

Smart-Tech® Forward Clutch Drum

Part No.

76654-01K

Patent No. 9,562,573

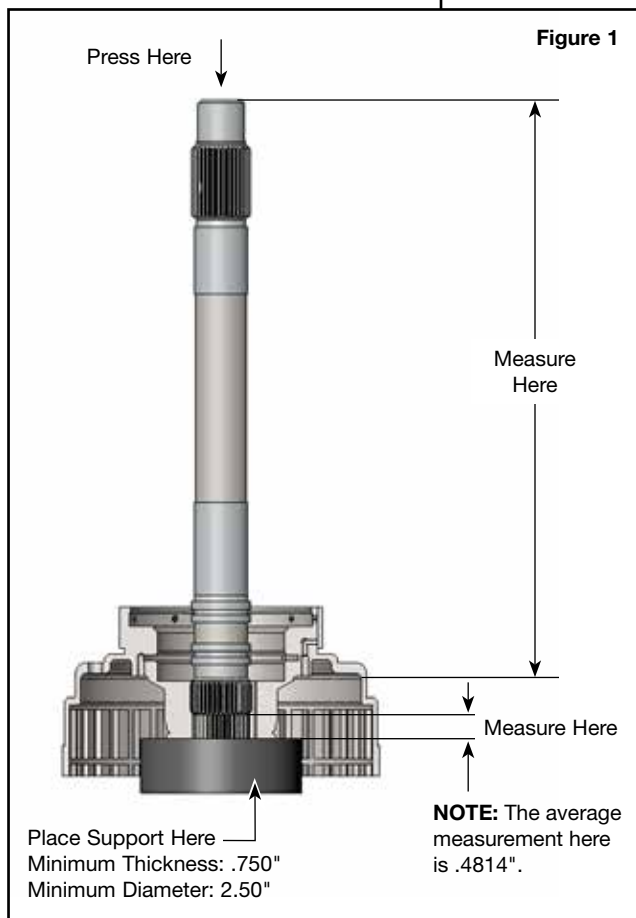


NOTE: Must use thickest OE wave spring (.082" thick — Ford part no. XL3Z-7E085-AA) with Sonnax kit **76654-01K**. If extra friction capacity is desired, Smart-Tech high capacity forward clutch drum kit **76655-01K** is available from your distributor.

Ford 4R70E, 4R70W, 4R75E, 4R75W, AOD, AODE



Figure 1



1. Disassembly

- Before removing OE input shaft, take and record measurement from either end of the input shaft to the drum as shown.
- Press input shaft out of OE forward drum.

2. Shaft Assembly

- Before pressing OE input shaft into Sonnax forward drum, support the center of the drum as shown.
- Use an appropriate high pressure lubricant (STP® oil treatment, 80/90 gear oil, or equivalent) when pressing the parts together.
- Press OE shaft into Sonnax drum (**Figure 1**) until shaft-to-drum measurement is equal to that recorded in disassembly step 1A.

3. Clutch Assembly & Clearance



NOTE: Recommended clutch clearance is .010–.014" per friction. Drum will accommodate (5) .061" frictions and (5) .068" steels.

- Assemble clutch pack, backing plate, and retaining ring.
- Verify clutch clearance by applying slight downward pressure on backing plate, then insert feeler gage between retaining ring and backing plate.
- If more or less clearance is required, change the selective thickness retaining ring (**Figure 2, page 2**).

Figure 2

NOTE: To replace an AOD cast forward drum requires updating related components with AODE versions. Update forward clutch pack with AODE style friction, steel & waved plates, backing plate and retaining ring. Additionally, either:

1. Machine tips of reluctor from forward drum OR:
2. Update sun gear shell and Reverse drum with AODE versions.

Retaining Rings	OE Part Numbers	Thickness
	5L3Z-7D483-D	.094"
	5L3Z-7D483-C	.084"
	5L3Z-7D483-B	.075"
	5L3Z-7D483-A	.070"