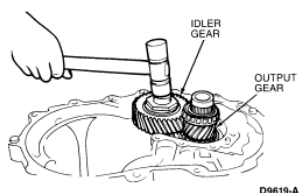


**Transaxle, Assembly****Assembly**

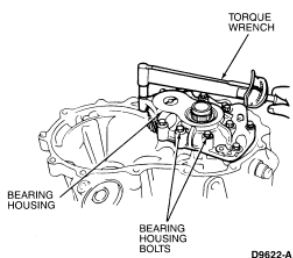
## Tools Required:

- Turbine Shaft Holder T88C-77000-KH
- Converter Seal Replacer T88C-77000-BH

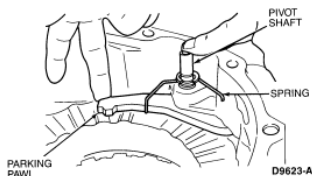
1. Align the bearing cover with guide bolts. Press the bearing cover into the torque converter housing.
2. Tighten the torque converter bearing cover bolts to 11-14 Nm (8-10 lb-ft).
3. Install the idler gear and output gear as an assembly by lightly tapping them in with a hammer.



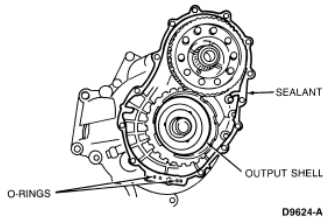
4. Install the output gear bearing housing onto the torque converter housing.
5. Align the groove on the idler shaft with the mark on the bearing housing.
6. Install the output gear bearing housing bolts and tighten to 19-26 Nm (14-19 lb-ft).



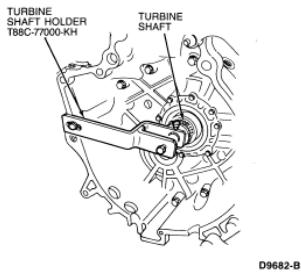
7. Tap a new roll pin into the bearing housing using a 5/32-inch pin punch and hammer.
8. Install the parking pawl and shaft.
9. Install the shaft spring and snap clip.



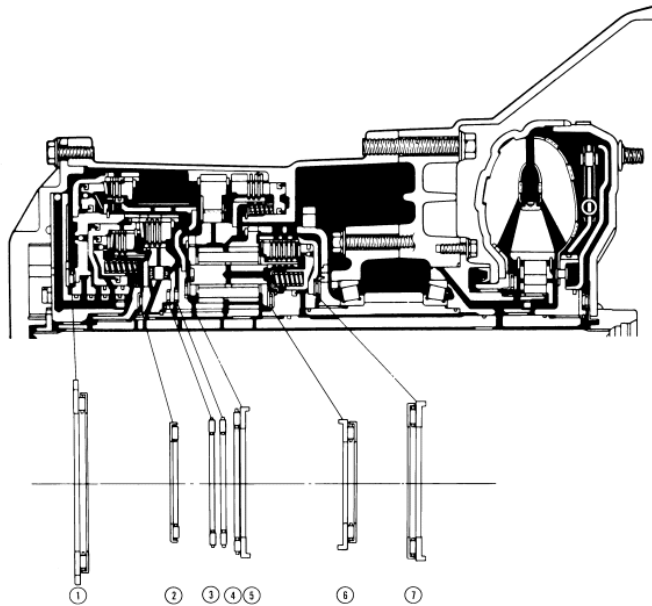
10. Install the parking pawl actuator support with new bolts. Tighten the parking pawl actuator bolts to 11-14 Nm (8-10 lb-ft).
11. Install the detent lever and return spring.
12. Install the parking assist lever.
13. Install the detent lever holder and bolt. Tighten the detent lever holder bolt to 8-11 Nm (69-95 lb-in).
14. Install the manual shaft.
15. Install the detent plate, washer, and nut securing the manual shaft. Tighten the manual shaft nut to 41-55 Nm (30-41 lb-ft).
16. Install the differential assembly.
17. Install the output shell to the output gear.
18. Apply a thin coat of silicone sealant to the contact surfaces of the torque converter housing and transaxle housing.



19. Install new O-rings onto the oil passage ports.
20. Attach the transaxle case to the torque converter housing. Tighten the transaxle case-to-converter housing bolts to 37-52 Nm (27-38 lb-ft).
21. If necessary, install the low and reverse clutch. Refer to the low and reverse clutch assembly procedure in this section.
22. Install Turbine Shaft Holder T88C-77000-KH to the transaxle.



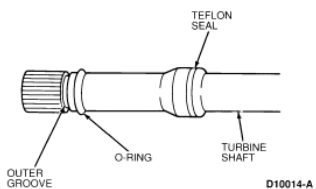
**Bearing and Thrust Washer (Race) Locations**



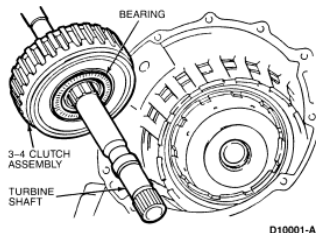
		1	2	3	4	5	6	7
Bearing	mm(in)	86.0 (3.39)	56.1 (2.21)	58.0 (2.28)	58.0 (2.28)	86.0 (3.39)	56.1 (2.21)	72.1 (2.84)
Race	mm(in)	88.0 (3.46)				84.0 (3.31)		

D9621-A

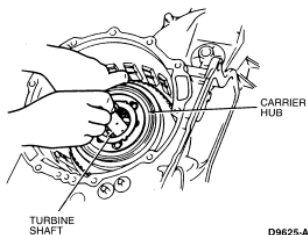
23. Assemble the turbine shaft and 3-4 clutch assembly.  
**NOTE: The O-ring should be installed on the inner groove of the turbine shaft.**
24. Position the needle bearing between the 3-4 clutch assembly and the thrust washer on the output shell.



25. Install the turbine shaft and the 3-4 clutch assembly into the transaxle housing.



- 26. Install the internal ring gear into the 3-4 clutch assembly.
- 27. Install the snap ring.
- 28. Position the needle bearing and thrust washer between the carrier hub assembly and the 3-4 clutch drum.
- 29. Hold the turbine shaft with one hand.
- 30. Install the carrier hub into the 3-4 clutch drum by rotating it to align the carrier hub with the 3-4 clutch pack.



31. Install the low and reverse clutch assembly.

The order of installation is as follows:

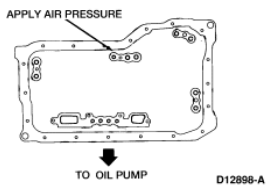
1. Driven plate
2. Drive plate
3. Driven plate
4. Drive plate
5. Driven plate
6. Drive plate
7. Driven plate
8. Drive plate

- 32. Install the retaining plate.
- 33. Install the snap ring.
- 34. Measure the clearance between the snap ring and the pressure plate. If it is not within specification 2.1-2.4mm (0.083-0.094 inch), select the appropriate snap ring from the chart.

2.0 mm (0.0787 in)	2.2 mm (0.0866 in)	2.4 mm (0.0945 in)
2.6 mm (0.1024 in)	2.8 mm (0.1102 in)	3.0 mm (0.1181 in)

CD9802-A

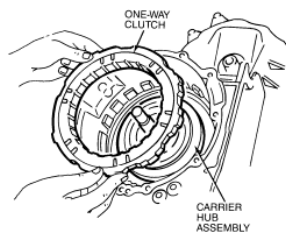
35. Verify the proper operation of the low and reverse clutch by applying 392 kPa (57 psi) of compressed air through the fluid passage as shown.



36. Install the large wave spring.

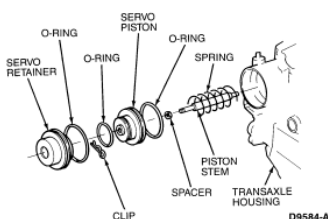
**CAUTION:** The one-way clutch can be installed improperly. Be certain that after installing the one-way clutch, you can rotate the carrier by hand in a counterclockwise direction while working from the rear side of the transaxle. If the one-way clutch is installed improperly, gear ranges may not function or the geartrain may lock up. This may cause overheating of the transaxle and unnecessary overhauling of the unit.

37. Install the one-way clutch horizontally. Rotate the carrier counterclockwise while installing the one-way clutch.



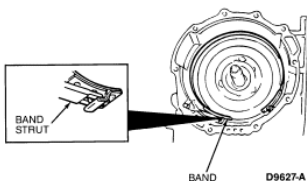
D9626-A

38. Install the snap ring.  
 39. Install the wave ring.  
 40. Install the servo assembly and spring into the transaxle housing.  
 41. Compress the servo assembly into its bore and install the servo snap ring.



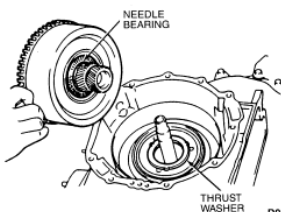
D9584-A

42. Install the band anchor strut and the band anchor shaft into the transaxle housing.  
 43. Install the 2-4 brake band into the transaxle housing so it is fully expanded.  
 44. Interlock the band and band strut as shown.



D9627-A

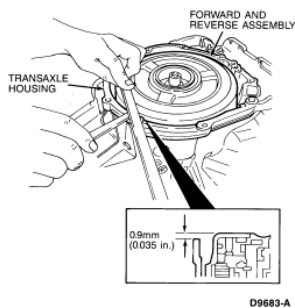
45. Position the needle bearing and the thrust washer.



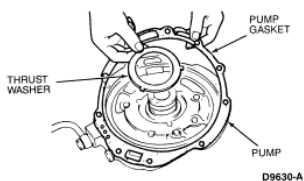
D9628-A

46. Install the small sun gear and one-way clutch assembly.  
 47. Rotate the one-way clutch assembly to line up the clutch pack.  
 48. Install the thrust bearing into its correct position.  
 49. Install the reverse clutch assembly while rotating it to align the clutch pack.  
 50. Position the needle bearing on the one-way clutch assembly.  
 51. Install the forward and reverse clutch drum assembly.

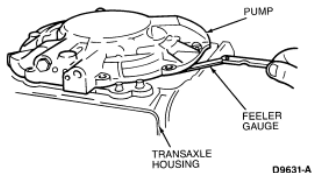
**NOTE:** Measure the height difference between the forward and reverse drum and the transaxle housing. Maximum clearance should be 0.9mm (0.035 inch).



- 52. Install the turbine shaft snap ring into the bottom groove of the turbine shaft.
- 53. To adjust the total end play, set the bearing onto the forward and reverse clutch assembly.
- 54. Remove the previously used thrust washer and gasket located on the pump.



- 55. Set the thickest thrust washer, 2.2mm (0.087 inch), on the oil pump.
- 56. Set the oil pump onto the clutch assembly.
- 57. Using a feeler gauge, measure the clearance between the transaxle housing and the oil pump.

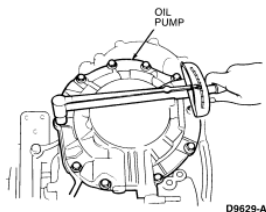


- 58. Select a suitable thrust washer.

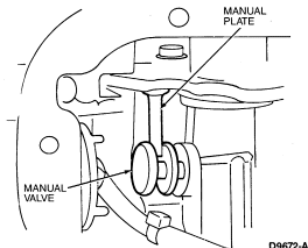
Clearance A mm (in)	Select this thrust washer mm (in)
0.91-1.10 (0.036-0.043)	1.2 (0.047)
0.71-0.90 (0.028-0.035)	1.4 (0.055)
0.51-0.70 (0.020-0.027)	1.6 (0.063)
0.31-0.50 (0.012-0.019)	1.8 (0.071)
0.11-0.30 (0.004-0.011)	2.0 (0.078)
0-0.10 (0)	2.2 (0.087)

D9704-B

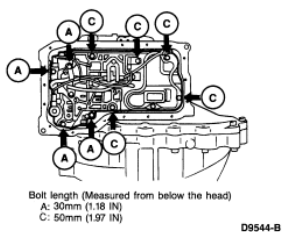
- 59. Remove the oil pump.
- 60. Place the selected thrust washer and a new gasket onto the oil pump.
- 61. Install the oil pump onto the clutch assembly. Secure it with the oil pump-to-transaxle housing bolts. Tighten the oil pump-to-transaxle housing bolts to 19-26 Nm (14-19 lb-ft).



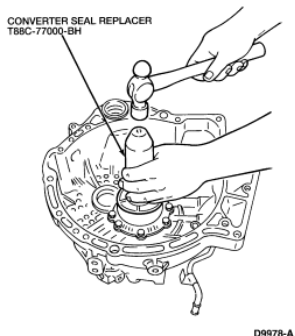
62. Install a new O-ring onto the kickdown cable bracket and insert the cable into the transaxle.
63. Connect the kickdown cable to the throttle lever in the transaxle.
64. Install the kickdown cable bracket and secure with a bolt. Tighten the kickdown cable bracket-to-transaxle bolt to 8-11 Nm (69-95 lb-in).
65. Connect the solenoid connector.
66. Install the electric wire retaining clip.
67. Position the valve body to the transaxle housing. Align the manual valve with the pin on the manual plate.



68. Install the bolts securing the valve body. Refer to the illustration for bolt lengths and positions. Tighten the valve body-to-transaxle bolts to 8-11 Nm (69-95 lb-in).



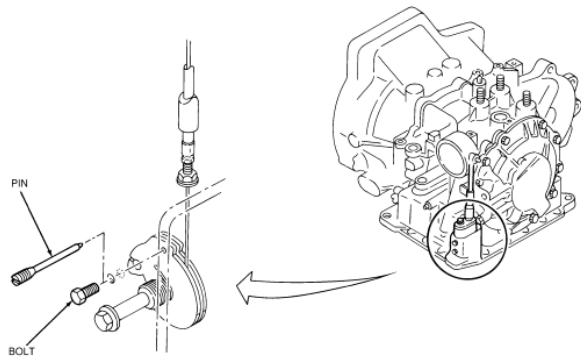
69. Connect the wiring connectors on the valve body.
70. Install a new gasket onto the oil pan. Be certain to properly position the magnets in the pan.
71. Position the oil pan onto the transaxle. Tighten the oil pan bolts to 8-11 Nm (69-95 lb-in).
72. Install the pulse signal generator and solenoid connector. Tighten the pulse signal generator retaining bolt to 8-11 Nm (69-95 lb-in).
73. Install and adjust the manual lever position switch. Refer to [Section 07-14](#).
74. Install the remaining wiring brackets to the transaxle housing.
75. Install a new O-ring onto the dipstick/oil filler tube.
76. Install the oil filler tube into the transaxle housing. Tighten the oil filler tube bolt to 7-11 Nm (62-95 lb-in).
77. Install the oil pump shaft into the transaxle.
78. Install a new O-ring on the turbine shaft.
79. Use Converter Seal Replacer T88C-77000-BH to install a new torque converter hub seal onto the transaxle.



80. Position the torque converter to the torque converter housing and rotate it to align the splines.

**NOTE: A pin is used for securing the throttle cam in a fixed position on new and rebuilt 4EAT units. This pin must be removed to allow proper transaxle operation. If the pin is not removed, the throttle lever will remain in a fixed position.**

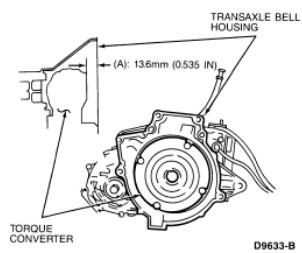
After removing the pin, apply sealant to the throttle cam pin bolt from the previous transaxle. Install the throttle cam pin bolt and tighten it to 8-11 Nm (69-95 lb-in).



D9996-A

**NOTE:** The torque converter should slide into the transaxle very easily. Do not force the torque converter into the transaxle.

81. To ensure that the torque converter has aligned properly, measure the distance between the torque converter and the edge of the transaxle bell housing. The distance should be at least 13.6mm (0.535 inch).



D9633-B