

Transmission Type....**L4N71B/E4N71B/JM600**

Rebuilder's Kwik  
Reference Guide



**Clutch Clearances**

**Adjusted By:**

Forward Clutch..... .031-.059” ..... Pressure Plate  
**Intermediate Clutch**  
 High/Rev. Direct Clutch ..... .063-.071” ..... Pressure Plate  
 Low/Reverse Clutch ..... .031-.049” ..... Pressure Plate  
**Reverse Clutch**  
 Direct Overrun Clutch ..... .063-.071” ..... Pressure Plate  
**Overdrive Clutch**

**Torque Specifications**

Pump Halves .....35-48 In. Lbs.  
 Pump To Case .....33-40 Ft. Lbs.  
 Valve Body Halves .....15-20 In. Lbs.  
 Valve Body To Case.....33-45 In. Lbs.  
**Chain Cover To Case**  
 Pan .....36-47 In. Lbs.  
**Center Support**  
 Extension Housing .....14-18 Ft. Lbs.  
**Driven Sprocket Support**  
**Overdrive Support**  
**Chain Cover**  
**Transfer Gears**  
 Governor Bolts .....30-42 In. Lbs.  
 Bellhousing To Main Case .....33-40 Ft. Lbs.  
**Idler Nut**  
**Endcover Bolts**

**Band Adjustment**

Intermediate Band.....10 Ft Lbs.....2 Turns  
**2-4 Band**  
**Low/Reverse Band**  
 Overdrive Band.....10 Ft Lbs.....2 Turns

**Unit Endplays**

**Location**

**Selective**

Front Unit .020-.031” ..... Pump ..... Thrust Washer  
 Middle Unit .020-.031” ..... Drum Support ..... Thrust Washer  
**Rear Unit**  
**Differential**  
**Chain Sprocket**

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### Clutch & Band/Solenoid Application Charts

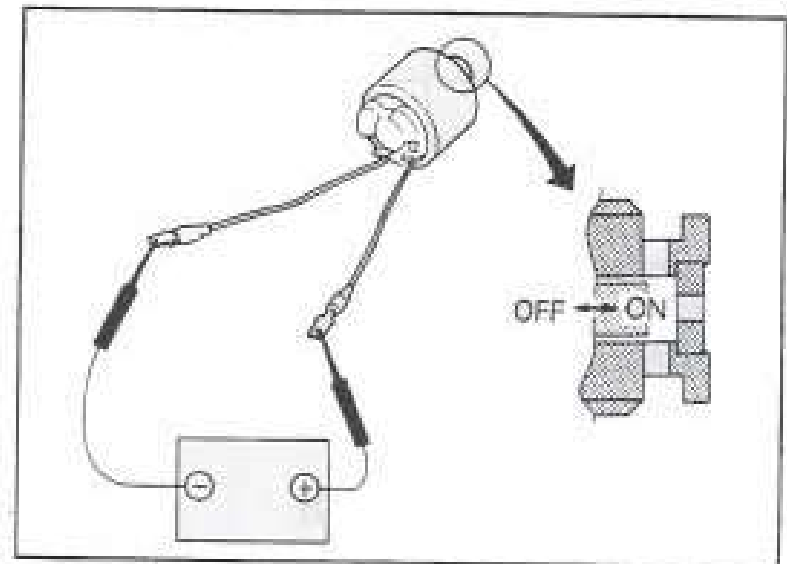
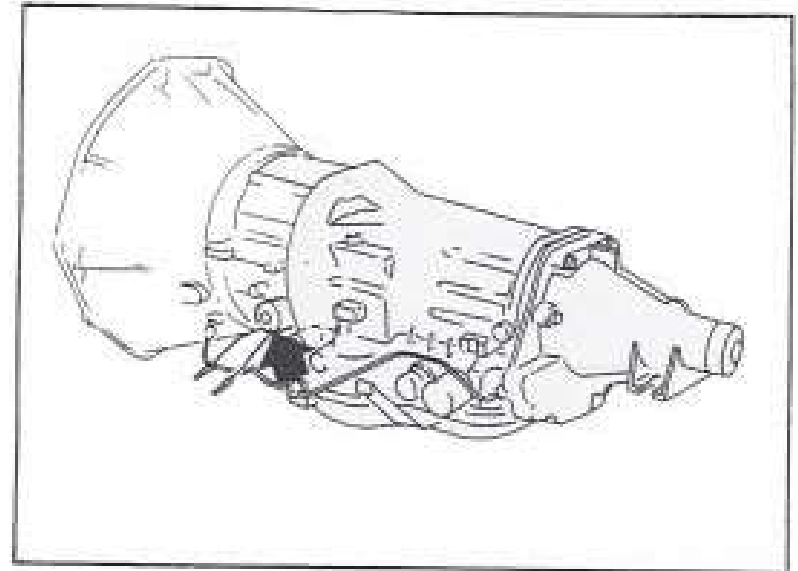
Gear		Direct Clutch	OD Band	Front Clutch	Rear Clutch	Low/Reverse Brake	2nd Band	1-Way Clutch
Reverse		Applied		Applied		Applied		
D	1st	Applied			Applied			Applied
	2nd	Applied			Applied		Applied	
	3rd	Applied		Applied	Applied			
	4th		Applied	Applied	Applied			
2	2nd	Applied			Applied		Applied	
1	1st	Applied			Applied	Applied		Applied
	2nd	Applied			Applied	Applied		

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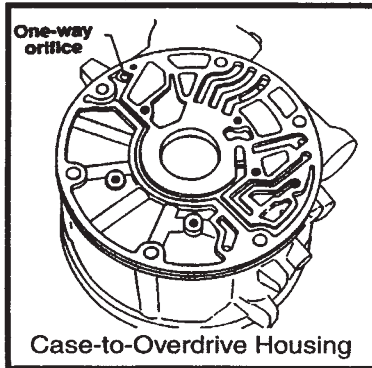
Technical Tips For Rebuilding This Unit



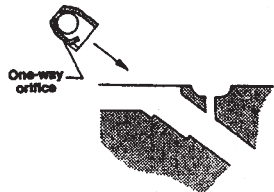
**Solenoid & Harness Information**



### Technical Tips For Rebuilding This Unit

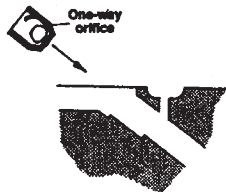


1. If the unit has an overrun sprag in the overdrive housing:



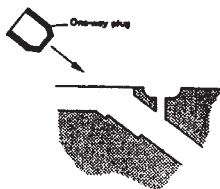
...Install the checkball capsule this way.

2. If the unit **doesn't** have an overrun sprag in the overdrive housing:

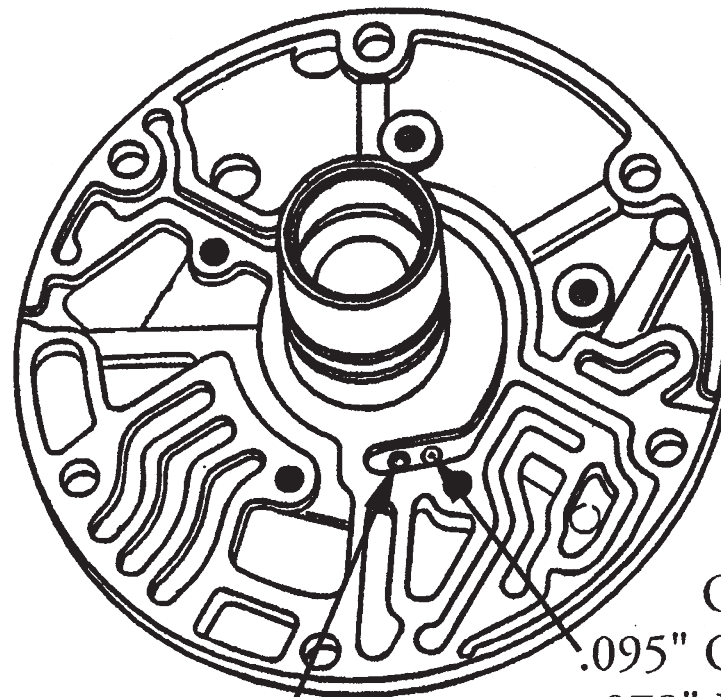


...Install the checkball capsule this way.

3. Some of the real early units (1984) didn't use a checkball capsule — they used a plug that **always** installs with the tapered side facing in, like this:



### Checkball Locations



Checkball (.195")

Orifice:

.095" One Cushion

.078" No Cushion

No Checkball - Two Cushions

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### Checkball Locations

**NOTE** Not all models have every orifice—all models have a TV and spring

