

## Internal Reassembly

**1** Begin Main Case Assembly

With all subassemblies complete, you're ready to assemble the main case, which begins with the number-9 thrust washer at the roller clutch. You can see that the roller clutch outer race has already been installed. Lubricate the thrust washer with transmission assembly lube.

**2** Install Roller Clutch Spring Retainer

Roller clutch spring retainer (also called a cage) is next. Some incorrectly call this a sprag clutch.

**3** Inspect Inner Race

The roller clutch's inner race ultimately splines inside the low-reverse drum once the roller clutch is assembled. It is shown here with the low-reverse drum and hub. The roller clutch (not pictured) allows low-reverse drum rotation one way, but not the other.

**4** Install Inner Race

Get the springs backward, which results in prompt transmission failure. Spring lip must point toward the outside of the case at the roller and toward the inside opposite the roller. Rollers lock against the rise in the case, which is how this works as a one-way clutch. Like a ratchet in your toolbox, the one-way clutch allows rotation only one way.

## Documentation Required



The inner race fits in the center of the roller clutch. Note how the spring retainer, roller, and spring go together—with only one set installed here. There are 12 rollers and 12 springs. Install the springs as shown here. It is easy to



## Roller Clutches

Roller clutches bite amateurs and professionals alike because it's so easy to make a mistake here. Don't be in a hurry. Roller clutch malfunction comes from improper assembly—mostly springs installed backward. Pay very close attention to detail here. Even one roller spring installed backward causes transmission failure. ■

# How To Rebuild And Modify Ford Caud Automatic Transmissions

**CL Gary**



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