sonnax®
PERFORMANCE

HIGH PERFORMANCE **TRANSMISSION** PARTS

Instructions

Ford 5R110W

High Capacity Direct Clutch Apply Piston Kit

Part No. 36965-01K

- Backing Plate
- Apply Plate
- Apply Piston

NOTE: See optional clutch lubrication modification on page 3.

1. Disassembly

a. Dismantle direct clutch assembly using OEM-recommended methods and procedures.

b. Discard OE apply piston, apply plate, and backing plate. Set aside remaining components for reuse.

2. Installation & Assembly

This direct clutch apply piston kit is designed to use one additional 5R110W OE thickness (.077") friction plate for a total of five, and four OE thickness steels (.080") with the included Sonnax apply plate, backing plate, and apply piston. Other clutch/steel combinations are possible. OE recommended clutch clearance is .050–.068". See selective retaining ring chart (**Figure 1**) for adjusting clutch clearance.

a. Install Sonnax apply piston into housing assembly (**Figure 2**).

b. Reinstall OE return spring.

c. Install OE piston dam. Using appropriate tools, compress piston dam just far enough to allow OE piston dam retaining ring installation.

WARNING: Use care to avoid damaging inner and outer sealing lips on piston dam. Compressing the piston dam too far will cause inner seal lip damage.

d. Install Sonnax piston apply plate (**Figure 2**).

e. Reinstall or replace OE steel plates and frictions following OEM-recommended methods and procedures making sure to include one additional friction.

f. Install Sonnax backing plate (**Figure 2**).

g. Reinstall or replace OE backing plate retaining ring.

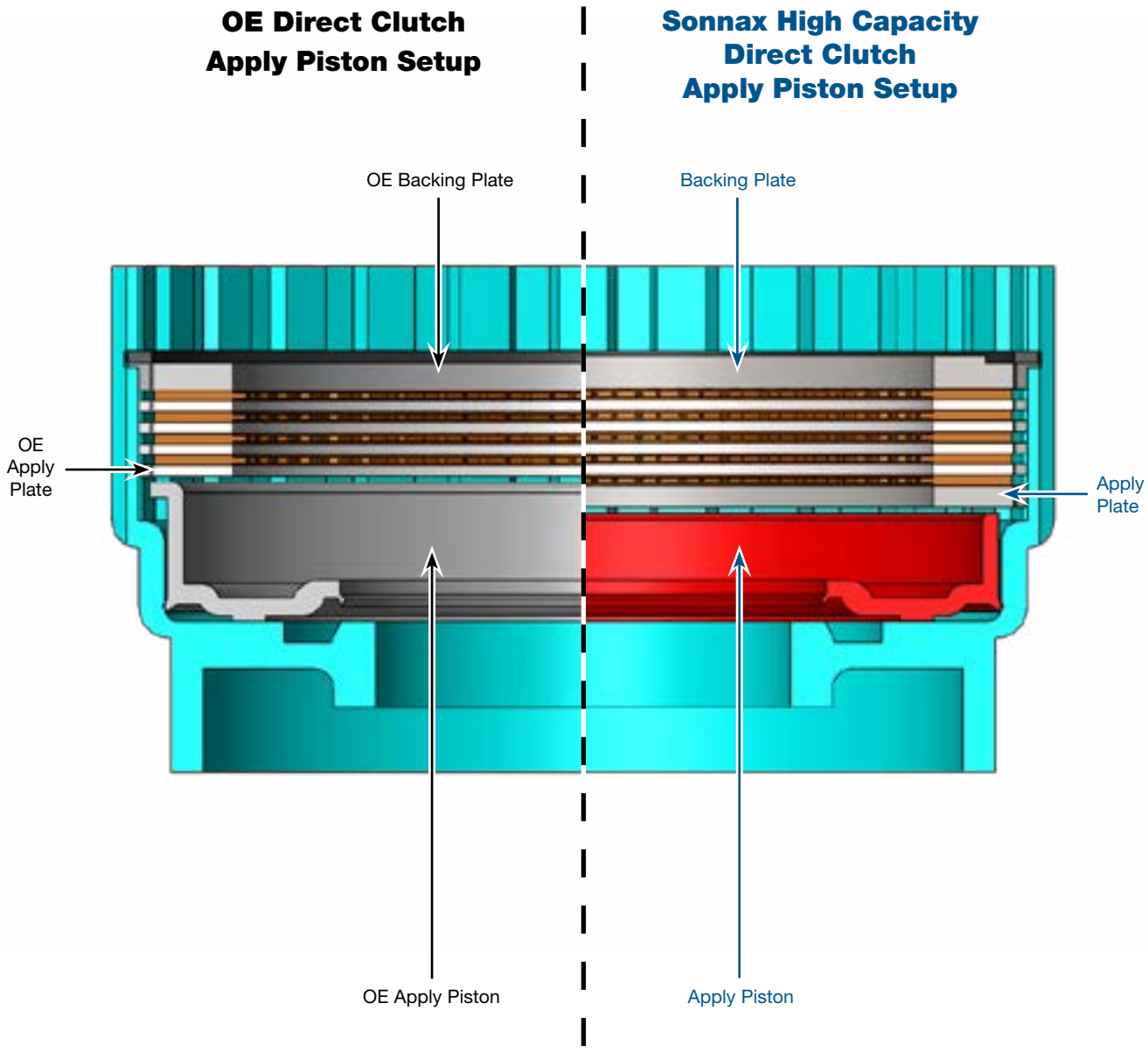
NOTE: OE retaining ring is selective and is available in varying thicknesses to allow for proper setting of clutch clearance (**Figure 1**).

OE Retaining Ring Thickness **Figure 1**

Part No.	mm	Inches
377444-S	2.34–2.44	.092–.096"
377128-S	2.11–2.21	.083–.087"
377127-S	1.88–1.98	.074–.078"
377126-S	1.65–1.75	.065–.069"
377437-S	1.42–1.52	.056–.060"

800-843-2600 • 802-463-9722 • F: 802-463-4059 • www.sonnax.com

Figure 2

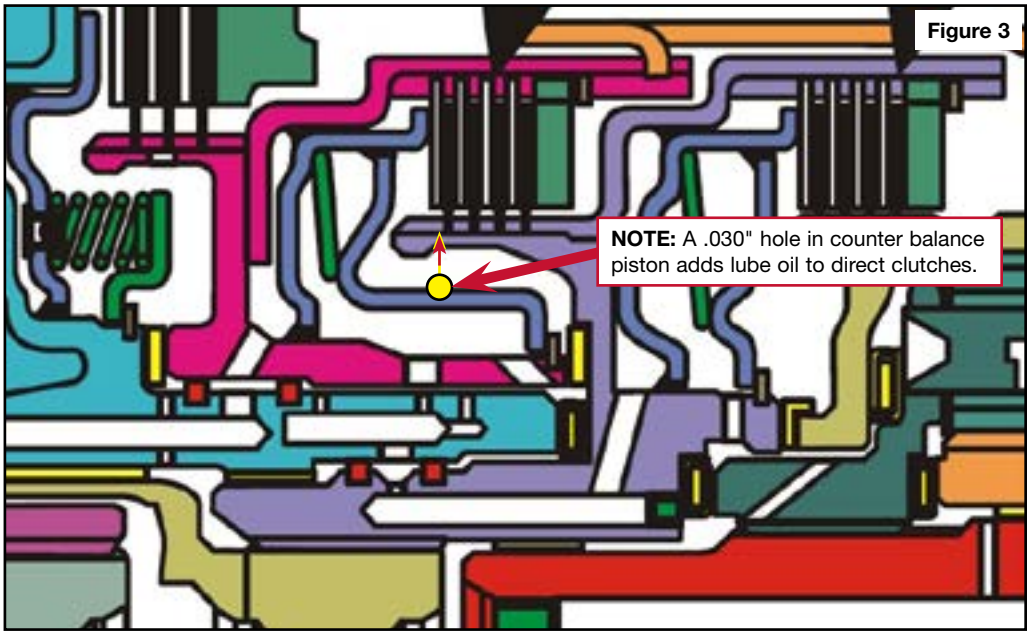


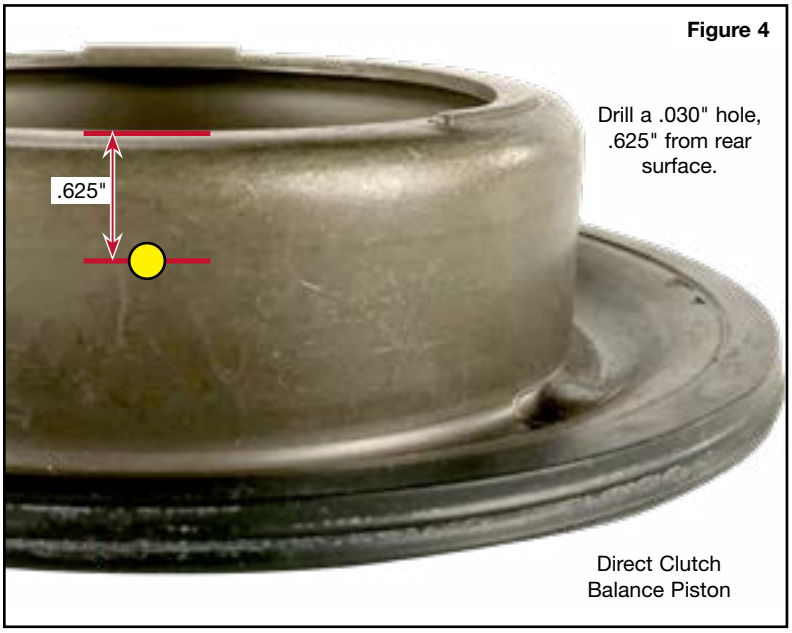
800-843-2600 • 802-463-9722 • F: 802-463-4059 • www.sonnax.com

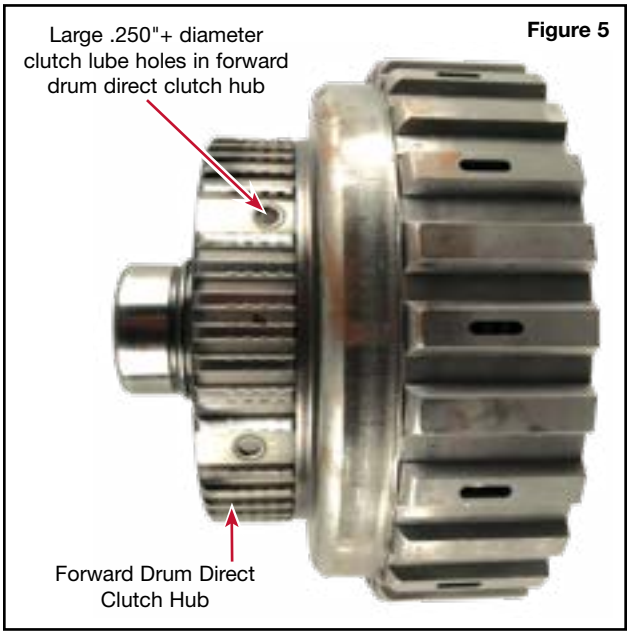
OPTIONAL: Direct clutch lube modification to direct counter balance piston.

Overall failure rate of direct clutch and high prevalence of failure seen in higher revving smaller displacement gas applications indicates a possibility of insufficient open clutch lube oil.

Due to large diameter clutch lube holes in forward drum, direct clutch hub (**Figure 5**), intended clutch lube oil may exit rear holes thereby reducing lube oil to front holes and front friction discs. Modification outlined below (**Figures 3 & 4**) supplies extra direct clutch lube oil in line with front lube holes in forward drum direct clutch hub.







800-843-2600 • 802-463-9722 • F: 802-463-4059 • www.sonnax.com