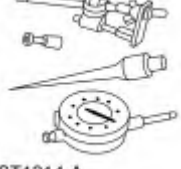


SECTION 307-01: Automatic Transaxle/Transmission — 6R80
DISASSEMBLY AND ASSEMBLY OF SUBASSEMBLIES

2014 F-150 Workshop Manual
 Procedure revision date: 10/25/2013

Intermediate Clutch Assembly

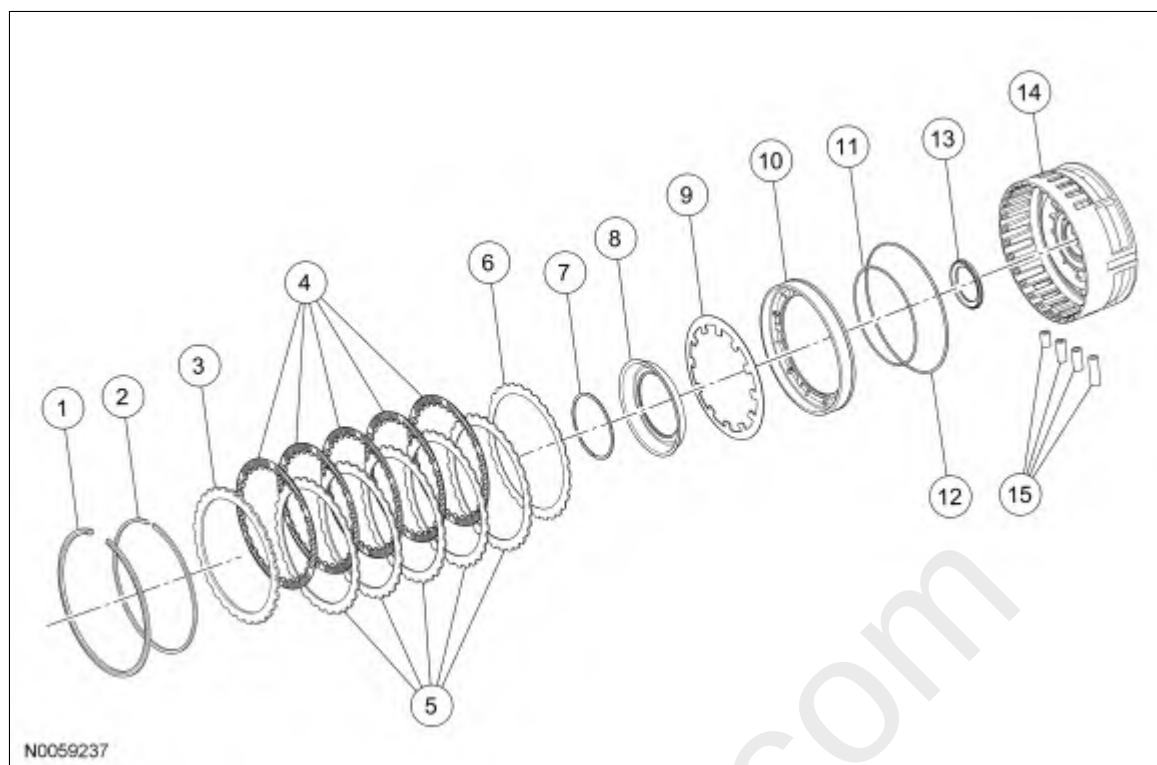
Special Tool(s)

 ST2881-A	Compressor, Clutch Spring 307-525
 ST1214-A	Dial Indicator Gauge with Holding Fixture 100-002 (TOOL-4201-C) or equivalent
 ST2892-A	End Play Gauge, Clutch 307-555

Material

Item	Specification
Motorcraft® MERCON® LV Automatic Transmission Fluid XT-10-QLVC (US); CXT-10-LV12 (Canada)	MERCON® LV

Intermediate Clutch Assembly



Item	Part Number	Description
1	7D483	Center support retaining ring
2	7D483	Intermediate clutch pack retaining ring
3	7B066	Intermediate clutch pressure plate
4	7B164	Intermediate clutch internal splined friction plates (quantity model dependent)
5	7B442	Intermediate clutch external splined steel plates (quantity model dependent)
6	7E085	Intermediate clutch cushion spring
7	7A577	Intermediate clutch snap ring
8	7B043	Intermediate clutch return spring retaining ring
9	7A480	Intermediate clutch piston return spring
10	7E005	Intermediate clutch piston (model dependant)
11	7F225	Intermediate clutch piston inner seal
12	7F224	Intermediate clutch piston outer seal
13	7F373	Bearing (T6)
14	7A130	Intermediate/low/reverse clutch center support
15	7G199	Center support seals (2 — 7G199, 1 — 7G087, 1 — 7G484)

Disassembly

NOTICE: The intermediate clutch plate quantity is model dependent on engine size. Check the clutch plate quantity charts in specifications for the correct clutch plate quantity. Failure to install the

correct clutch plate quantity will result in transmission failure.

NOTICE: The intermediate clutch piston is model dependent on engine size due to the different quantity of intermediate clutch plates. If installing a new intermediate clutch piston, check to make sure the height of the new piston is the same as the original piston. Failure to install the correct piston will result in transmission failure.

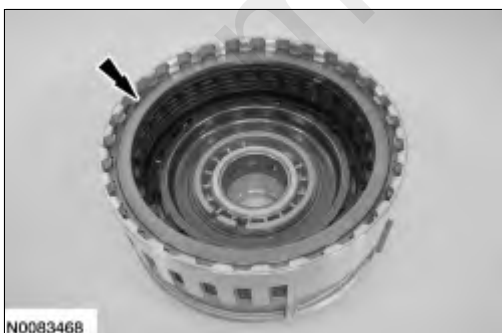
1. Remove the T6 thrust bearing.



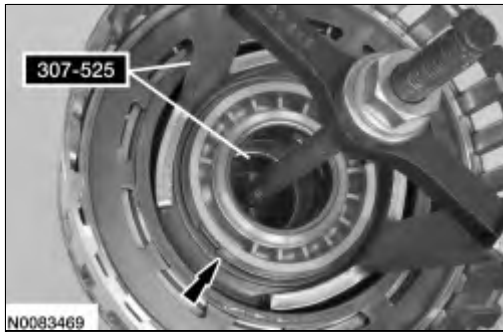
2. Remove the intermediate clutch plate snap ring.



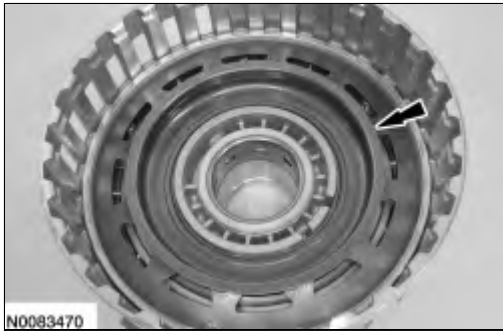
3. Remove the intermediate clutch plates.



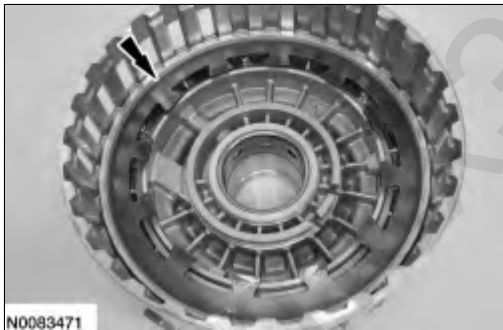
4. Using the Clutch Spring Compressor, remove and discard the intermediate clutch return spring retainer.



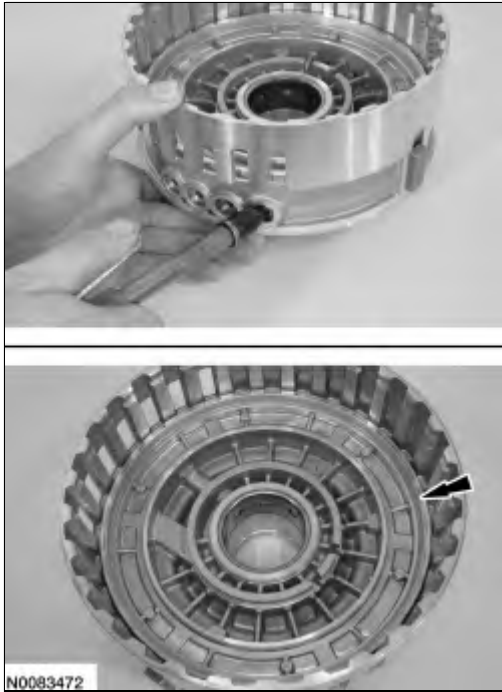
5. Remove the intermediate clutch return spring top plate.



6. Remove the intermediate clutch return spring.



7. Applying a slight amount of air to the port, remove the intermediate clutch piston.

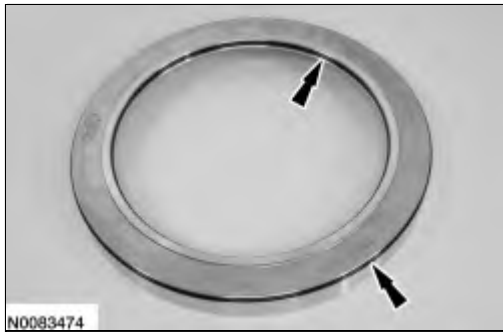


8. Remove and discard the inner and outer intermediate clutch piston O-ring seals.

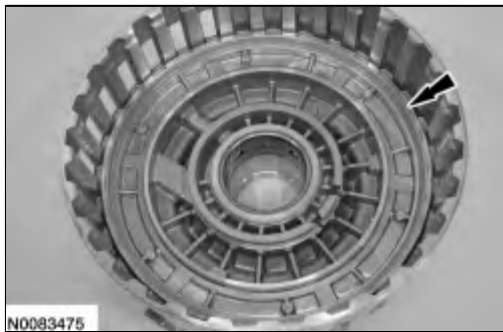


Assembly

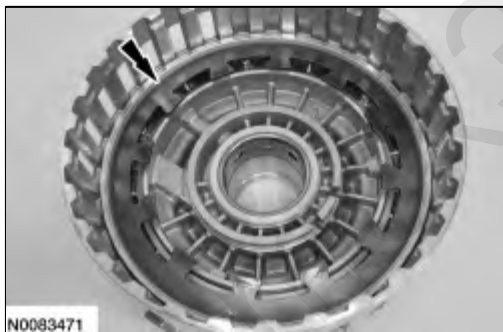
1. Install new inner and outer intermediate clutch piston O-ring seals.



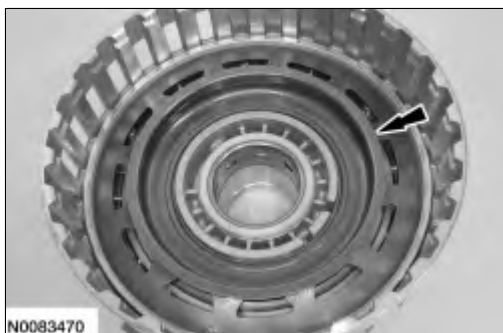
2. Lightly coat the O-ring seals in clean automatic transmission fluid and install the intermediate clutch piston.



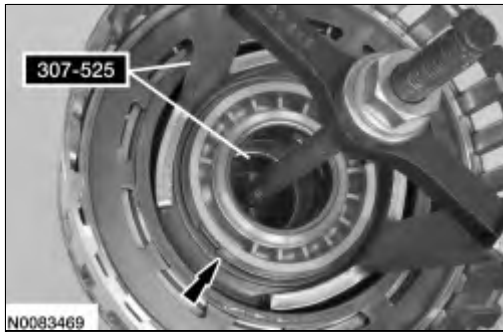
3. Install the intermediate clutch return spring.



4. Install the intermediate clutch return spring top plate.



5. Using the Clutch Spring Compressor, install a new intermediate clutch return spring retainer.

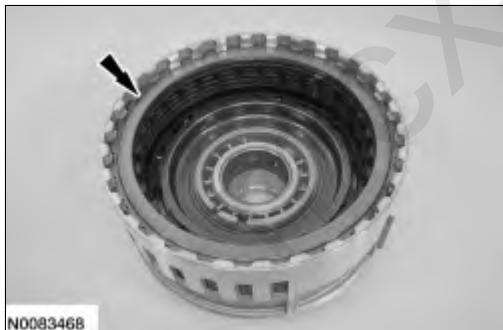


6. **NOTE:** Friction and steel plate quantity will vary based on engine displacement. For additional information, refer to the Clutch Plate Quantity Chart in the Specifications portion of this section.

Soak the new intermediate clutch plates in clean automatic transmission fluid.



7. Install the new intermediate clutch plates, starting with the wave spring then a steel plate and alternating between friction and steel plates, and ending with the pressure plate.

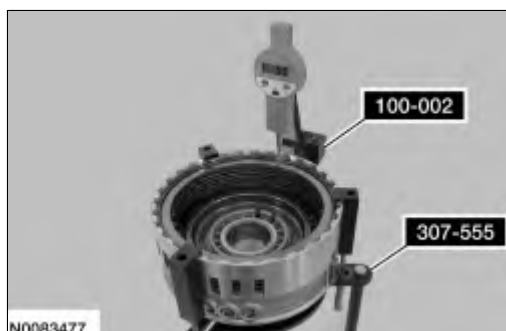


8. Install the intermediate clutch plate snap ring.



9. **NOTE:** All intermediate clutch plates, friction and steel are of a wave-type design.

Install the intermediate clutch assembly into the Clutch End Play Gauge and install the Dial Indicator Gauge with Holding Fixture and position the plunger so it fits into the opening of the snap ring.



10. With the Dial Indicator Gauge set at zero, lift up on the steel pressure plate so it is against the select fit snap ring. Record this reading as reading A.



11. Rotate the intermediate clutch assembly 180 degrees from the opening of the snap ring, take a second reading and record this reading as reading B.

Description	Reading
Reading A	
Reading B	
Add reading A to reading B for a total end clearance	
Divide the total reading by 2 for an average end clearance	

12. **NOTE:** If the final measurement is not within specification, install a new snap ring until the correct specification is achieved.
- 0.7-1.1 mm (0.027-0.043 in).

If the free pack end clearance between the bottom of the snap ring and the top of the pressure plate is high, remeasure using a thicker select fit snap ring. If the free pack end clearance between the bottom of the snap ring and the top of the pressure plate is low, remeasure using a thinner select fit snap ring.

13. Install the T6 thrust bearing.



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