

# Transmission Type....F4A51

Rebuilder's Kwik  
Reference Guide



## Clutch Clearances

Low Brake Clutch.....	.050-.083"	.....	Pressure Plate
2nd Brake Clutch.....	.042-.061"	.....	Pressure Plate
<b>3rd Direct Clutch</b>			
<b>Low/Reverse Clutch</b>			
Reverse Clutch.....	.059-.063"	.....	Snap Ring
Underdrive Clutch.....	.063-.070"	.....	Snap Ring
Overdrive Clutch.....	.063-.070"	.....	Snap Ring

## Adjusted By:

## Torque Specifications

Pump.....	17 Ft Lbs.
Case Halves.....	35 In Lbs.
Valve Body Halves.....	8 Ft Lbs.
Valve Body To Case.....	8 Ft Lbs.
Transfer Gear Nut.....	141 In Lbs.

### Pan

### Center Support

### Extension Housing

### Driven Sprocket Support

Output Shaft Nut.....	123 In Lbs.
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Oil Filter.....	87 In Lbs.
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### Forward Ban Servo Cover

### Manual 2-1 Band Servo Cover

Differential Drive Gear.....	98 In Lbs.
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Transfer Drive Gear.....	14 In Lbs.
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Rear Cover.....	17 In Lbs.
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## Band Adjustment

### Intermediate Band

### 2-4 Band

### Low/Reverse Band

### Overdrive Band

## Unit Endplays

Front Unit .027-.057".....	Pump Tower.....	Shim
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### Middle Unit

### Rear Unit

Differential Case .0018-.0065".....	Differential.....	Shim
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Output Shaft (Preload) .0035-.0004".....	Shaft.....	Shim
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## Location

## Selective

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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	

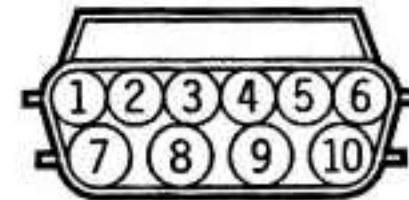
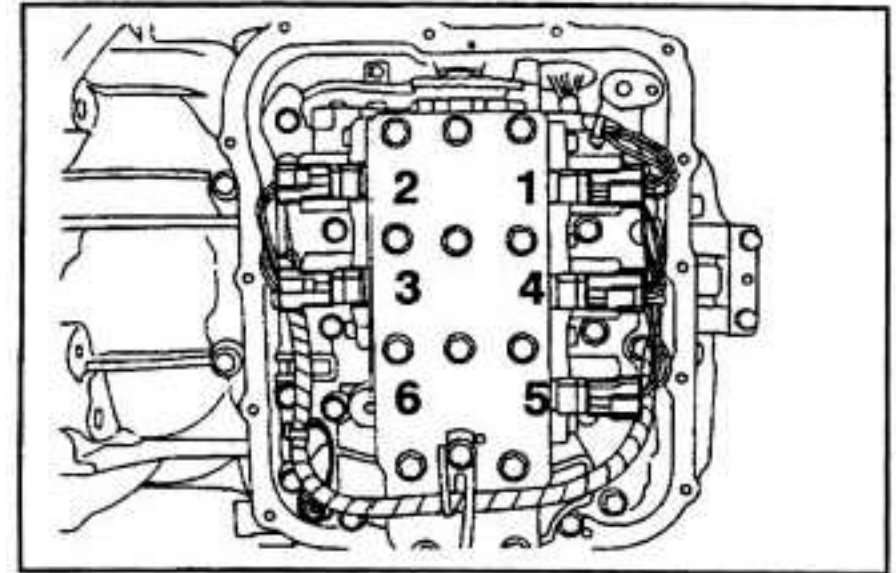
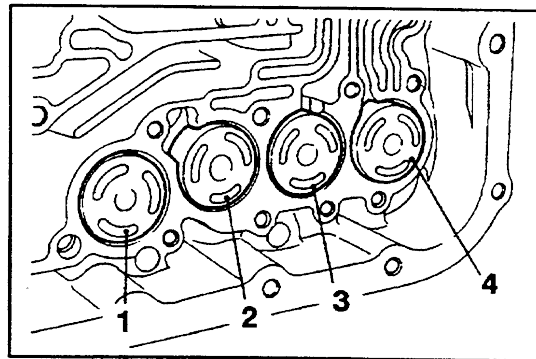
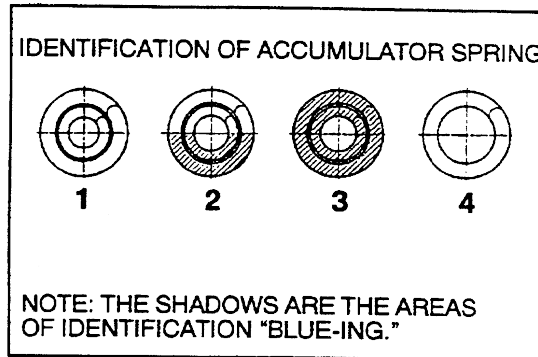
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## Technical Tips For Rebuilding This Unit

## 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

Steel ball and spring

Damping valve

