

Transmission Type...413/470/670

Rebuilder's Kwik Reference Guide



Clutch Clearances Adjusted By:

Forward Clutch.....	.026-.043"	Snap Ring
Intermediate Clutch			
Direct Clutch.....	.087-.146"	Snap Ring
Low/Reverse Clutch			
Reverse Clutch			
Overrun Clutch			
Overdrive Clutch			

Band Adjustment

Intermediate Band.....	72 In. Lbs.	2.5 Turns
2-4 Band			
Low/Reverse Band.....	72 In. Lbs.	3.5 Turns
Overdrive Band			

Torque Specifications

Pump Halves	20 Ft. Lbs.
Pump To Case	22 Ft. Lbs.
Valve Body Halves	40 In. Lbs.
Valve Body To Case.....	40 In. Lbs.
Differential Cover To Case	13 Ft. Lbs.
Pan	13 Ft. Lbs.
Center Support	
Extension Housing	20 Ft. Lbs.
Driven Sprocket Support	
Overdrive Support	
Chain Cover	
Transfer Gears	200 Ft. Lbs.
Governor Bolts	60 In. Lbs.
Bellhousing To Main Case	
Idle Nut	
Endcover Bolts	13 Ft. Lbs.
Ring Gear Bolts.....	70 Ft. Lbs.

Unit Endplays

Front Unit .008-.060"	On Output Shaft	Thrust Washer
Middle Unit		
Rear Unit		

Differential 5-18 In. Lbs. Turning Torque

Chain Sprocket

Output Shaft 3-8 In. Lbs. Turning Torque

Transfer Shaft .002-.010"

Unit Endplays Location

Front Unit .008-.060"	On Output Shaft	Thrust Washer
Middle Unit		
Rear Unit		
Differential 5-18 In. Lbs. Turning Torque	Under Race	Spacer
Chain Sprocket		
Output Shaft 3-8 In. Lbs. Turning Torque	Between Bearings.....	Spacer
Transfer Shaft .002-.010"	Between Bearings.....	Spacer

Unit Endplays Selective

Front Unit .008-.060"	On Output Shaft	Thrust Washer
Middle Unit		
Rear Unit		
Differential 5-18 In. Lbs. Turning Torque	Under Race	Spacer
Chain Sprocket		
Output Shaft 3-8 In. Lbs. Turning Torque	Between Bearings.....	Spacer
Transfer Shaft .002-.010"	Between Bearings.....	Spacer

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Clutch & Band/Solenoid Application Chart

Gear		Front Clutch	Rear Clutch	Lock-Up Clutch	Overrunning Clutch	Front Band (Kickdown)	Rear Band (Low/Reverse)
Reverse		Applied					Applied
Drive	1st		Applied		Applied		
	2nd		Applied			Applied	
	3rd	Applied	Applied	Applied			
2nd	1st		Applied		Applied		
	2nd		Applied			Applied	
Low (1st)		Applied					Applied

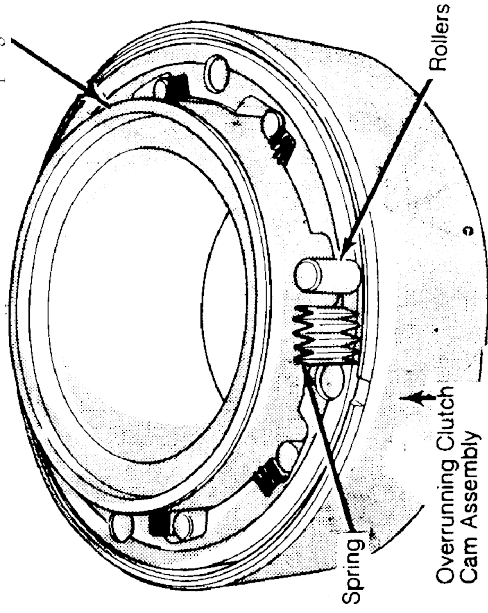
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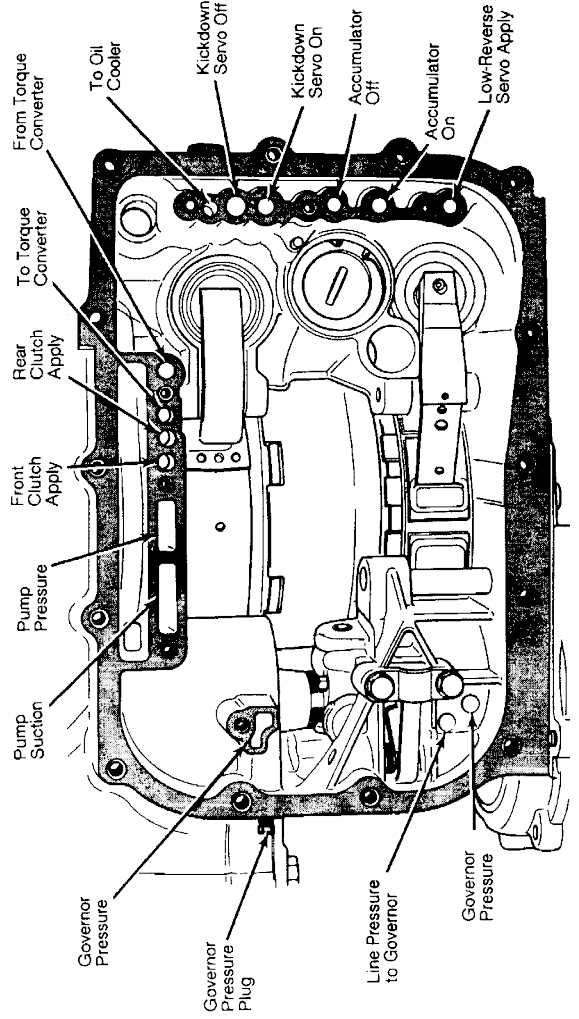
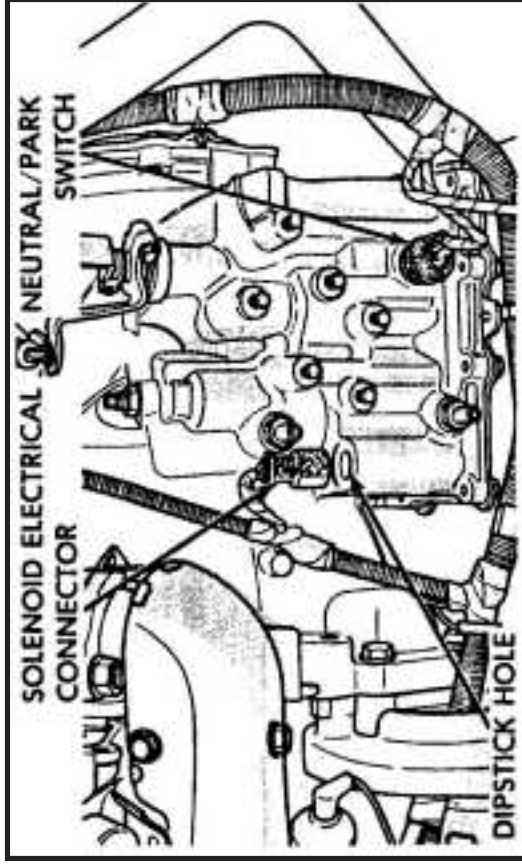


Technical Tips For Rebuilding This Unit

Use sprag race from old case to hold spring & rollers.



Installing Rollers & Springs in Overrunning Clutch



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Checkball Locations



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