

## Smart-Tech® Direct Clutch Drum & Shaft Kit

### Part No.

## 76656-01K

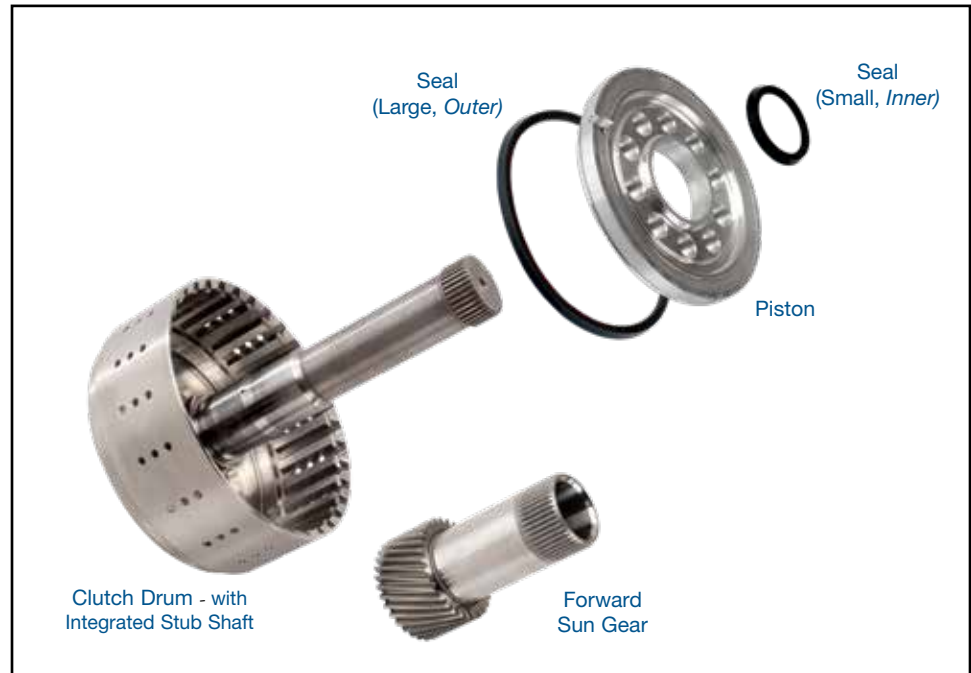
- Forward Sun Gear 31-Tooth
- Clutch Drum - with Integrated Stub Shaft
- Piston
- Seal Large, Outer
- Seal Small, Inner

Patent Pending



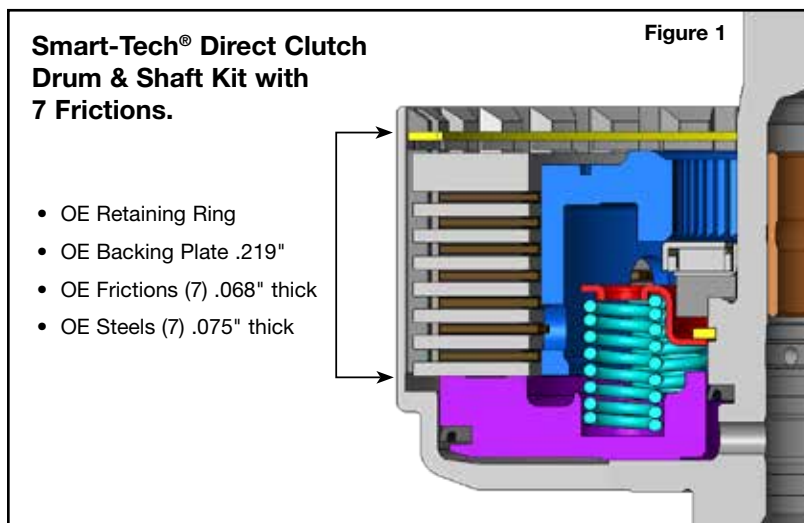
**NOTE:** Fits all 2.84/1.55 gear sets.

## Ford 4R70E, 4R70W, 4R75E, 4R75W



### 1. Clutch Assembly Information

This Smart-Tech® direct clutch drum and shaft kit is set up to accommodate one additional 4R70W OE thickness friction plate and steel plate for a total (7) .068" frictions and (7) .075-.079" steels with OE .219" thick backing plate. Other clutch/steel combinations are possible. OE recommended clutch clearance is .010-.014" per friction. See list of selective retaining rings for adjusting clutch clearance (**Figure 2**).



- Assemble inner lip seal onto shaft portion of drum (**Figure 1**).
- Assemble outer lip seal onto piston.
- Install piston into Sonnax direct drum. Special lip seal protector installation tools are available to help with piston installation. Reference OE tool T80L-77254-A.
- Install return spring and retainer.
- Install clutches, steels, backing plate and retaining ring (**Figure 1**).
- Check clutch clearance by maintaining downward pressure on backing plate, and measuring clearance between backing plate and retaining ring.
- Adjust clearance as necessary with selective retaining rings (**Figure 2**) or different thickness steels.

### 2. Unit Assembly

- a. Follow published assembly procedures for 4R70E, 4R70W, 4R75E and 4R75W transmissions.
- b. Assemble transmission with Sonnax clutch drum– with integrated stub shaft into transmission in place of OE direct drum and stub shaft.
- c. Install Sonnax 31-tooth Forward sun gear in place of OE Forward sun gear.

Figure 2

Retaining Rings	OE Part Numbers	Thickness
	F3AZ-7D483-A	.052"
	F3AZ-7D483-B	.066"
	F3AZ-7D483-C	.080"
F3AZ-7D483-D	.094"	