

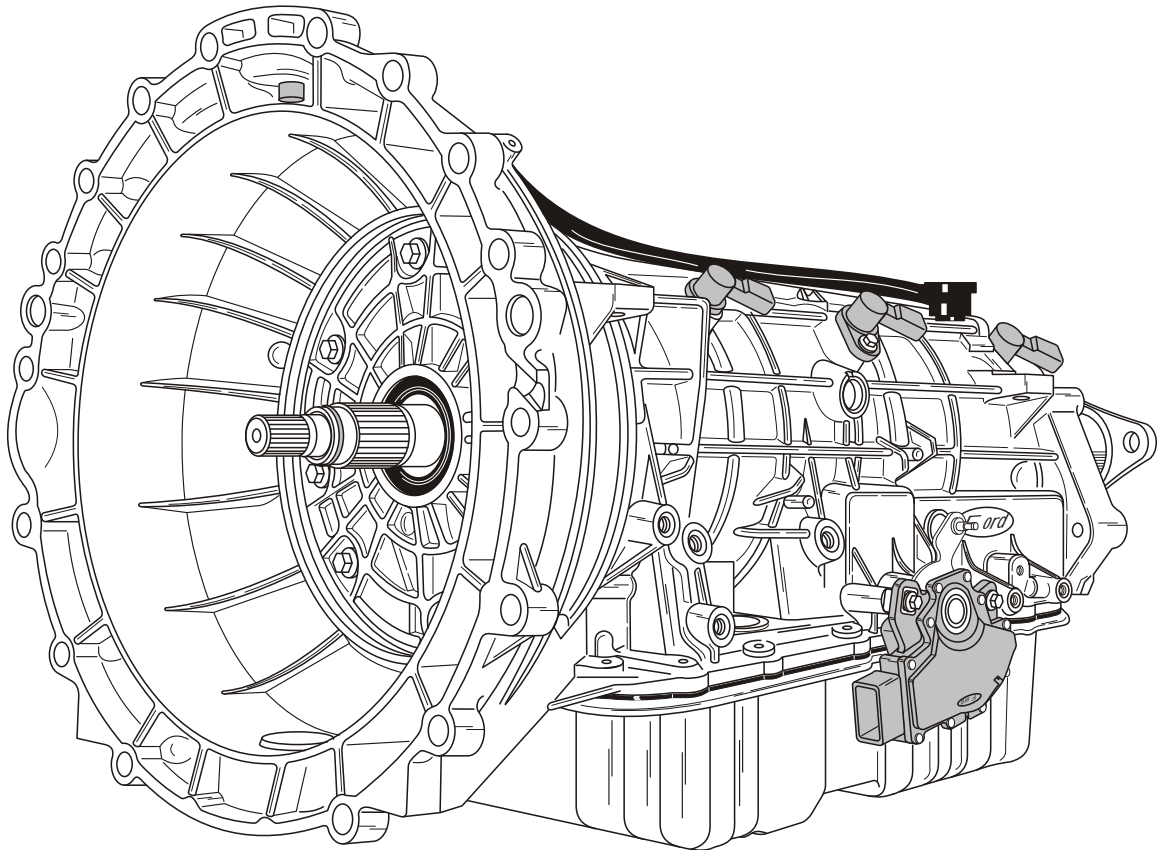


Technical Service Information

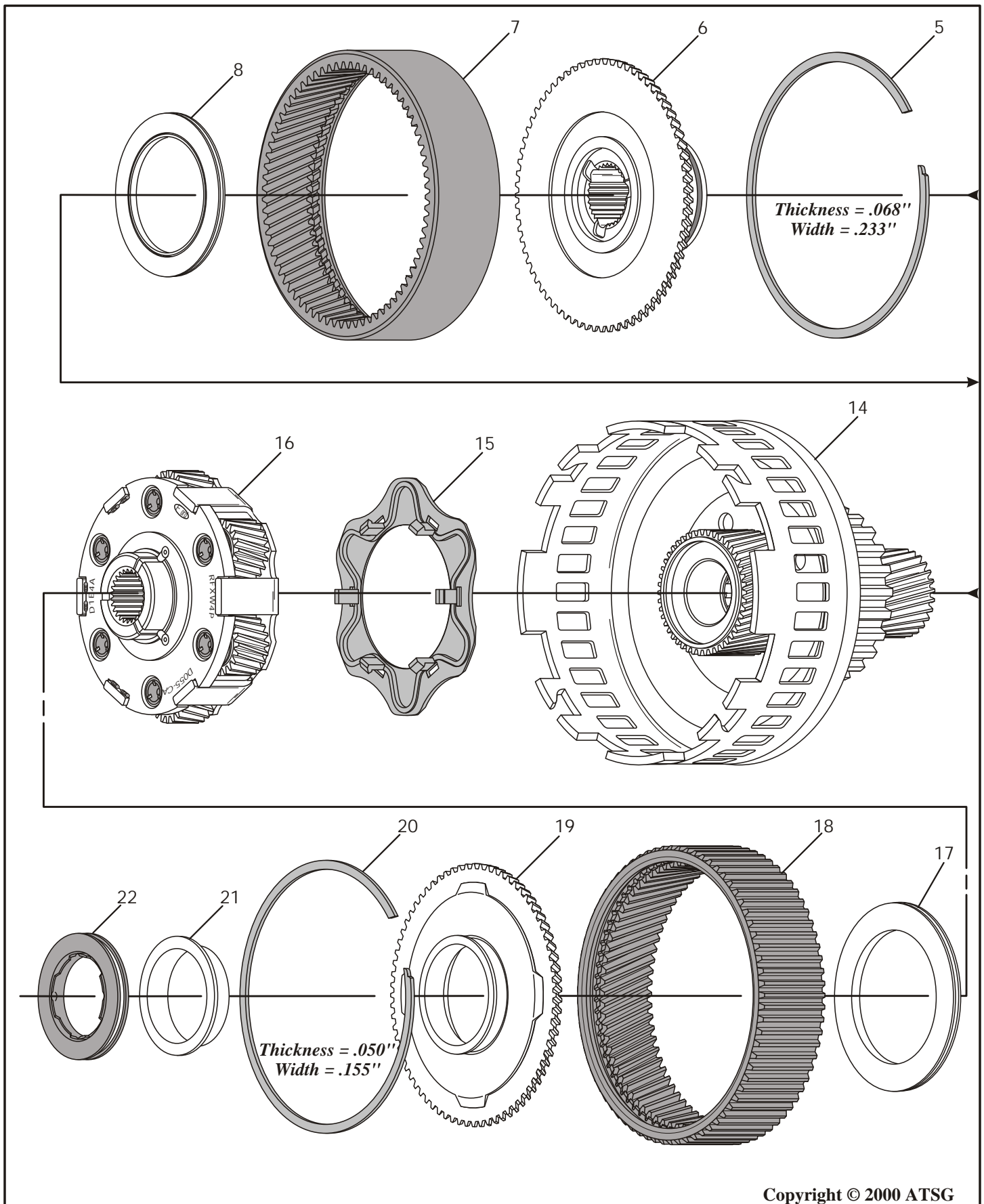
FORD 5R55N LOW SPRAG ASSEMBLY

There are some different procedures that need to be addressed on the assembly of the Low Sprag on the new 5R55N transmission from Ford Motor Company. Some of these procedures are enough different that some mis-assemblies could easily occur if the technician did not refer to the manual. ATSG will have an assembly/disassembly manual available very soon.

1. The reverse drum to sprag inner race caged needle bearing must be installed into the reverse drum first, as shown in Figure 3. The Low Sprag Assembly is very difficult to remove if this bearing is forgotten.
2. The Low Sprag Assembly **must** be installed into the reverse drum with the locking tabs facing down as shown in Figure 3. It is very easy to install in the other direction, but reverse drum will freewheel in the wrong direction.
3. We have also provided you with illustrations of the gear train in Figures 1 and 2, to assist you in the assembly process, in case you encounter one of these units before you have a manual. ATSG will have a manual available very soon.



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Figure 1

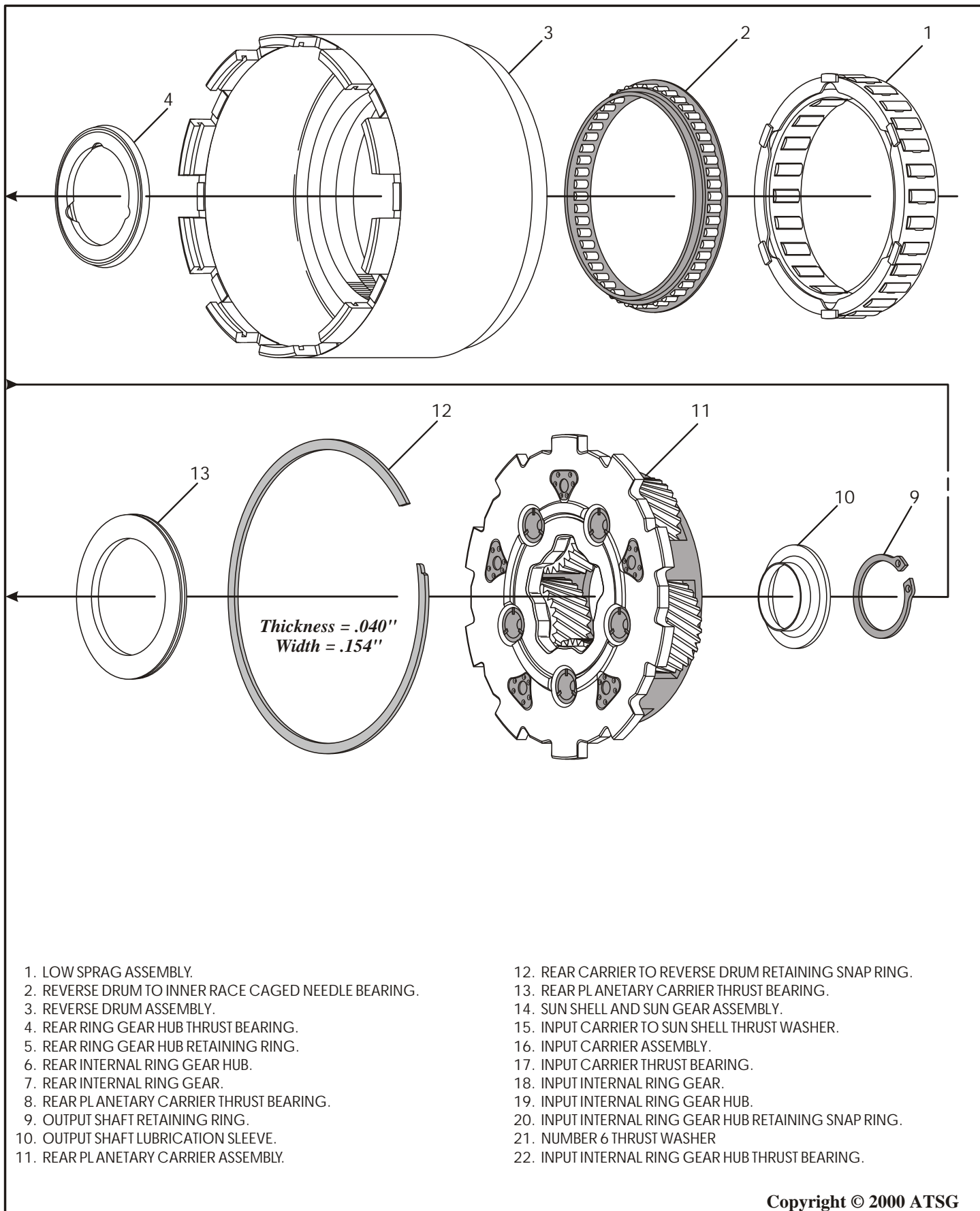
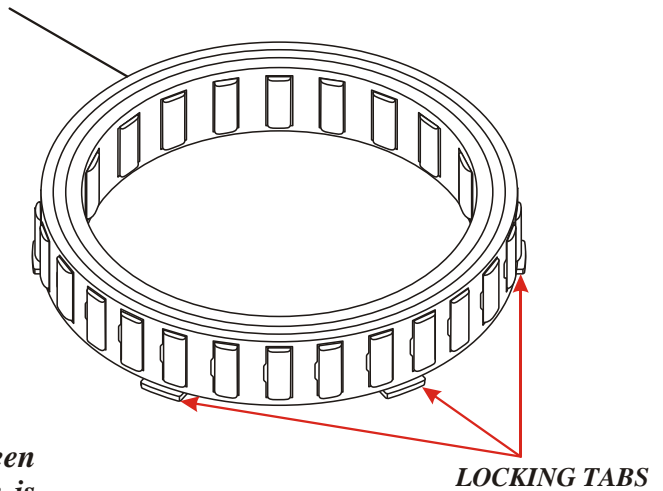
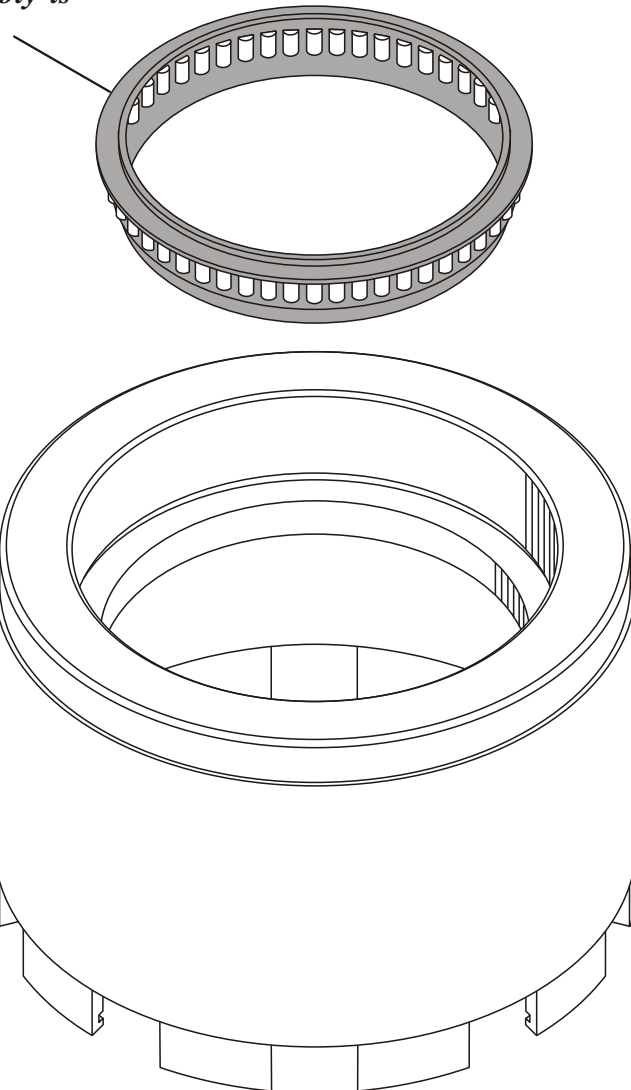


Figure 2

Second, ensure that sprag assembly is installed with the "Tabs" facing down as shown here. It is very easy to install in opposite direction, but you won't like it.



First, ensure that this caged needle bearing has been installed in direction shown, before sprag assembly is installed, as sprag assembly is difficult to remove.



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Figure 3