

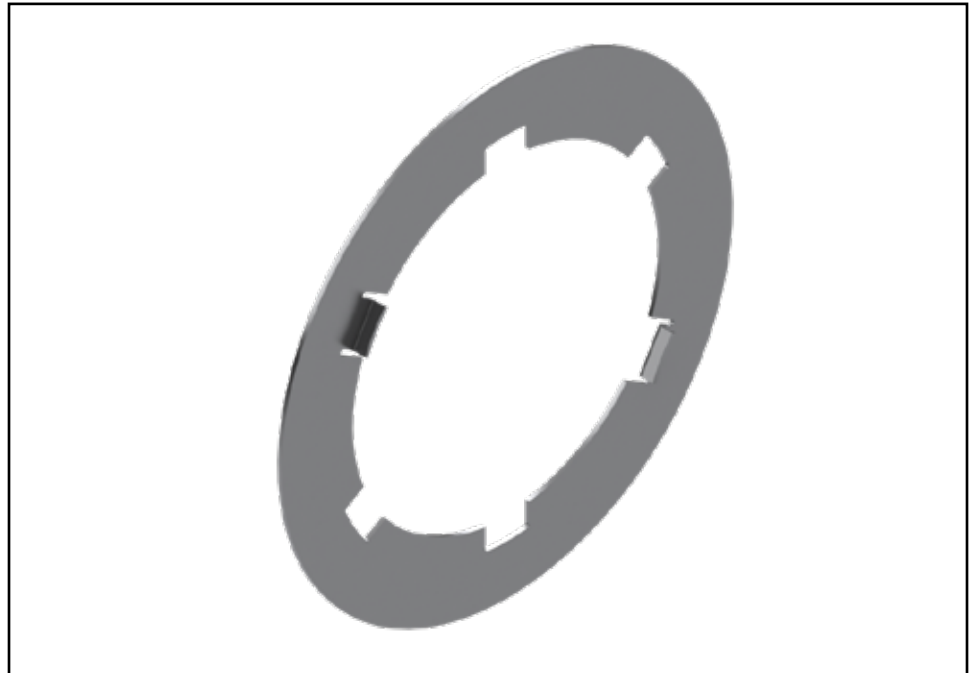
Ford 6R140

Wear Plate

Part No.

FD-WS-40

NOTE: For use in units with spring and roller one-way clutch.



1. Disassembly

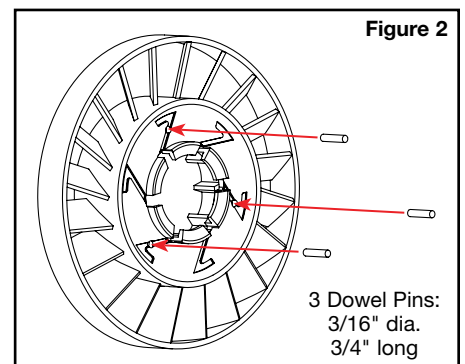
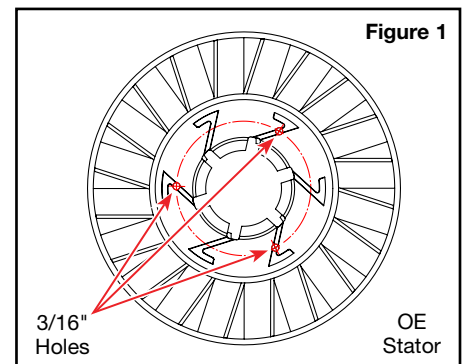
Remove stator cap, inner race, ten springs and ten rollers.

2. Outer Race Removal

- Place a mark on both the stator and outer race to ensure outer race gets reassembled in the same location.
- End mill three 3/16" holes in the fixed side of the stator, at the oil grooves, 3.5" dia. around the center. Do NOT mill into the outer race (**Figure 1**).
- Using three 3/16" dia., 3/4"+ long slip fit dowel pins, press out the outer race (**Figure 2**).

3. Machine Stator

- Verify OD of **FD-WS-40**, which measures 3.485–3.515".
- Machine a pocket on the worn stator surface to the thickness of **FD-WS-40** (.0275–.0325") to ensure **FD-WS-40** sits at or below the original stator surface (**Figure 3**).



3. Machine Stator (continued)

- c. This can be achieved by undercutting the O.D. (Figure 4) or ensuring the tool radius is outside the O.D. of FD-WS-40 (Figure 5).

4. Reassemble Stator

Option 1:

- a. Using the two locating/bent tabs on the FD-WS-40, line up the oil slots in FD-WS-40 with the oil slots in stator.
- b. Line up marks, made during step 2, on the stator and the outer race and re-press outer race in.

Option 2:

- a. Using the two locating/bent tabs on the FD-WS-40, line up the oil slots in FD-WS-40 with the oil slots in stator.
- b. Use pins or stakes in between the outer race and the stator to ensure the race will not spin.
- c. Reassemble rollers, springs and inner race.
- d. Re-swedge stator cap in place.

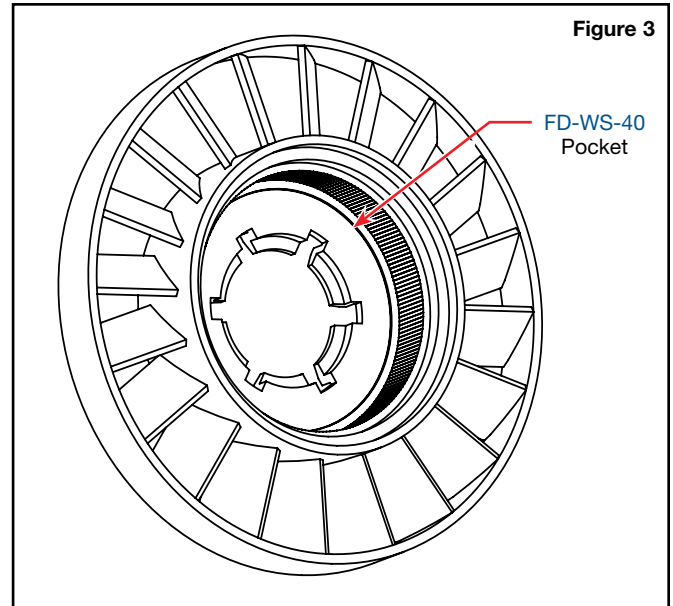


Figure 3

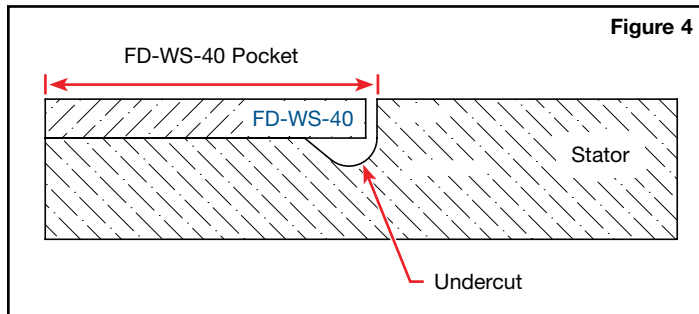


Figure 4

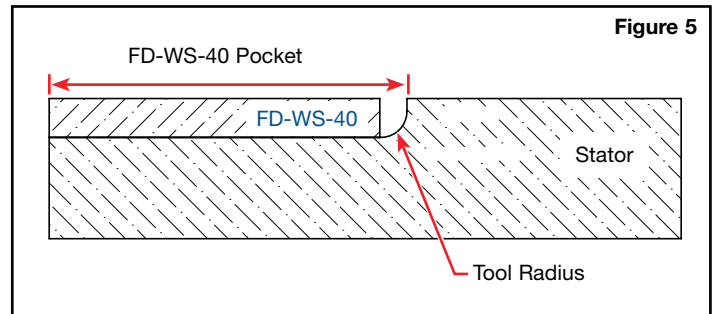


Figure 5

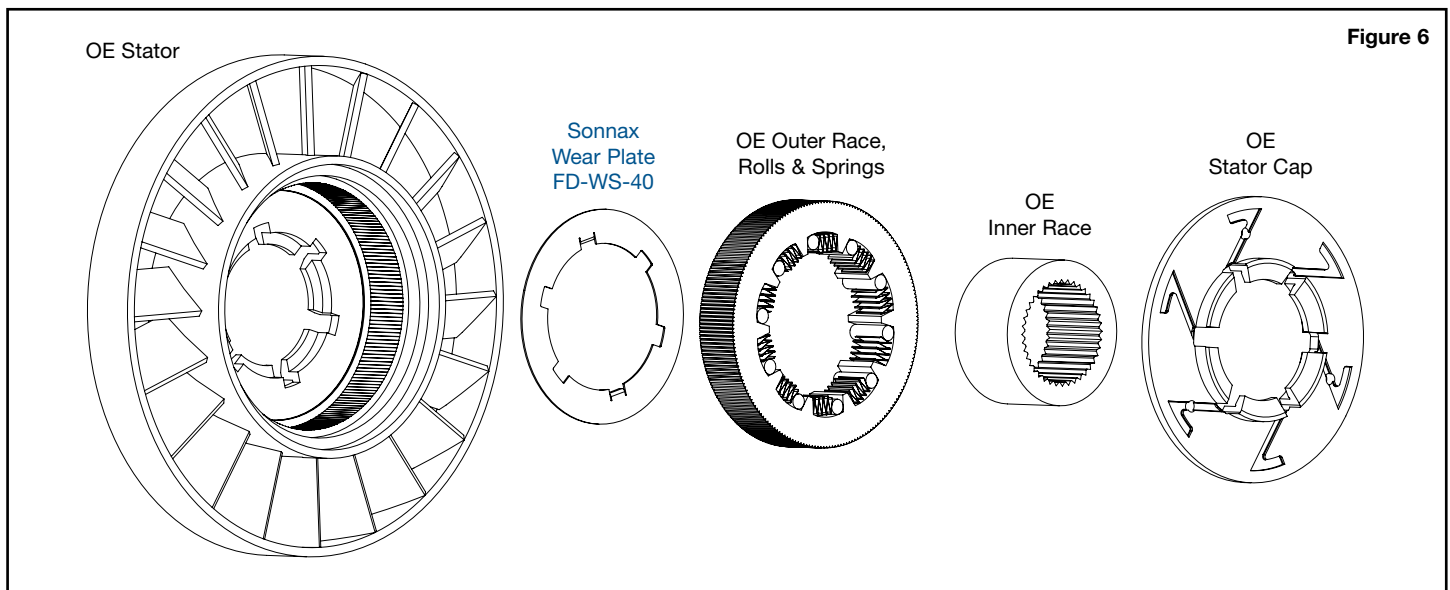


Figure 6