

# Transmission Type....F4A41

Rebuilder's Kwik  
Reference Guide



## Clutch Clearances

Low Brake .....	.041-.059"	.....	Pressure Plate
2nd Brake .....	.019-.037"	.....	Pressure Plate
U-D Clutch .....	.049-.057"	.....	Snap Ring
O-D Clutch .....	.047-.055"	.....	Snap Ring
Reverse Clutch .....	.047-.055"	.....	Snap Ring

**Overrun Clutch**  
**Overdrive Clutch**

## Band Adjustment

**Intermediate Band**  
**2-4 Band**  
**Low/Reverse Band**  
**Overdrive Band**

## Adjusted By:

## Torque Specifications

Pump .....	17 Ft Lbs.
Oil Filter .....	8.7 Ft Lbs.
Valve Body Halves .....	8 Ft Lbs.
Valve Body To Case .....	8 Ft Lbs.
Case Halves .....	35 Ft Lbs.
Transfer Gear Nut .....	141 In Lbs.
Output Shaft Nut .....	123 In Lbs.

**Extension Housing**  
**Differential Drive Gear** ..... 98 In Lbs.  
**Transfer Drive Gear** ..... 14 Ft Lbs.  
**Rear Cover** ..... 17 Ft Lbs.  
**Forward Ban Servo Cover**  
**Manual 2-1 Band Servo Cover**  
**Accumulator Cover**  
**Endcover Bolts**  
**Ring Gear Bolts**

## Unit Endplays

	Location	Selective
Front Unit .027-.057" .....	Pump Tower.....	Shim
<b>Middle Unit</b>		
<b>Rear Unit</b>		
Differential Case .0018-.0065" .....	Differential .....	Shim
Output Shaft (Preload) .0035-.0004" .....	Shaft .....	Shim

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## Clutch & Band/Solenoid Application Charts

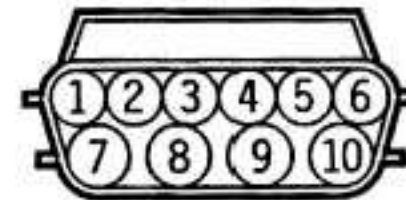
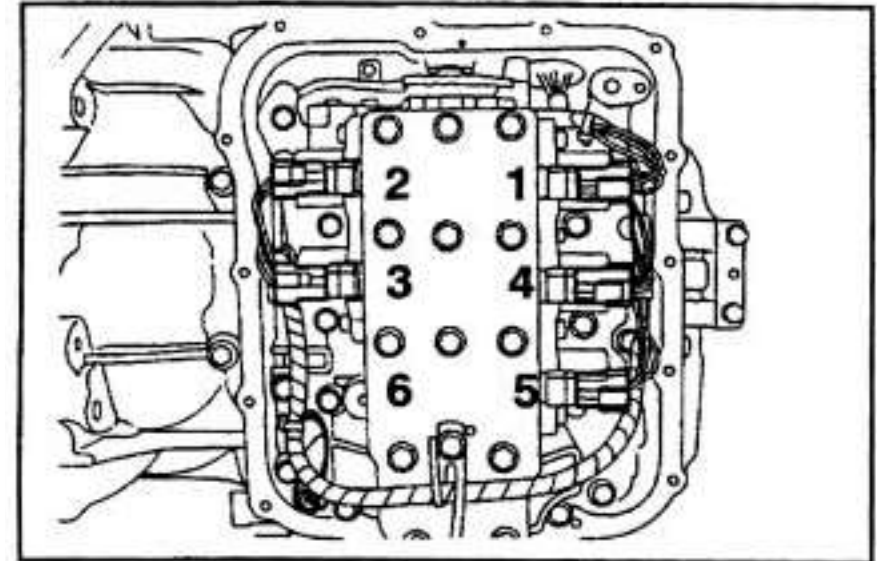
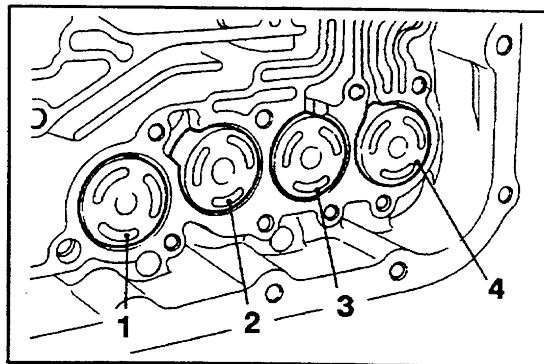
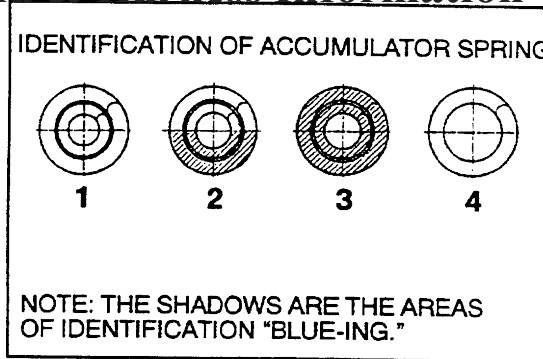
Gear		Underdrive Clutch	Reverse Clutch	Overdrive Clutch	Low/Reverse Brake	2nd Brake
Reverse			Applied		Applied	
OD	1st	Applied			Applied	
	2nd	Applied				Applied
	3rd	Applied		Applied		
	4th			Applied		Applied
3	1st	Applied			Applied	
	2nd	Applied				Applied
	3rd	Applied		Applied		
2	1st	Applied			Applied	
	2nd	Applied				Applied
L	1st	Applied			Applied	

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## Technical Tips For Rebuilding This Unit Solenoid & Harness Information



NO.	NAME	IDENTIFICATION "BLUE-ING"
1	For low-reverse brake	None
2	For underdrive clutch	Half
3	For second brake	Whole surface
4	For overdrive clutch	None

Terminal Number	Name	Resistance
1 - 2	Transmission Oil Temperature Sensor	16,700 - 20,500 $\Omega$ (at 32° F) 570 - 690 $\Omega$ (at 212° F)
3 - 9	Underdrive Solenoid Valve	2.7 - 3.4 $\Omega$ (at 68° F)
4 - 9	Second Solenoid Valve	2.7 - 3.4 $\Omega$ (at 68° F)
5 - 9	Overdrive Solenoid Valve	2.7 - 3.4 $\Omega$ (at 68° F)
6 - 10	Low and Reverse Solenoid Valve	2.7 - 3.4 $\Omega$ (at 68° F)
7 - 10	Lock-Up Solenoid	2.7 - 3.4 $\Omega$ (at 68° F)

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## Checkball Locations Valve Body

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Steel ball and spring

Damping valve

Steel ball  
and spring

