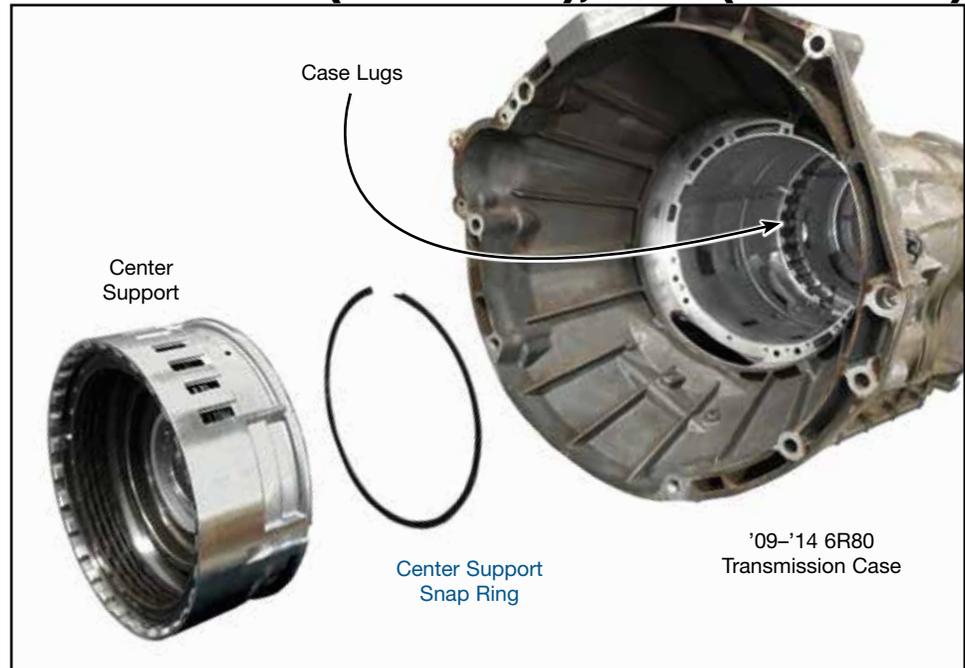


Ford 6R60, 6R75, 6R80 (2009–2014), 6R80 (2015-Later)

Center Support Snap Ring

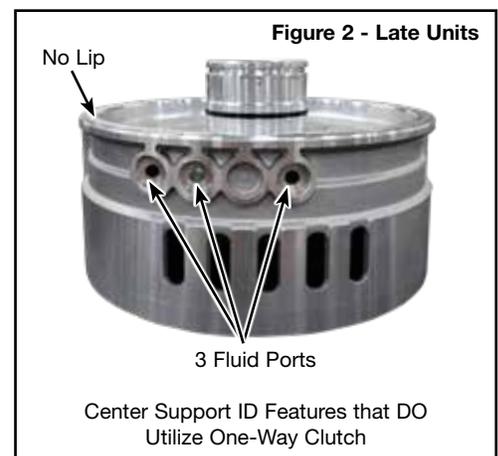
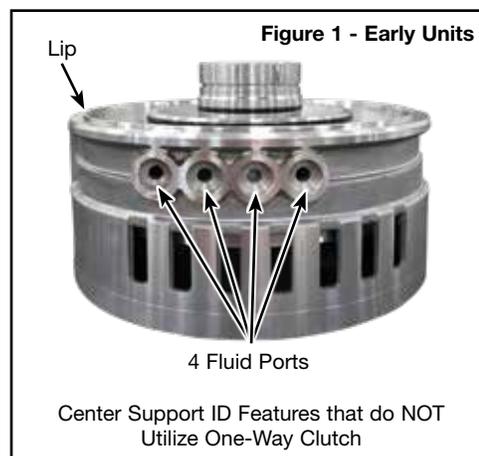
Part No.

95630-01



1. Identify Center Support

- Early units ('09-'14) did not utilize a one-way clutch. The center support in these units can be identified by four open fluid ports as well as a lip on the face that contacts the lugs (**Figure 1**).
- Later units ('15-later) that utilize a one-way clutch have three open fluid ports and no lip on the lug contact surface (**Figure 2**).



2. Preparation for Machining

- Remove components from center support (piston, clutches etc.), including outer alignment blocks (**Figure 3**). Save for reinstallation.
- Measure and record thickness of Sonnax snap ring; it will be between .045–.049" thick.



NOTE: This thickness will be the depth of material removed from center support face, starting at the shiny, unworn surface (**Figure 4**).

3. Machine Center Support

Machine the thickness of the Sonnax snap ring (**Step 2b**) from the center support face as indicated (**Figure 5, Dimension C**).

4. Verify Post-Machining Lip Height

- With One-Way Clutch: The lip created by the cut will be .045–.049" tall.
- Without One-Way Clutch: Lip height post-machining will be .125–.129" tall.

5. Installation & Assembly

- Clean all debris from the center support. Inspect the machined surface and the O.D. of the center support to ensure there is no raised material. Remove all burrs.
- Reinstall alignment blocks, piston and clutches into center support.
- Clean and remove all debris from the transmission walls and case lugs.
- Install Sonnax snap ring into the transmission bore. Ensure that it rests firmly against the case lugs that center support rests on (**Figure 6**).
- Install center support, ensuring it rests flush on snap ring.

