

Transmission Type...RL4F03A/RL4F03V

Rebuilder's Kwik
Reference Guide



Clutch Clearances

Forward Clutch018-.034" Pressure Plate
Intermediate Clutch		
Direct Clutch055-.071" Pressure Plate
Low/Reverse Clutch055-.071" Pressure Plate
Reverse Clutch019-.031" Pressure Plate
Overrun Clutch039-.055" Pressure Plate
Overdrive Clutch		

Adjusted By:

Torque Specifications

Pump Halves	62-97 In. Lbs.
Pump To Case	13-15 Ft. Lbs.
Valve Body Halves	44-62 In. Lbs.
Valve Body To Case	62-80 In. Lbs.
Chain Cover To Case	
Pan	44-62 In. Lbs.
Center Support	
Extension Housing	
Driven Sprocket Support	
Overdrive Support	
Chain Cover	
Transfer Gears	181-203 Ft. Lbs.
Governor Bolts	
Bellhousing To Main Case	
Idler Nut	181-203 Ft. Lbs.
Endcover Bolts	44-62 In. Lbs.

Band Adjustment

Intermediate Band	
2-4 Band	35-53 In. Lbs. 2.5 Turns
Low/Reverse Band	
Overdrive Band	

Unit Endplays

Location

Selective

Front Unit .010-.022"	Pump/Direct Drum	Bearing Race
Middle Unit		
Rear Unit		
Differential .000-.006"	Under Race	Shim
Chain Sprocket		
Reverse Clutch Drum .026-.039"	Pump/Reverse Drum	Thrust Washer

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Clutch & Band/Solenoid Application Charts

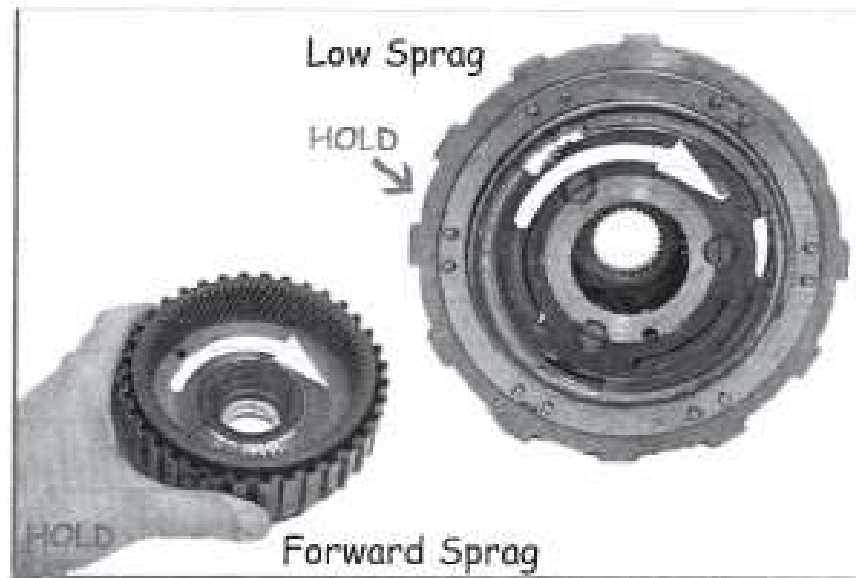
Gear		Reverse Clutch	High Clutch	Forward Clutch	Overrun Clutch	2nd Apply Band Servo	3rd Release Band Servo	4th Apply Band Servo	Forward 1-Way Clutch	Low 1-Way Clutch	Low/Reverse Brake
Reverse		Applied									Applied
D	1st			Applied	Applied (OD off)				Applied	Applied	
	2nd			Applied	Applied (OD off)	Applied			Applied		
	3rd		Applied	Applied	Applied (OD Off)		*		Applied		
	4th		Applied	*		Applied	*	Applied			
2	1st			Applied	Applied				Applied	Applied	
	2nd			Applied	Applied	Applied			Applied		
1	1st			Applied	Applied				Applied		Applied
	2nd			Applied	Applied	Applied			Applied		
* Applied but does not transmit power.											

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Technical Tips For Rebuilding This Unit

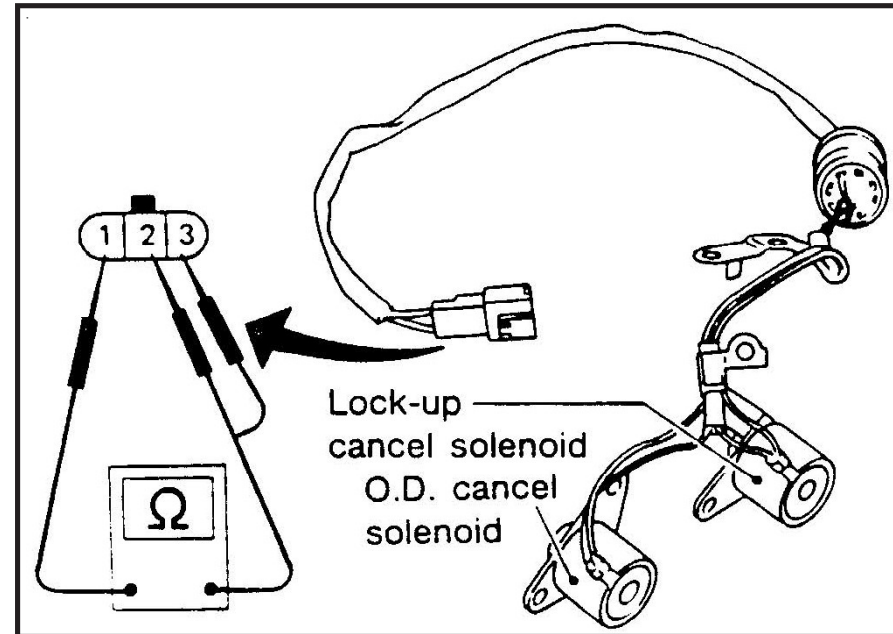
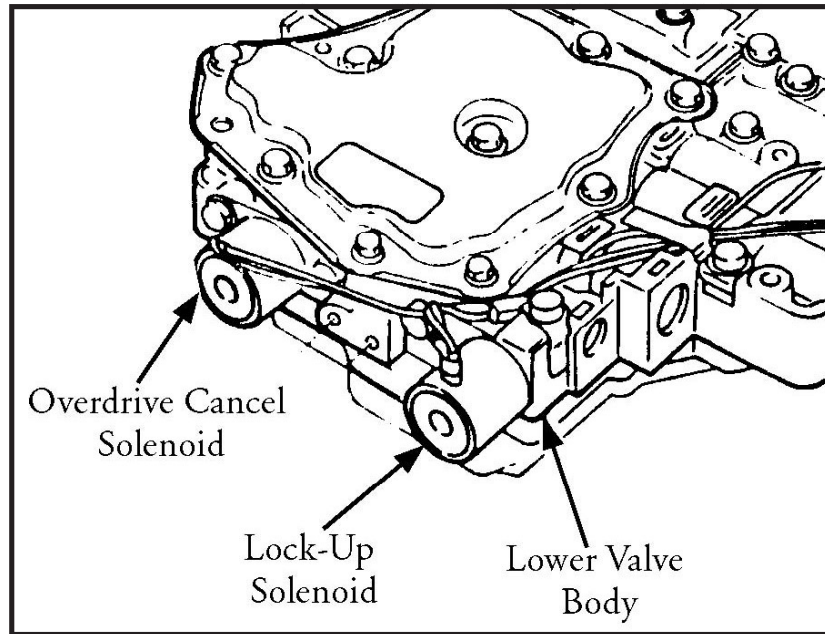


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Solenoid & Harness Information



#	Description	Resistance
1, 2	OD Cancel Solenoid	25 Ohms
1, 3	Lock-Up Cancel Solenoid	25 Ohms

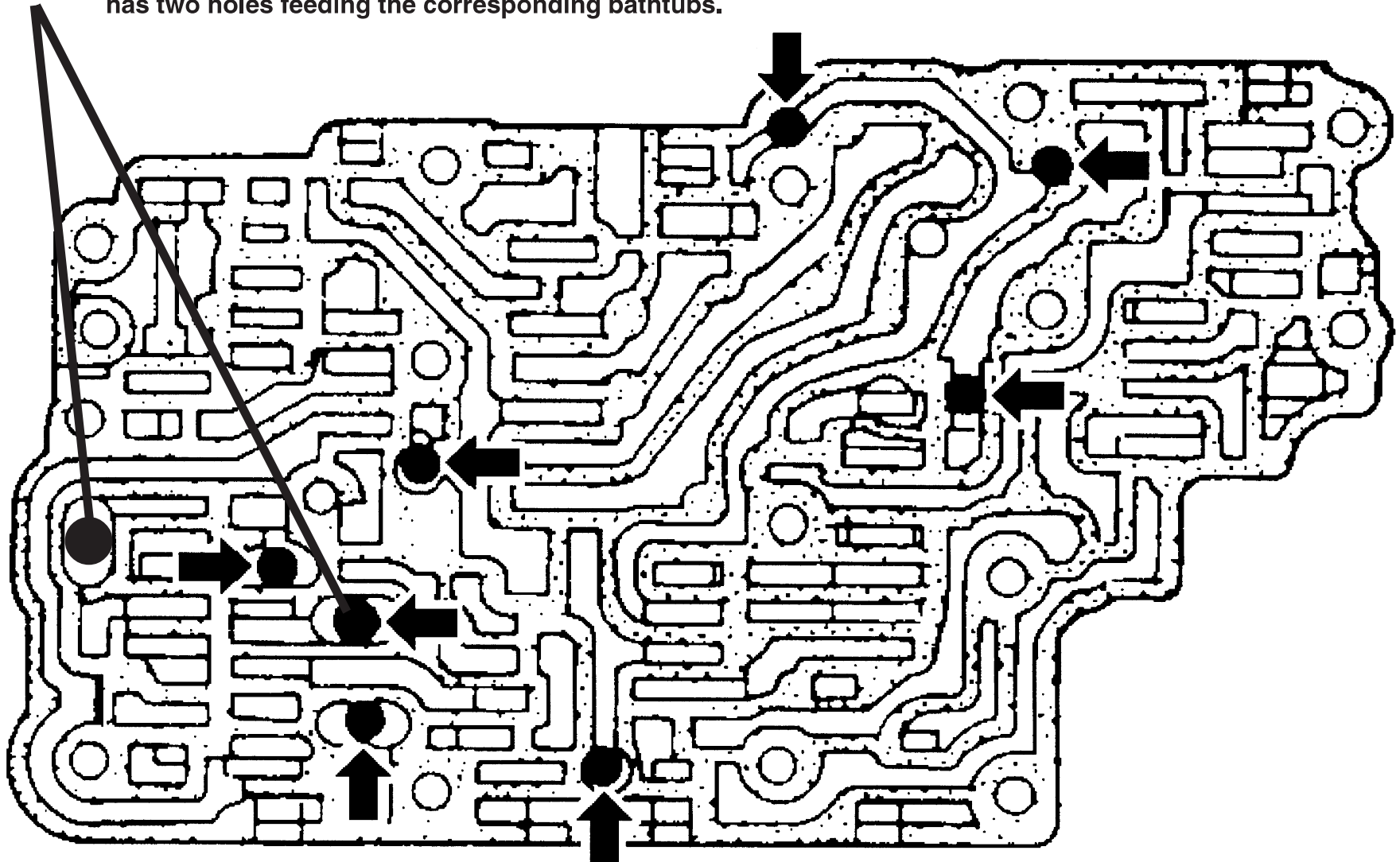
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Checkball Locations Upper Valve Body

NOTE Checkball is only used in the locations indicated if the separator plate has two holes feeding the corresponding bathtubs.



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Checkball Locations Intermediate Valve Body

