



6R80 / ZF6HP26 Hi-Performance G3® Friction/Steel Module with A, B, C, D & E Clutch Powerpacks® 2002-ON

ALTO PART # 183750PWR

- (27) 183700A160 (.063" / 1.60mm) A/B/C/D Clutch G3® Frictions
- (9) 183702B160 (.063" / 1.60mm) E Clutch G3® Frictions
- (16) 183701-173 (.068" / 1.73mm) A/B/C/D Clutch Steel Plates
- (6) 183701-208 (.082" / 2.08mm) A/B/C/D Clutch Steel Plates
- (6) 183701-300 (.118" / 3.00mm) A/B/C/D Clutch Bottom Steel Plates
- (8) 183703-160 (.063" / 1.60mm) E Clutch Steel Plates
- (2) 183703-300 (.118" / 3.00mm) E Clutch Bottom Steel Plate
- (4) 183250A (.092" / 2.34mm) A/B/C Clutch Snap Rings

IMPORTANT INFORMATION:

The 183750PWR is designed to be a drop in, no machining required Hi-Performance kit for the 6R80 and ZF6HP26 applications. Once installed, you may experience firmer shifts compared to a transmission equipped with stock OEM clutch plates.

Prior to installation, blow off any dust or friction fragments, with shop air, pre-soak the friction plates for at least 20 minutes in the manufacturer's recommended ATF or the ATF that the clutch plates will be used in.

INSTALLATION INSTRUCTIONS:

A (1-2-3-4, Forward) CLUTCH ZF6HP26 : Stack up is the same method as OE. Install the OE factory wave plate, you will be installing 5 of the .063"/1.60mm G3 friction plates, 2 of the .068"/1.73mm steel plates, 2 of the .082"/2.08mm steel plates, 2 of the .118"/3.00mm steel plates. Start with a .118" steel plate then alternate friction & steel plates, continue until the last plate installed is a .118"/300mm steel plate. (5 frictions & 6 steels). Install the OE factory snap ring. Using air (40 PSI) apply the A clutch several times to seat all of the clutch pack elements. With a feeler gauge, measure between the bottom of the snap ring and the top of the pressure plate. Clearance should be .035" to .055" (.889 to 1.40mm). Use 183250A snap-ring if required to achieve correct clutch pack clearance.

A (1-2-3-4, Forward) CLUTCH 6R80: Stack up is the same method as OE. Install the OE factory wave plate, you will be installing 6 of the .063"/1.60mm G3 friction plates, 2 of the .068"/1.73mm steel plates, 2 of the .082"/2.08mm steel plates, 2 of the .118"/3.00mm steel plates. Start with a .118" steel plate then alternate friction & steel plates, continue until the last plate installed is a friction plate (6 frictions & 6 steels). Install the OE factory top pressure plate & one of the .092"/2.34mm snap rings. Using air (40 PSI) apply the A clutch several times to seat all of the clutch pack elements. With a feeler gauge, measure between the bottom of the snap ring and the top of the pressure plate. Clearance should be .035" to .055" (.889 to 1.40mm).

B (3-5-R, Direct) CLUTCH ZF6HP26: Stack up is the same method as OE with the exception of eliminating the OE factory wave plate. Install an .118"/300mm steel plate on the bottom & then an .063"/1.60mm G3 friction plate & continue until the last plate installed is a friction plate (5 frictions & 5 steels). This clutch pack will utilize (2) .068"/1.73mm steel plates and (2) .082"/2.08mm steel plates. One of the .082"/2.08mm steel plates should be installed in the center of the clutch pack to help dissipate heat. Then install the OE factory top pressure plate & OE snap ring. Using air (40 PSI) apply the B clutch several times to seat all of the clutch pack elements. With a feeler gauge, measure between the bottom of the snap ring and the top of the pressure plate. Clearance should be .040" to .065" (1.02 to 1.65mm). The .092"/2.34mm snap rings provided in this kit can be used to adjust clutch pack clearance.

B (3-5-R, Direct) CLUTCH 6R80: Stack up is the same method as OE with the exception of eliminating the OE factory wave plate. Install an .118"/300mm steel plate on the bottom & then an .063"/1.60mm G3 friction plate &

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continue until the last plate installed is a friction plate (2) .068"/1.73mm (2) .118"/300mm (2) .082"/2.08mm steel plates (6 frictions & 6 steels). Then install the OE factory top pressure plate & one of the .092"/2.34mm snap rings provided in this kit. Using air (40 PSI) apply the B clutch several times to seat all of the clutch pack elements. With a feeler gauge, measure between the bottom of the snap ring and the top of the pressure plate. Clearance should be .040" to .065" (1.02 to 1.65mm).

C (2-6, Intermediate) CLUTCH ZF6HP26: Stack up is the same method as OE with the exception of eliminating the OE factory wave plate. Install a .118"/3.00mm steel plate on the bottom & then an .063"/1.60mm G3 friction plate & continue until the last plate installed is a friction plate (6 frictions & 6 steels). This clutch pack will utilize (3) .068"/1.73mm steel plates and (2) .082"/2.08mm steel plate, and (1) .118"/300mm steel plate. Install the .082"/2.08mm steel plates in the center of the clutch pack to help dissipate heat. Then install the OE factory top pressure plate & OE snap ring. Using air (40 PSI) apply the C clutch several times to seat all of the clutch pack elements. With a feeler gauge, measure between the bottom of the snap ring and the top of the pressure plate. Clearance should be .045" to .075" (1.14 to 1.90mm).

C (2-6, Intermediate) CLUTCH 6R80: Stack up is the same method as OE with the exception of eliminating the OE factory wave plate. Install a .118"/300mm steel plate on the bottom & then an .063"/1.60mm G3 friction plate & continue until the last plate installed is a friction plate 8 frictions & 8 steels. Then install the OE factory top pressure plate & one of the .092"/2.34mm snap rings provided in this kit. Using air (40 PSI) apply the C clutch several times to seat all of the clutch pack elements. With a feeler gauge, measure between the bottom of the snap ring and the top of the pressure plate. Clearance should be .045" to .075" (1.14 to 1.90mm). The OE snap-ring can be used to adjust clutch pack clearance.

D (Low/Reverse) CLUTCH ZF6HP26: Stack up is the same method as OE. Install the OE factory pressure plate, an .063"/1.60mm G3 friction plate & then an .068"/1.73mm steel plate. Alternate friction & steel plates, finishing the stack up with an .068"/1.73mm steel plate (8 frictions & 8 steels). Then install the OE factory wave plate. The D clutch pack requires some specialty tools to measure the clutch pack clearance. If you measure the overall thickness of the clutch pack prior to installation without the pressure plate or the wave plate, it should measure 1.048"/26.62mm +/- .020"/.508mm. The factory clearance specification is .039" to .062" (1.00 to 1.60mm).

D (Low/Reverse) CLUTCH 6R80: Stack up is the same method as OE. Install the OE factory pressure plate, an .063"/1.60mm G3 friction plate & then an .068"/1.73mm steel plate. Alternate friction & steel plates, finishing the stack up with an .118"/3.00mm steel plate (6 frictions & 6 steels). Then install the OE factory wave plate. The D clutch pack requires some specialty tools to measure the clutch pack clearance. If you measure the overall thickness of the clutch pack prior to installation without the pressure plate or the wave plate, it should measure .670"/17.02mm +/- .020"/.508mm. The factory clearance specification is .039" to .062" (1.00 to 1.60mm).

E (4-5-6, Overdrive) CLUTCH ZF6HP26: Stack up is the same method as OE with the exception of eliminating the OE factory wave plate. Install a .118"/3.00mm steel plate on the bottom & then an .063"/1.60mm G3 friction plate & then an .063"/1.60mm steel plate. Alternate friction & steel plate until the last plate installed is a .118"/3.0mm steel plate (8 frictions & 9 steels). Then install the OE factory snap ring. Using air (40 PSI) apply the E clutch several times to seat all of the clutch pack elements. With a feeler gauge, measure between the bottom of the snap ring and the top of the pressure plate. Clearance should be .030" to .055" (.762 to 1.40mm).

E (4-5-6, Overdrive) CLUTCH 6R80: Stack up is the same method as OE with the exception of eliminating the OE factory wave plate. Install a .118"/3.00mm steel plate on the bottom & then an .063"/1.60mm G3 friction plate & then an .063"/1.60mm steel plate. Alternate friction & steel plate until the last plate installed is a .063"/1.60mm friction plate. (8) .063"/1.60mm (1) .118"/3.00mm steel plates (9 frictions & 9 steels). Then install the OE factory pressure plate and snap ring. Using air (40 PSI) apply the E clutch several times to seat all of the clutch pack elements. With a feeler gauge, measure between the bottom of the snap ring and the top of the pressure plate. Clearance should be .030" to .055" (.762 to 1.40mm). There are (5) selective thickness snap rings available from Ford for the E clutch.

NOTE: In order to help adjust clutch pack clearance, there are more steel plates included in this kit than are required.