Off	H	H	L
	4	Off	Off	Off	Off	H	H	H
	5	Off	Off	On	On	H	H	H
D4	1	On	Off	Off	On	R	L	L
	2	On	Off	On	On	L	R	L
	3	On	On	Off	On	R	L	L
	4	Off	Off	Off	Off	R	R	H

L = Low Pressure
H = High Pressure
R = Regulating Pressure

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Clutch & Band /Solenoid Application Charts

Base Shifter

Selector Position	Gear	Shift Solenoid A	Shift Solenoid B	Shift Solenoid C	Shift Solenoid D	PC A	PC B	PC C
P or N	P or N	On	Off	Off	On	L	R	L
R	R	On	Off	Off	On	L	H	H
D5	1	On	Off	Off	On	R	L	L
	2	On	Off	On	On	L	R	L
	3	On	On	Off	On	R	L	L
	4	Off	Off	Off	On	R	L	H
	5	Off	Off	On	On	R	R	H
D4	1	On	Off	Off	On	R	L	L
	2	On	Off	On	On	L	R	L
	3	On	On	Off	On	R	L	L
	4	Off	Off	Off	Off	R	R	H
Manual 3	3	On	On	Off	Off	R	R	L
Manual 2	2	On	Off	On	Off	R	R	L
Manual 1	1	On	Off	Off	Off	R	R	L

L = Low Pressure

H = High Pressure

R = Regulating Pressure

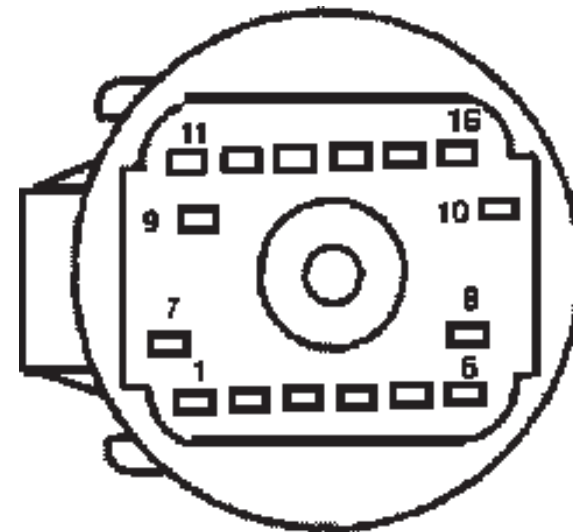
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Solenoid & Harness Information

Pin #	Description	Resistance
1	Pressure Control Solenoid A	3.3 - 7.5 Ohms
2	TFT Sensor	-
3	Solenoid Power	-
4	Pressure Control Solenoid B	3.3 - 7.5 Ohms
5	Shift Solenoid D	16 - 45 Ohms
6	Shift Solenoid C	16 - 45 Ohms
7	Blank	-
8	Blank	-
9	Blank	-
10	Blank	-
11	Pressure Control Solenoid C	3.3 - 7.5 Ohms
12	Signal Return	-
13	Reverse Pressure Switch	-
14	TCC	9 - 6 Ohms
15	Shift Solenoid B	16 - 45 Ohms
16	Shift Solenoid A	16 - 45 Ohms



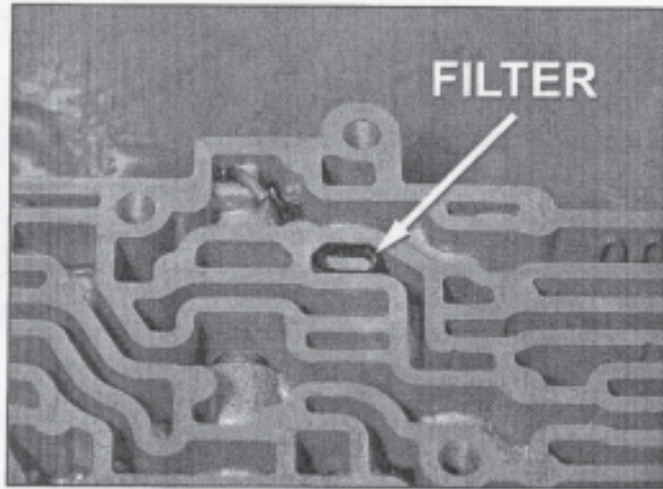
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Checkball Locations

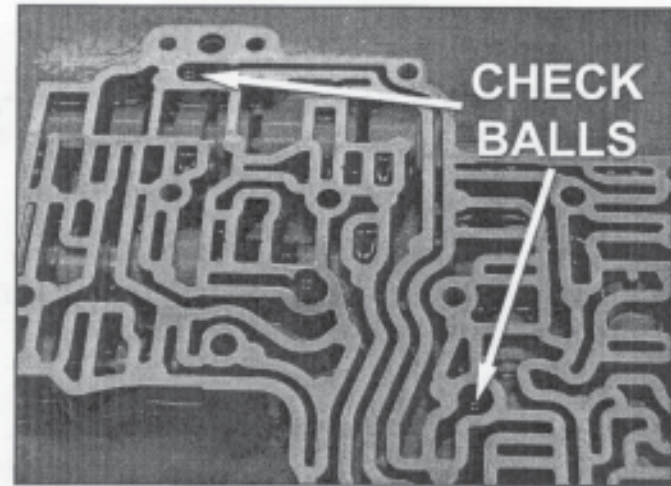
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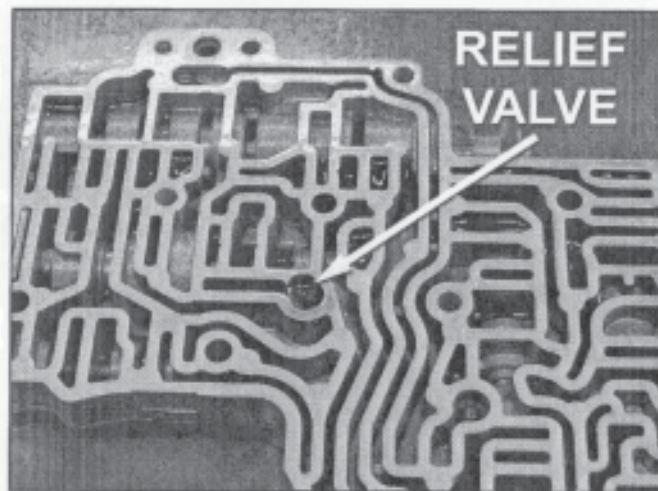
PASSAGE FILTER



CHECK BALLS



RELIEF VALVE AND SPRING

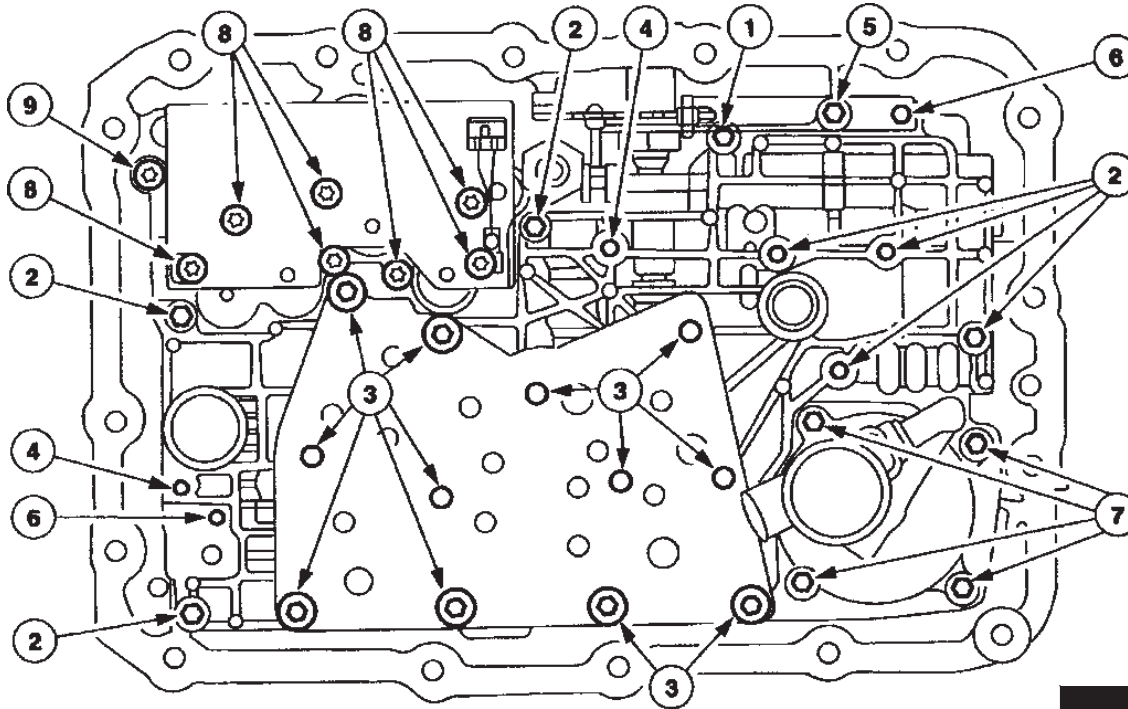


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Screw Locations



ITEM	DESCRIPTION
1	M 6 x 27 hex screw
2	M 6 x 45 hex screw
3	M 6 x 52 hex screw
4	M 6 x 82.2 hex screw
5	M 6 x 30 hex screw
6	M 6 x 20 cap int lob screw
7	M 6 x 70 hex screw
8	M 6 x 63 cap int lob screw
9	M 6 x 25 cap int lob screw

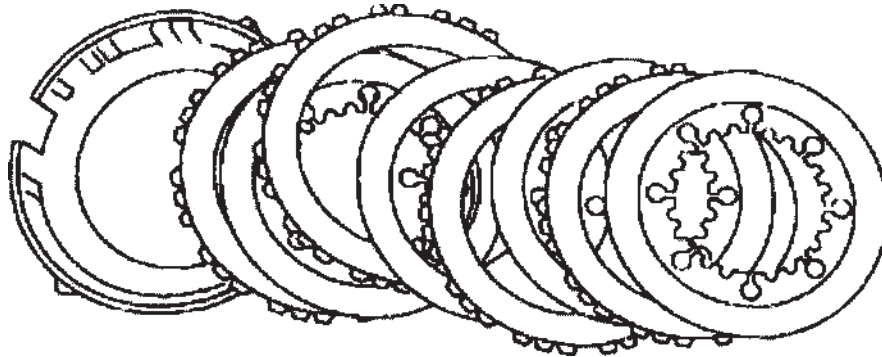
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Technical Tips for Rebuilding this Unit

Intermediate Clutch

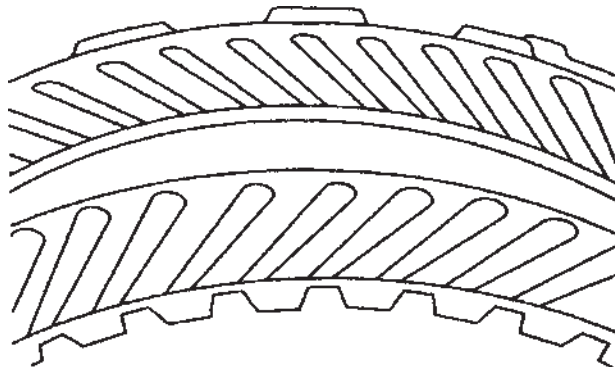


The friction side of the plates must face down toward the clutch cylinder. Assemble in alternating order starting with an internally splined clutch plate.

Install the intermediate clutch plates into the cylinder.

Install the intermediate clutch cylinder.

Direct Clutch



Direct clutch friction plates are directional and must be installed with grooves clockwise or counterclockwise (I.D. to O.D.). Alternate the internally splined (clockwise) and externally splined (counterclockwise) clutch plates.

Assemble the friction plates in alternating order, starting with an externally splined (counterclockwise) plate and then an internally splined (clockwise) plate.

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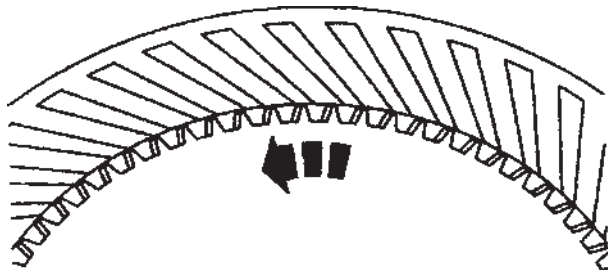
Technical Tips for Rebuilding this Unit

Coast Clutch



Coast Clutch friction plates are directional and must be installed with grooves clockwise (I.D. to O.D.).
The word "TOP" should face up.

Forward Clutch



Forward clutch friction plates are directional and must be installed with grooves counterwise (I.D. to O.D.).

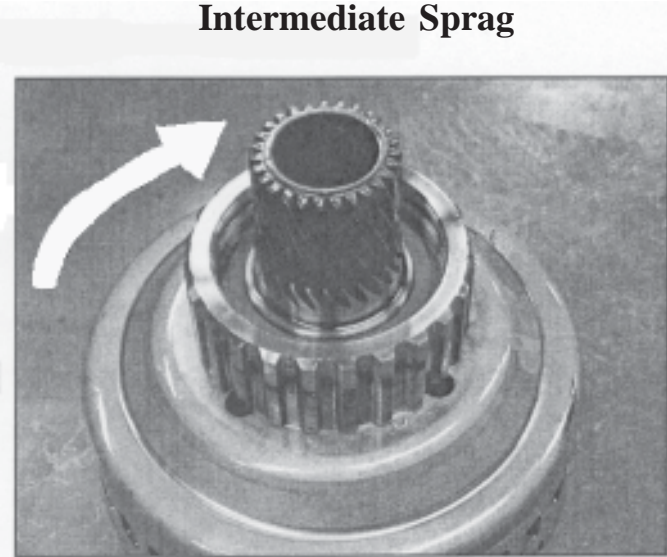
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Technical Tips for Rebuilding this Unit

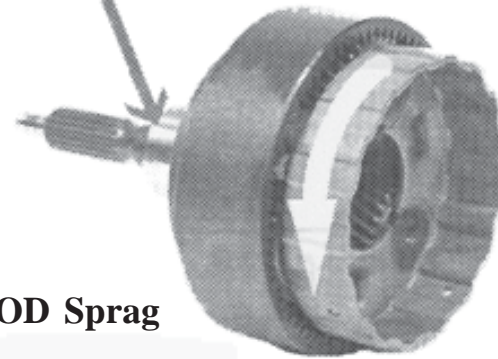
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Intermediate Sprag

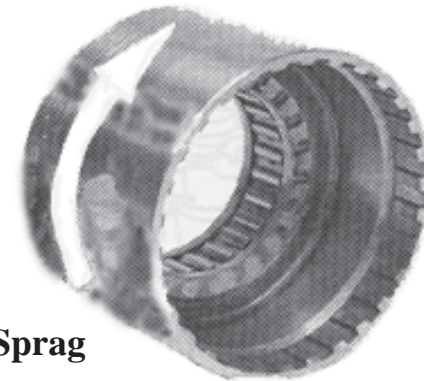


Hold



OD Sprag

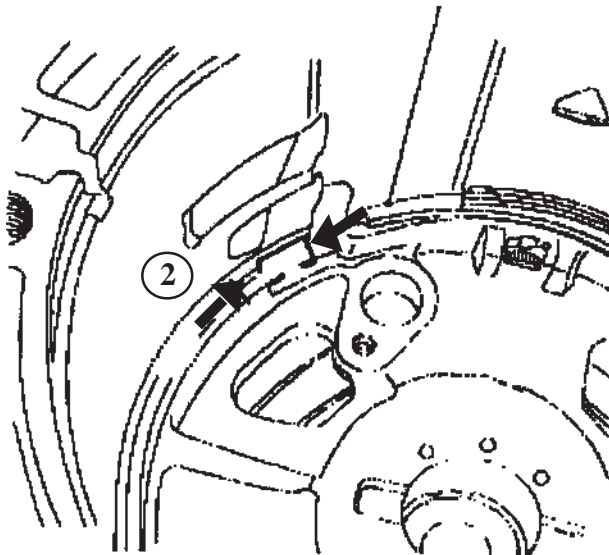
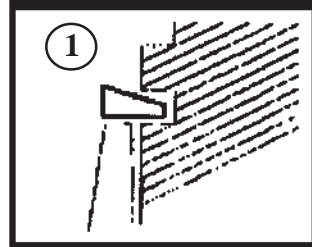
Low Sprag



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Center Support Snap Ring Installation

1. Install center support ring with tapered side facing up.
2. Make sure the notch opening is not obstructed by the center support retaining ring.

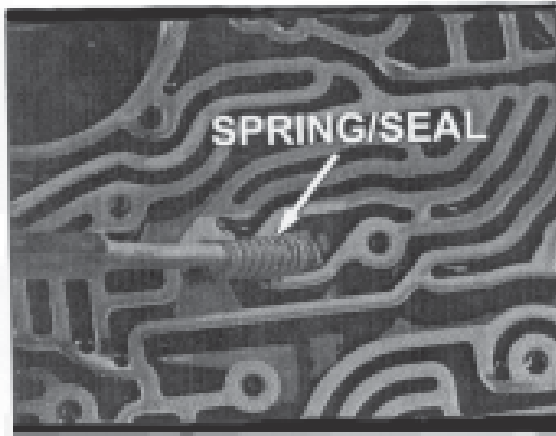
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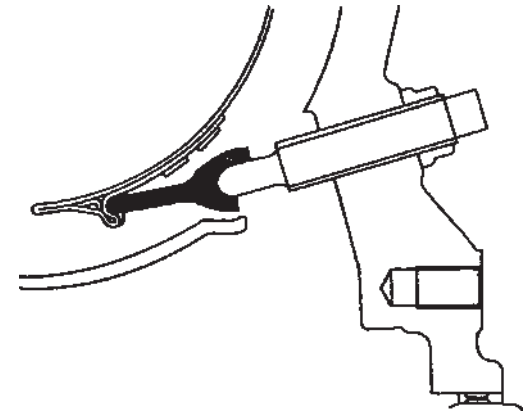


Inlet Tube Seal and Spring

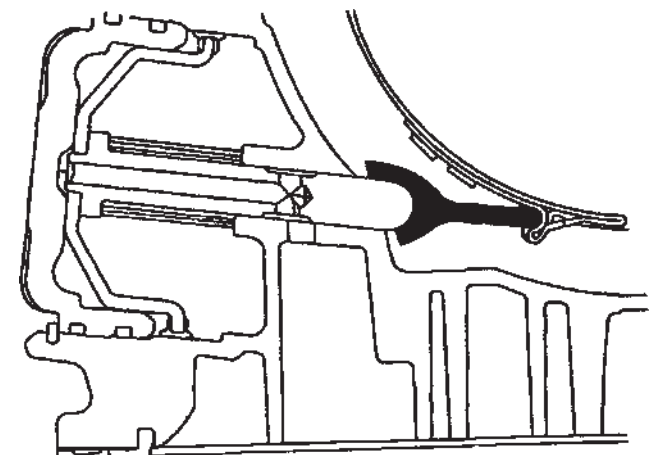


Use a drift punch to install and seat the intermediate clutch fluid inlet tube seal and spring into the case.

OD Band Anchor Strut



OD Band Apply Strut



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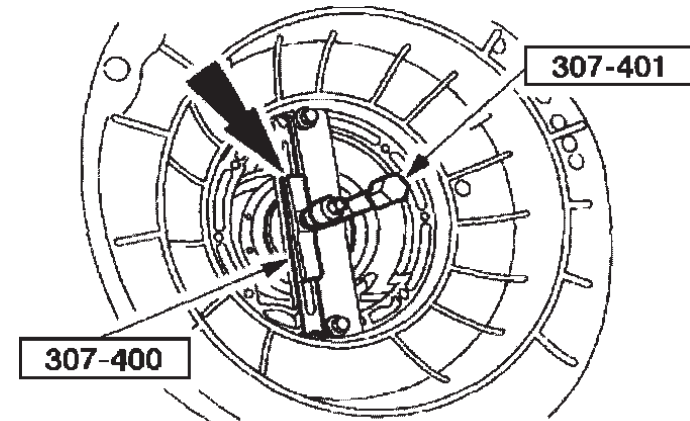
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Technical Tips for Rebuilding this Unit

Front Unit EndPlay Checking Procedure

1. Install cushion spring compressor #307-401 or equivalent on gasket surface of front pump. Hold in position with two pump bolts at the 6 and 12 o'clock position.
2. Tighten pressure screw on tool to 10 In. Lbs.
3. Position gauge bar #307-400 or equivalent and depth micrometer on gasket surface of front pump. (gauge bar is .700 thick)
4. Measure the distance from the top of the gauge bar to the coast drum bearing surface in two places. If the special tool is used measure through the two holes in the pressure disc. (See Figure 3)
5. Add the two measurements together and divide by two. Use this as dimension A.
6. Subtract dimension A from the thickness of the gauge bar (.700) to determine dimension B.
7. Use dimension B to select the proper thickness front pump washer from the chart.



Dimension B	Washer Thickness	Identification Color/ID
1.500-1.510	.060	Brown/8
1.510	.070	Red/4
1.510/1.520	.080	Black/6
1.520/1.530	.090	Orange/9
1.530	.100	Purple/10

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Technical Tips for Rebuilding this Unit

Rear Unit Endplay Checking Procedure

1. Position gauge bar #307-400 or equivalent and depth micrometer on gasket surface of front pump. (Gauge bar is .700 thick)
2. Measure the distance from the top of the gauge bar or equivalent to the center support ledge in the case at four places 90 degrees apart (See Figure 1).
3. Add the four measurements together and divide by four. Use this as dimension A.
4. Install cushion spring compressor #307-401 or equivalent on gasket surface of front pump. Hold in position with two pump bolts at the 6 and 12 o'clock position (See Figure 2).
5. Tighten pressure screw on tool to 10 In. Lbs.
6. Position gauge bar or equivalent and depth micrometer on gasket surface of front pump.
7. Measure the distance from the top of the gauge bar to the direct drum bearing surface in two places. If the special tool is used measure through the two holes in the pressure disc.
8. Add the two measurements together and divide by two. Use this as dimension B.
9. Subtract dimension A from dimension B to determine dimension C.
10. Use dimension C to select proper thickness center support thrust bearing from the chart.

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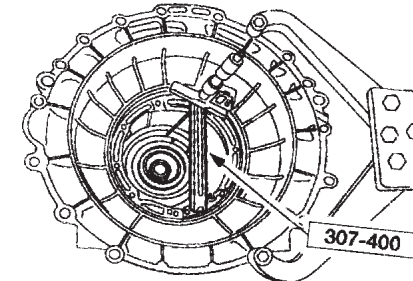


Figure 1

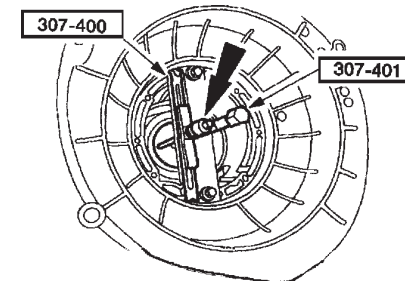


Figure 2

Dimension C	Bearing Thickness	Identification Notches
.066-.073	.104-.110	0
.073-.080	.111-.116	1
.081-.088	.118-.124	2
.089-.096	.126-.132	3