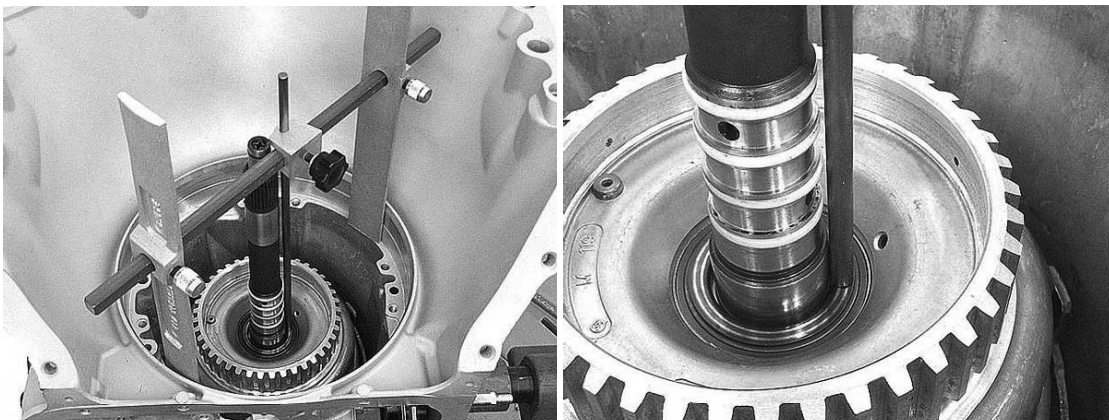


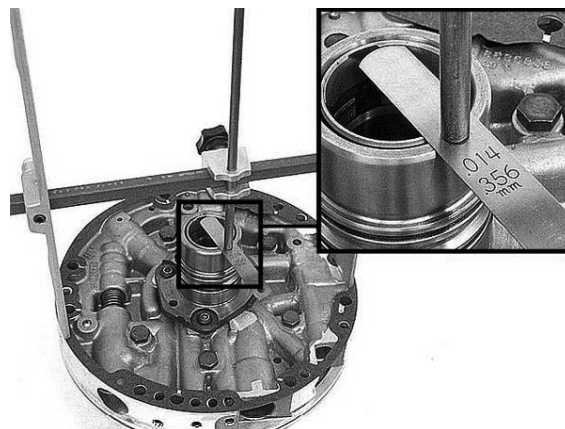
IMPORTANT- The following step concerns main unit endplay, which is arguably the most important adjustment to be made in a 4L60E. If this was checked and adjusted during disassembly, and no parts were changed that might change endplay, skip ahead to **Step #25**. Otherwise, proceed to the next step.

Step 24: Main unit end play must be checked and adjusted before final input drum installation. Here's one quick and easy method:

- Remove the turbine shaft seal ring sizer, then lower the input drum into the case *without the reverse input drum*, engaging the sun gear splines with the forward sprag, and the 3-4 clutches with the front ring gear. When the drum is all the way down, you'll get a nice solid 'clunk' when you move the drum up and down bit. Make sure that the selective endplay washer and thrust bearing are in place on top of the input drum.
- Place an 'H' gauge endplay measuring tool on the pump mounting surface of the case. Set the gauge pin on top of the input drum thrust bearing race and tighten the pin locking screw.



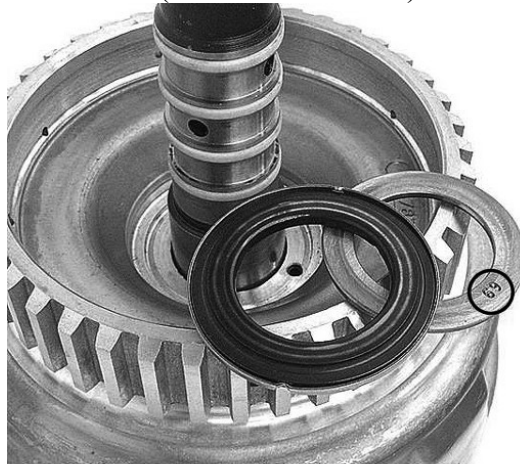
- Place a new pump gasket on the pump, and place the inverted 'H' gauge on the gasket. Use a feeler gauge to measure the clearance between the gauge pin and the thrust journal on the end of the stator support. This clearance, minus two or three thousandths, is your endplay distance.



The factory specification for this clearance is between 0.005" and 0.036". Since you need to allow for gasket crush, keep the minimum clearance above 0.010". To maximize unit life, keep the maximum measured clearance below 0.025".

Endplay is adjusted by changing the selective washer under the thrust bearing on top of the input drum. To reduce end play a certain amount, increase the washer thickness by that amount. Use a thinner washer to increase endplay. The available selective washer sizes are:

- 0.074" - 0.078" (1.87mm - 1.97mm) Identifier mark #67
- 0.080" - 0.084" (2.04mm - 2.14mm) Identifier mark #68
- 0.087" - 0.091" (2.21mm - 2.31mm) Identifier mark #69
- 0.094" - 0.098" (2.38mm - 2.48mm) Identifier mark #70
- 0.100" - 0.104" (2.55mm - 2.65mm) Identifier mark #71
- 0.107" - 0.111" (2.72mm - 2.82mm) Identifier mark #72
- 0.113" - 0.118" (2.89mm - 2.99mm) Identifier mark #73
- 0.120" - 0.124" (3.06mm - 3.16mm) Identifier mark #74



Once you know the correct selective washer size to use, install the correct selective washer under the thrust bearing on top of the input drum.

Step 25: Place the reverse input drum onto the input drum, rotating the reverse input drum to engage the reverse input clutches with the input drum. Be sure that the reverse drum is all the way down against the input drum thrust bearing. When all the reverse clutches are engaged, the reverse drum will rotate easily on the input drum while being pressed down upon.

