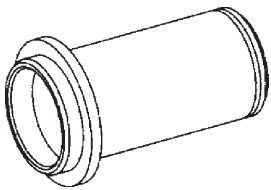
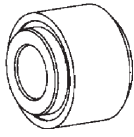
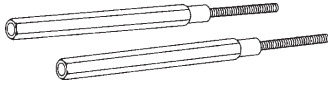
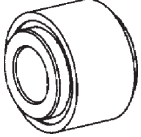
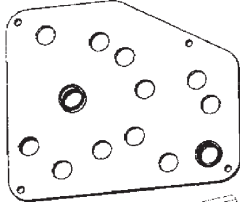
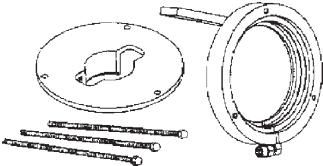
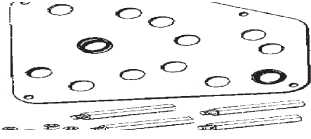
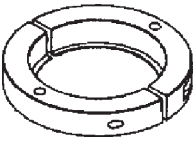
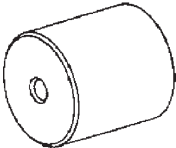
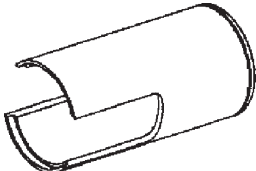


2.3 TRANSMISSION

2.3.1 SPECIAL TOOLS

			
<p>380001559 Transmission Torque Converter Seal Installation Tool</p>	<p>380001560 Transmission Input/ Output shaft seal installation tool</p>	<p>380001577 Transmission valve adjustment tool set</p>	<p>380001568 Transmission output shaft seal installation tool</p>

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<p>380001554 Nesting plate</p>	<p>380001556 Clutch pack holder and spring compressor tools</p>	<p>380001558 Alignment dowel set</p>
		
<p>380001555 Gear puller collet set</p>	<p>380001557 Clutch assembly holding knob set</p>	<p>380001567 Clutch spring compressor</p>

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2.3.2 SPECIAL TORQUES

Oil pipes	
Studs	9 Nm (80 lb-in)
Socket head screw	23 Nm (204 lb-in)
Screw plug	51 Nm (38 lb-ft)
Clutch K1, K2, K3, K4 Stud	17 Nm (150 lb-in)
Plugs	25 Nm (221 lb-in)
Output shaft	
Output shaft screws (apply Loctite 243 to threads)	23 Nm (204 lb-in)
Housing cover screws (apply Loctite 574 to threads)	46 Nm (407 lb-in)
Output flange screws	34 Nm (301 lb-in)
Oil feed housing and transmission pump	
Transmission pump screws	46 Nm (407 lb-in)
Oil feed housing screws	25 Nm (221 lb-in)
Engine connection and converter	
Input shaft screws	115 Nm (85 lb-ft)
Converter housing screws	68 Nm (50 lb-ft)
Cover	23 Nm (204 lb-in)
Converter cover	46 Nm (407 lb-in)
Input flange	34 Nm (301 lb-in)
Duct plate	
Screws	25 Nm (221 lb-in)
Screw plug	30 Nm (265 lb-in)
Hydraulic control unit	9.5 Nm (84 lb-in)
Filter	
Filter head screws	25 Nm (221 lb-in)
Oil distribution cover screws	25 Nm (221 lb-in)
Speed sensor and inductive transmitter	
Speed sensor screw	23 Nm (204 lb-in)
Inductive transmitter	30 Nm (265 lb-in)
Cover plate	23 Nm (204 lb-in)
Screw plug	140 Nm (103 lb-ft)

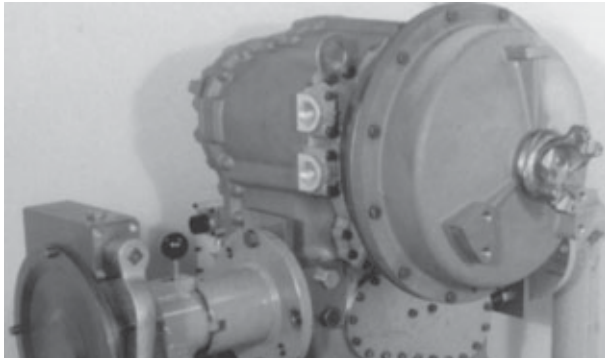
2.3.3 SPECIFICATIONS

Clutch KV and KR plate clearance	2.7 to 2.9 mm (0.106 to 0.114 in)
Clutch K1plate clearance	2.4 to 2.6 mm (0.094 to 0.102 in)
Clutch K2 and K3 plate clearance	1.8 to 2.0 mm (0.071 to 0.079 in)
Clutch K4 plate clearance	1.2 to 1.4 mm (0.047 to 0.055 in)

Note – The manufactured reserves the right to make improvements in design or changes in specifications at any time without incurring any obligation to install them on units previously sold.

2.3.4 DISASSEMBLY

STEP 1



GD98M833

Fasten transmission on an assembly stand using transmission mounting brackets.

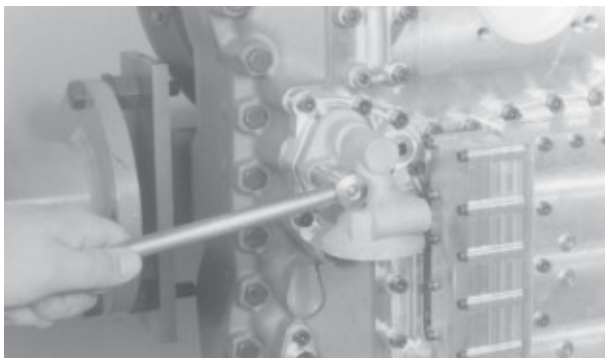
STEP 2



GD98M835

Remove and discard oil filter.

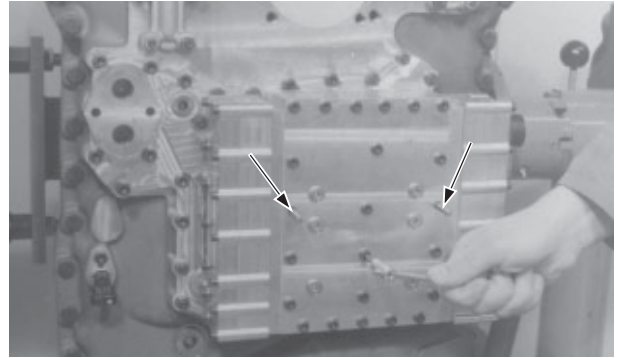
STEP 3



GD98M836

Remove hex head screws securing filter head. Remove filter head from transmission.

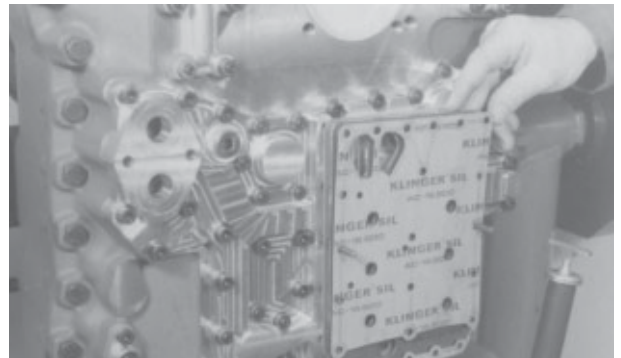
STEP 4



GD98M837

Remove two socket head screws and install **380001577** transmission valve adjustment tool set. Remove remaining 21 socket head screws securing control valve. Loosen and remove hex rods (part of **380001577**) from studs then remove control valve.

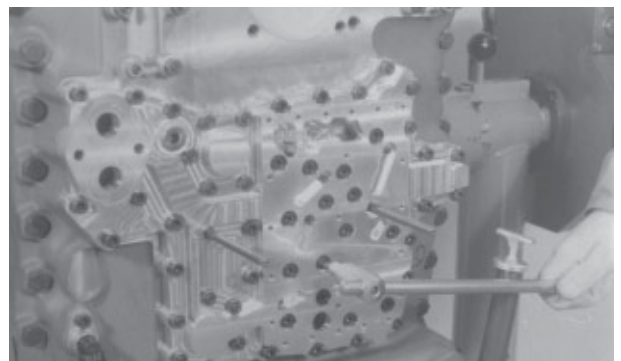
STEP 5



GD98M838

Remove both gaskets and the intermediate plate.

STEP 6



GD98M839

Remove socket head screws and hex nuts. Remove duct plate. Remove flat gasket.