



# Technical Service Information

## **FORD 6R140W - 6R80 CENTER GEAR CASE ASSEMBLE**

**COMPLAINT:** There is much confusion when assembling the 6R140W and 6R80 center gear case areas of these transmissions

**CAUSE:** Multiple bearings and washers within the assembly.

**CORRECTION:** In figures 1 through 14 the correct assembly of the 6R140W is shown. It is recommended to use the second design intermediate clutch housing seen in figure 3. The housing is shorter than the previous design. The anti-fretting ring shown in figure 2 has to be used with the second design level intermediate clutch housing. Figure 15 shows all the selective shims that are available to set the total transmission end play.

Clearance will be determined by the rear selective shim thickness as shown in the chart. Shim identification and part numbers are also shown.

Figures 16 through 18 show the correct assembly of the 6R80 center gear case. Ford does not make selective shim specifications available to aftermarket sources.



Figure 1



Figure 5



Figure 2



Figure 6



Figure 3



Figure 7



Figure 4



Figure 8





Figure 9



Figure 12



Figure 10



Figure 13



Figure 11



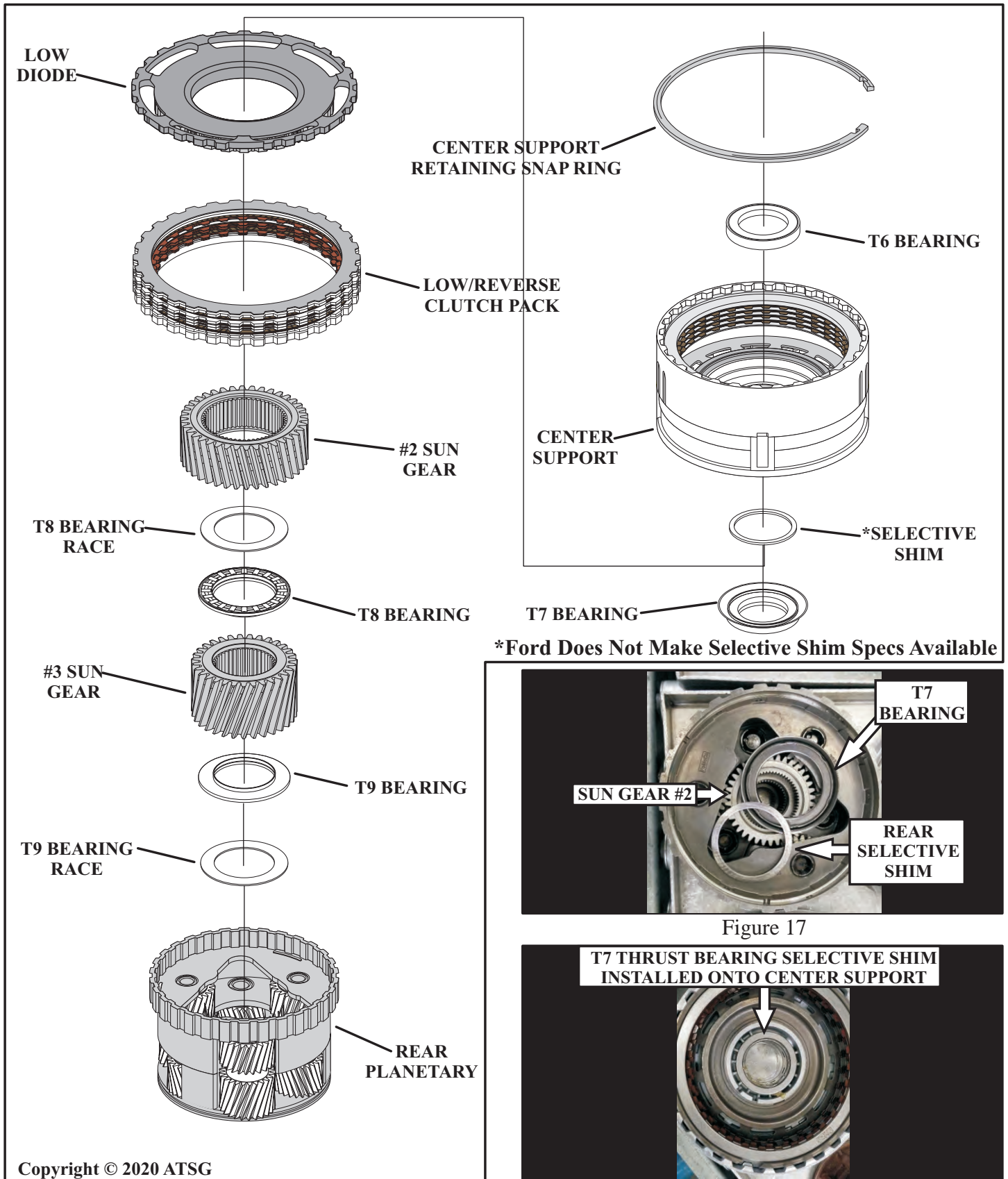
Figure 14

#### 6R140W SELECTIVE SHIM SPECIFICATIONS

*CLEARANCE	SELECTIVE SHIM PART #	DIMENSION/COLOR
.148" - .156" (3.75mm - 3.95mm)	BC3Z-7F405-E	.112" - .116" (2.85mm - 2.95mm)/Black
.156" - .163" (3.95mm - 4.15mm)	BC3Z-7F405-A	.120" - .124" (3.05mm - 3.15mm)/Yellow
.164" - .171" (4.16mm - 4.35mm)	BC3Z-7F405-B	.128" - .132" (3.25mm - 3.35mm)/White
.172" - .179" (4.36mm - 4.55mm)	BC3Z-7F405-C	.136" - .140" (3.45mm - 3.55mm)/Red
.180" - .187" (4.56mm - 4.75mm)	BC3Z-7F405-D	.143" - .148" (3.65mm - 3.75mm)/Blue

\*The target clearance with the correct rear selective shim installed is .031" - .043" (0.8mm - 1.1mm)

Figure 15



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Figure 16

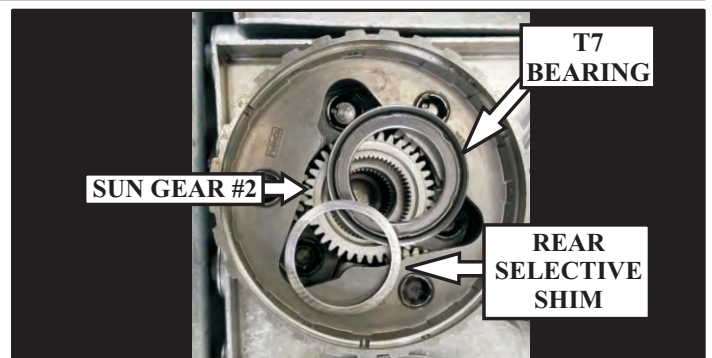


Figure 17



Figure 18