

Transmission Type....4L80-E



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Clutch Clearances

Forward Clutch035-.070"	Selective Steel
Intermediate Clutch040-.107"	Not Adjust.
Direct Clutch050-.070"	Selective Steel
Low/Reverse Clutch			
Reverse Clutch			
Overrun Clutch040-.100"	Not Adjust.
Overdrive Clutch040-.100"	Not Adjust.

Adjusted By:

Torque Specifications

Pump Halves	18 Ft Lbs.
Pump to Case	18 Ft Lbs.
Valve Body	
Valve Body To Case	98 In Lbs.
Chain Cover To Case	
Pan	18 Ft Lbs.
Center Support	32 Ft Lbs.
Extension Housing	25 Ft Lbs.
Driven Sprocket Support	
Overdrive Support	
Chain Cover	
Transfer Gears	
Bellhousing to Main Case	
Accumulator Cover	
Endcover Bolts	
Ring Gear Bolts	

Band Adjustment

Intermediate Band	
2-4 Band	
Low/Reverse Band	3/16-1/4" Servo Pin
Overdrive Band	

Unit Endplays

Front Unit .004-.022"	Pump.....	Washer
Middle Unit		
Rear Unit .005-.025"	Case.....	Washer
Differential		
Output Shaft		
Input Shaft		

Location

Selective

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Clutch & Band/Solenoid Application Charts

Gear		4th Clutch	Overrun Clutch	Overrive Roller Clutch	Forward Clutch	Direct Clutch	Front Band	Intermediate Sprag Clutch	Intermediate Clutch	Low Roller Clutch	Rear Band
Reverse				Holding		Applied					Applied
Over Drive	First			Holding	Applied			*		Holding	
	Second			Holding	Applied			Holding	Applied	Overrunning	
	Third			Holding	Applied	Applied		Overrunning	Applied	Overrunning	
	Fourth	Applied		Overrunning	Applied	Applied		Overrunning	Applied	Overrunning	
Drive	First		Applied	Applied	Applied			*		Holding	
	Second		Applied	Applied	Applied			Holding	Applied	Overrunning	
	Third		Applied	Applied	Applied			Overrunning	Applied	Overrunning	
2	First		Applied	Applied	Applied			*		Holding	
	Second		Applied	Applied	Applied		Applied	Holding	Applied	Overrunning	
1	First		Applied	Applied	Applied		Applied	Holding	Applied	Overrunning	Applied
	Second		Applied	Applied	Applied		Applied	*		Holding	Applied

* Applied but not transmitting power

Solenoid Application Chart			
Gear	Solenoid A Output 1 On = Green	Solenoid B Output 2 On = Green	Lock-Up Solenoid Output 3 On = Green
1st	On	Off	Off
2nd	Off	Off	Off
3rd	Off	On	Off
4th	On	On	Off
Lock-Up	On	On	On

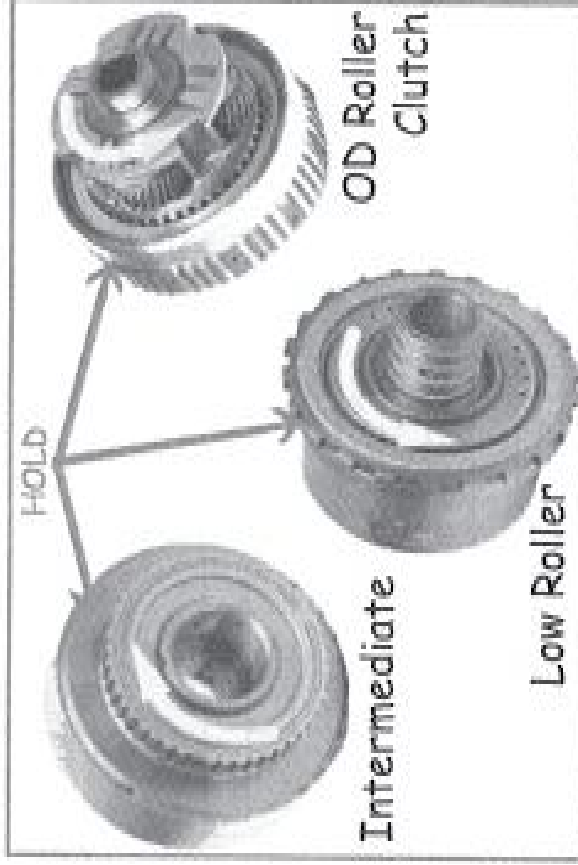
EPC Output 7	
Changes to control line pressure	
Changes to control line pressure	
Changes to control line pressure	
Changes to control line pressure	
Changes to control line pressure	

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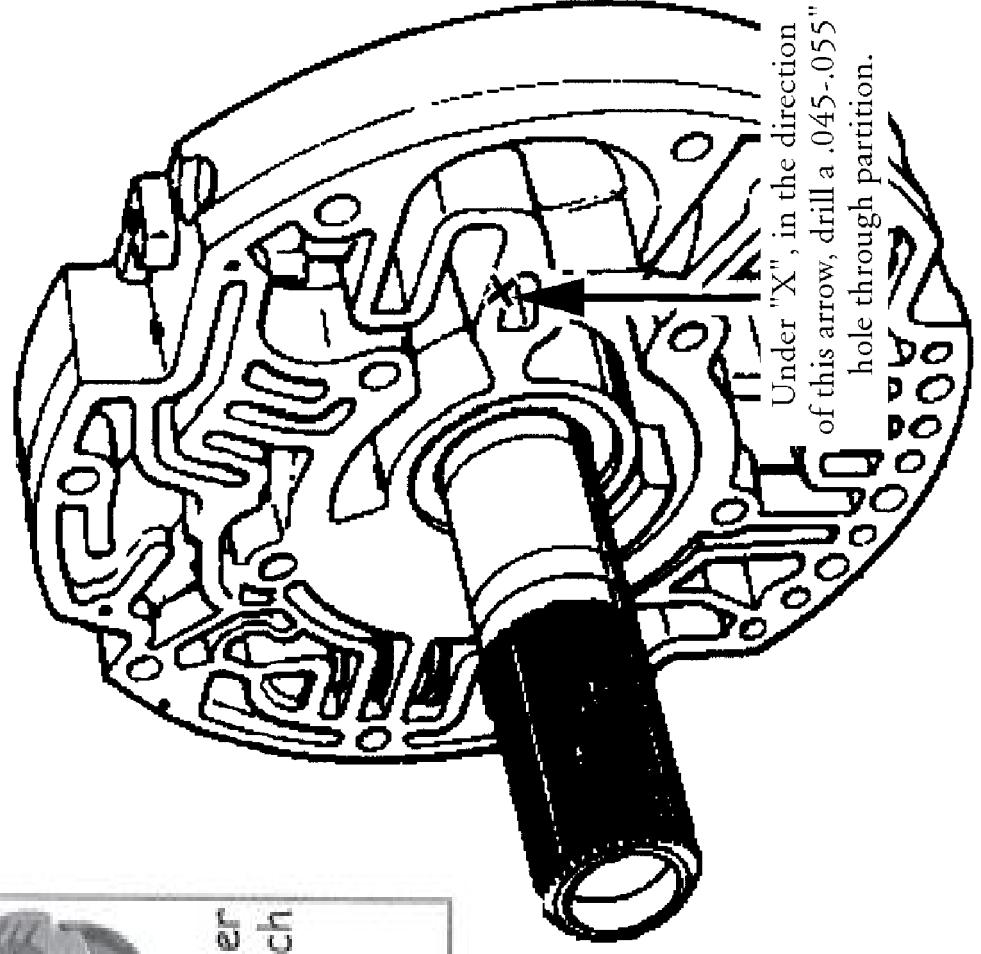
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Technical Tips For Rebuilding This Unit



Line to Lube Modification

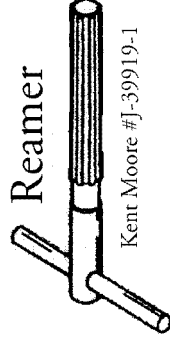
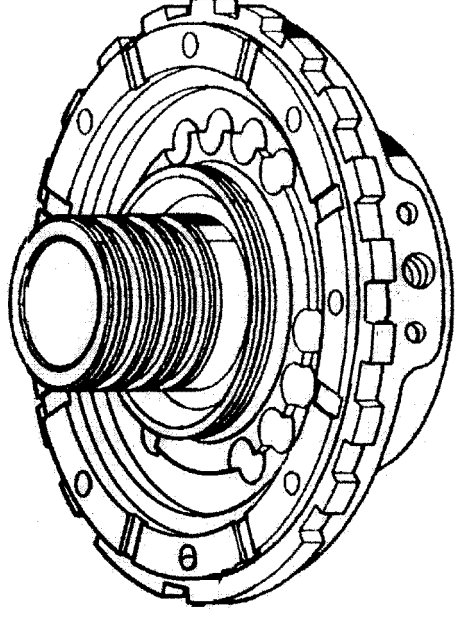
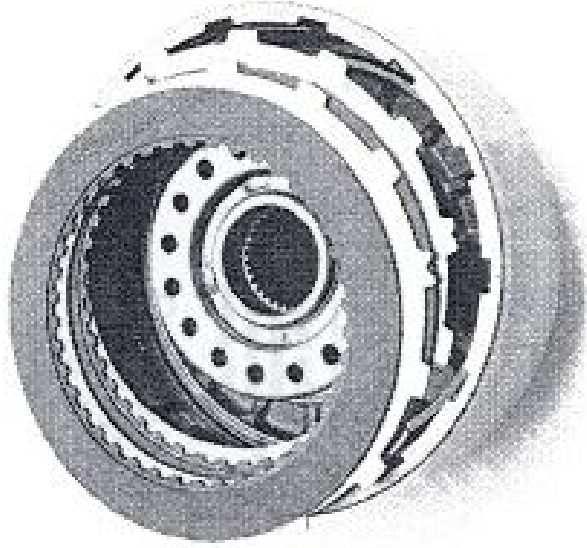


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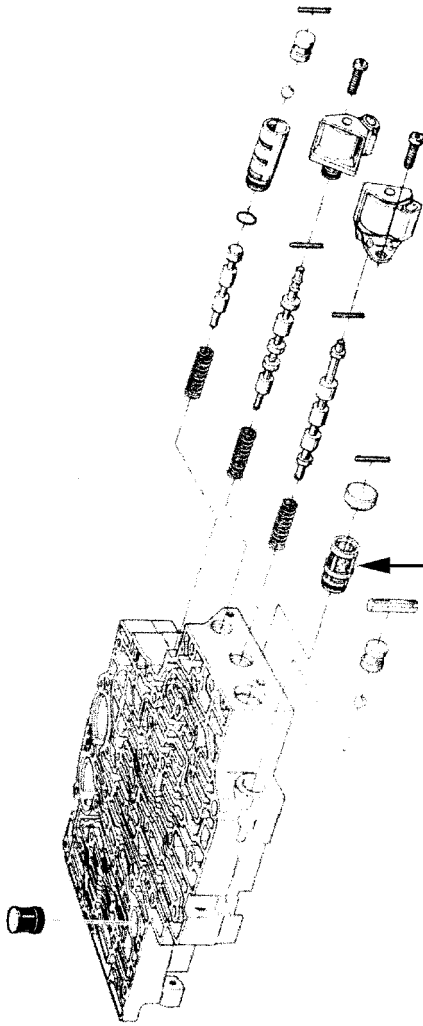


To fix the problem of the direct drum cushion plate breaking, install two 400 waved steels instead of the cushion plate.

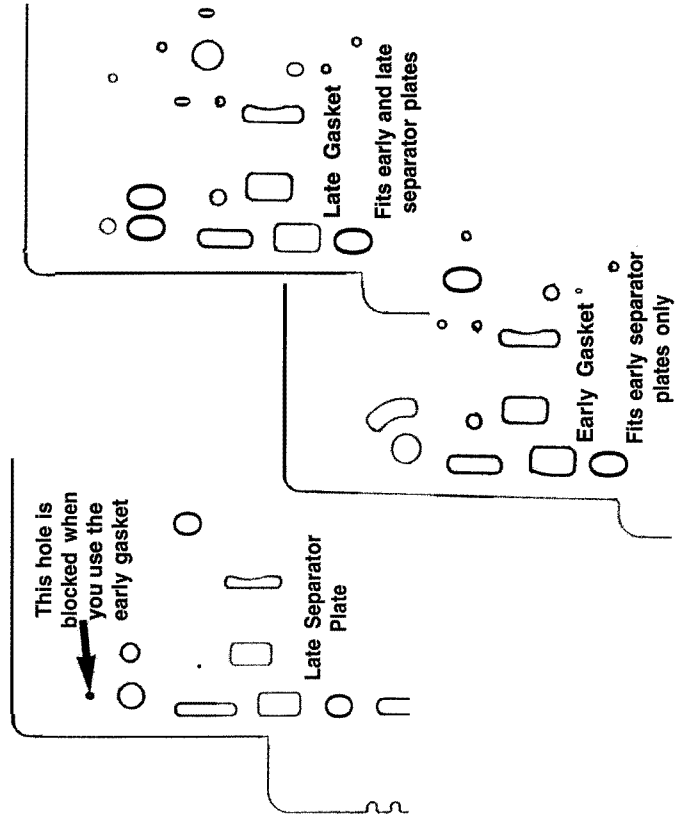
When installing a new center support bolt, always ream the support threads to make sure the bolt will tighten properly.

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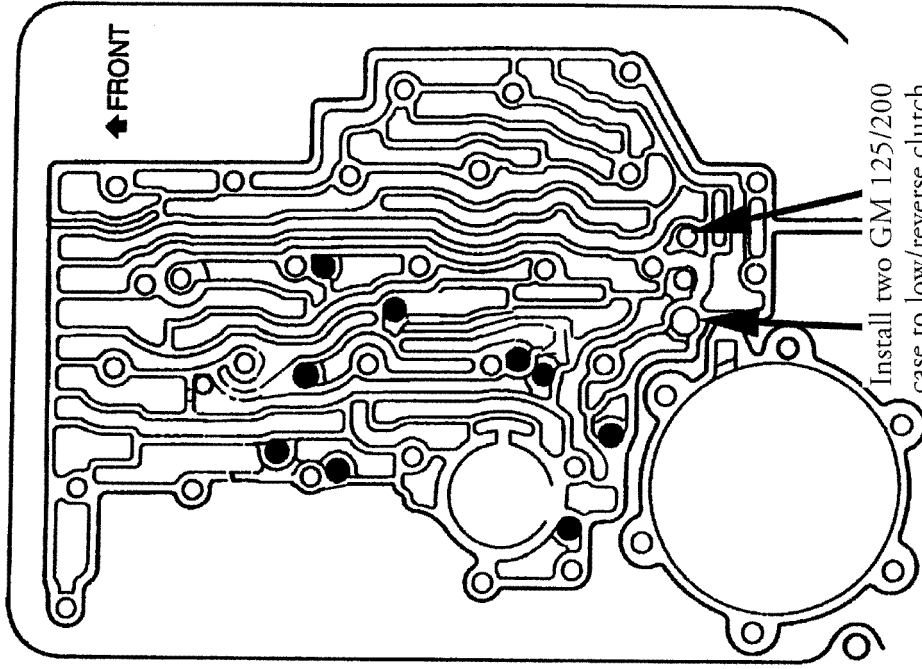
Technical Tips For Rebuilding This Unit



If this filter breaks, you will get 2nd gear starts and erratic shifts.



Gasket Identification



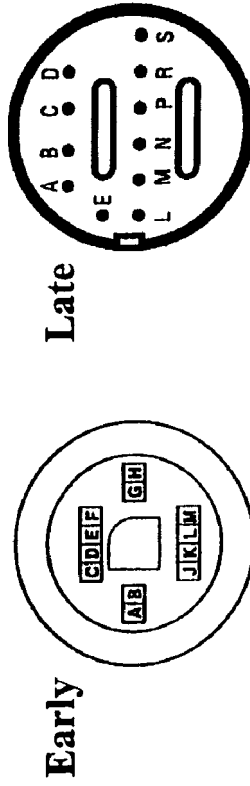
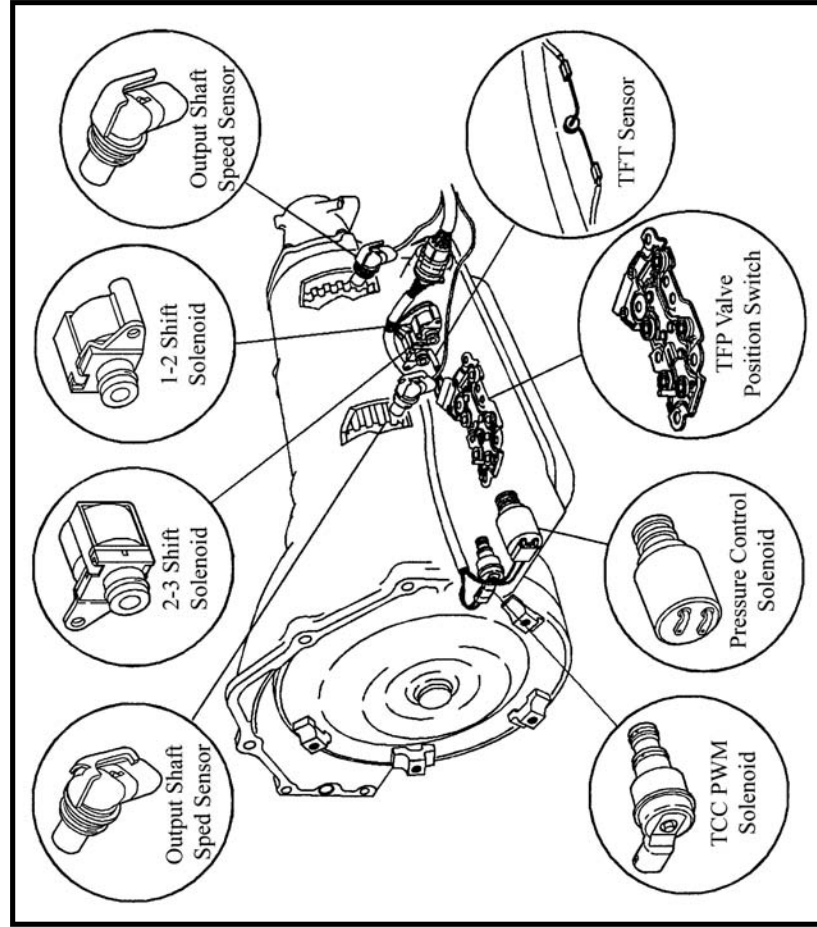
Install two GM 125/200 case to low/reverse clutch housing seals (short lip) here to stop leaks.

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Solenoid & Harness Information



Early Connector Pin #	Late Connector Pin #	Description	Resistance
A	A	Solenoid A	20 - 30 Ohms
B	B	Solenoid B	20 - 30 Ohms
C, K	E	Power to Solenoids	-
D	N	Pressure Switch (A)	-
E	R	Pressure Switch (B)	-
F	P	Pressure Switch (C)	-
G	M	TOT Sensor	-
H	L	TOT Sensor	-
J	S	Lock-Up Solenoid	10 - 17
L	D	EPC Power	7 - 9.2 Ohms
M	C	EPC Ground	7 - 9.2 Ohms
-	T, U, V	-	-



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Checkball Locations

