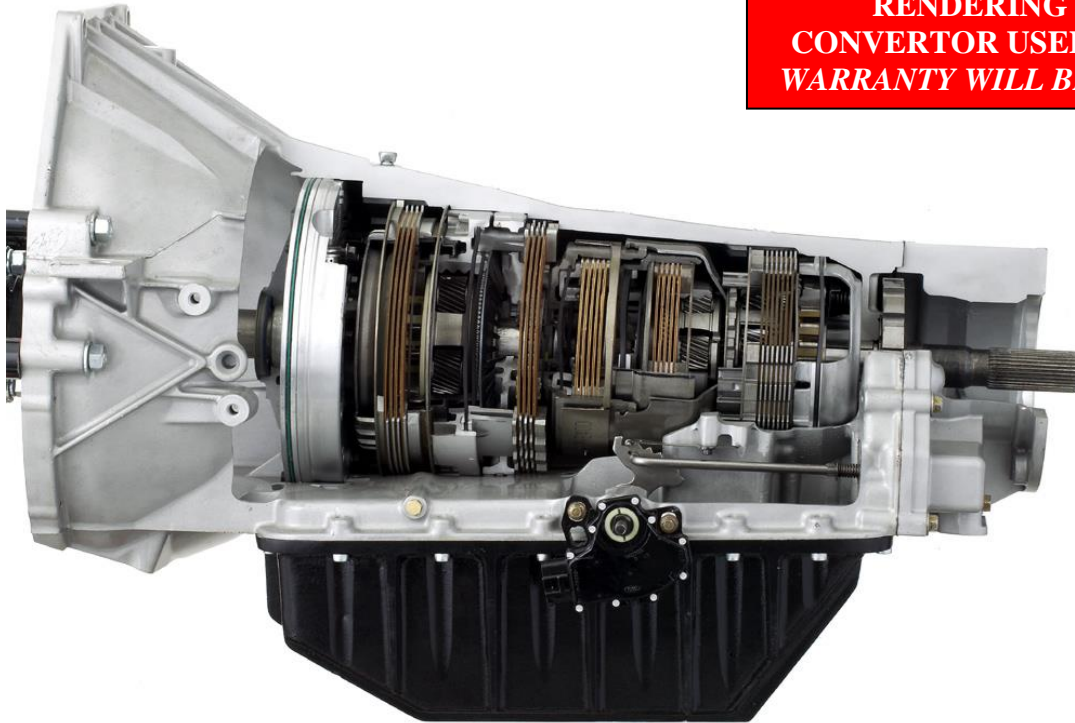




DO NOT USE WATER-BASED TRANSMISSION FLUSHING FLUID – THE LINING IN THE CONVERTOR CLUTCHES WILL DISINTIGRATE, RENDERING THE CONVERTOR USELESS AND WARRANTY WILL BE VOIDED.



BD PERFORMANCE TRANSMISSION

Ford Installation Instructions

2WD Transmissions		
1064402	1990-1994	E4OD
1064422	1995-1997	E4OD
1064442	1999-2003	4R100
1064442PTO	1999-2003 (w/ Power Take Off)	4R100
1064342	1999-2003 V10 Truck & M/H	4R100
1064462	2003-04	5R110
1064482	2005-06	5R110

4WD Transmissions		
1064404	1990-1994	E4OD
1064424	1995-1997	E4OD
1064444	1999-2003	4R100
1064444PTO	1999-2003 (w/ Power Take Off)	4R100
1064344	1999-2003 V10 Truck & M/H	4R100
1064464	2003-04	5R110
1064464-PTO	2003-04 w/PTO	5R110
1064484	2005-06	5R110

Please read the instructions and disclaimer before beginning installation.

BD Engine Brake Inc.

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ATTENTION: FOR 5R110 WARRANTY'S TO BE VALID, AN ECM PROGRAMMER (i.e. BD XTUNER, SCT, SUPERCHIPS, EDGE EVOLUTION) MUST BE INSTALLED WITH A TRANSMISSION PERFORMANCE PROGRAM.

REMOVAL:

- 1) Disconnect the negative battery cable(s).
- 2) Place the transmission into the Neutral (N) position.
- 3) Raise the vehicle on a hoist.
- 4) Mark the drive shaft and pinion yokes for assembly alignment. On 4WD models, remove the skid plate.
- 5) Remove the transmission oil filter tube nut and filler tube.
- 6) Position a drain pan & disconnect the transmission fluid cooler tubes at the cooler bypass valve.
- 7) Remove the drive shaft. On 4WD models, remove the front drive shaft & transfer case assembly. On SuperDuty/Motorhome models, remove the transmission mounted parking brake assembly.
- 8) **NOTE:** If the vehicle is equipped with a PTO (Power Take-Off) unit, all or part of the PTO will need to be removed.
- 9) Disconnect the shift cable from the transmission and manual lever.
- 10) Disconnect the cable housing from the bracket.
- 11) Disconnect the digital transmission range (TR) sensor connector.
- 12) Remove the transmission heat shield.
- 13) Disconnect the solenoid body connector.
- 14) On 4WD models, remove the four-wheel drive switch connector from the transfer case.
- 15) If equipped, disconnect the turbine shaft speed (TSS) sensor & the output shaft speed (OSS) sensor.
- 16) Remove the inspection cover.

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- 17) Rotate the crankshaft with a pry bar from under the vehicle until the converter bolts are accessible.
- 18) Raise the transmission slightly with a service jack to relieve the load on the cross-member and supports.

CAUTION: Make sure any securing straps or the transmission jack adapter DO NOT TOUCH the cooler bypass valve (CBV). Do not use the CBV as a handle. Damage to the CBV may cause a leak and/or failure to the transmission assembly.

- 19) Remove the exhaust and cross-member.
- 20) Remove the transmission mounting bolts.
- 21) Carefully work the transmission and torque converter assembly rearward off the engine block dowels.
- 22) Lower the transmission and remove the assembly from under the vehicle.
- 23) Carefully slide the torque converter out of the transmission.

Upon installation ensure the plug is in the torque converter and preload the torque converter with 2 quarts, fluid type see below.

<i>Application</i>	<i>Oil Type</i>
Ford E40D	Mercon V or Dexron III with Mercon
Ford 4r100	Mercon V
Ford Torqshift 5r110	Mercon SP

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INSTALLATION:

- 1) Pre-clean all the cooler lines and cooler bypass valve.
- 2) If the transmission is being overhauled or exchanged due to failure, then the transmission oil to air cooler will need to be replaced. Also the system must be flushed to remove any debris. Any failure to do this will result in the warranty being void. **DO NOT USE "TRANSMISSION FLUSH IN A CAN"**, the system must be flushed with back flow compatible dedicated transmission flushing machine using only oil.

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- 3) Inspect the wiring harness & connectors for damage, corrosion, seal integrity, and terminal condition. Repair or replace as required.
- 4) Lubricate the converter drive hub and oil pump seal lip with petroleum jelly.
- 5) Lubricate the converter pilot hub with transmission fluid.
- 6) Align and carefully install the torque converter into the oil pump. Rotate the converter back and forth until it is fully seated in the pump gears. The converter will be fully seated when you hear two loud "clunks".
- 7) If the vehicle is a 4WD model, install the transfer case assembly.
- 8) If removed, install the output shaft drive sprocket speed sensor and bolt.
- 9) Position the transmission on a jack and secure it with chains.
- 10) Check the condition of the converter drive plate. Replace the plate if it is cracked, distorted or damaged.
- 11) Raise the transmission and align the converter with the drive plate, and the bell housing with the engine block.
- 12) Move the transmission forward. Raise, lower or tilt the transmission to align the bell housing with the engine block dowels.
- 13) Carefully work the transmission forward and over the engine block dowels until the converter hub is seated into the crankshaft.
- 14) Install the bolts attaching the bell housing to the engine.
- 15) Install the torque converter to drive plate bolts using Loctite. On 7.3L diesel models, tighten the bolts to 53-72Nm (39-53 ft. lbs.), then check torque converter rotation.
- 16) Install the exhaust and cross-member.

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- 17) Install the inspection cover.
- 18) Connect the solenoid pack electrical connector.
- 19) Connect the digital transmission (TR) sensor.
- 20) Install the transmission heat shield.
- 21) Reconnect the shift cable, cable housing and bracket.
- 22) If equipped, reconnect the transmission mounted parking brake assembly.
- 23) If equipped, install the four-wheel drive connector.
- 24) Align and connect the drive shaft(s).
- 25) Install the transmission fluid cooler tubes to the cooler bypass valve.
- 26) Install the transmission fluid filler tube and bolt.
- 27) Install transmission mainline pressure gauge.
- 28) Lower the vehicle.
- 29) Connect the battery ground cable(s).
- 30) Fill the transmission with vehicle manufacturers suggested fluid.
(See table below for suggested amounts).

NOTE: Fill capacities listed only as a guide. **Correct fluid level should always be determined by marks on dipstick.** Capacities listed are total system capacity including torque converter and BD pan.

Application	First Fill Quarts (Liters)	Secondary Fill Quarts (Liters) (Includes TC Preload)	Total capacity (Liters)
1989 - 2010	12 (11.4)	11.5 (10.8)	23.5 (22.2)

- 31) Test Drive vehicle, verify pressures and record.

Mainline Pressures			
	At Idle	Wide Open Throttle	In Reverse
E40D	100 psi	220-250 psi	200-350 psi
4R100	100 psi	220-250 psi	200-350 psi
5R100	70 psi	250-270 psi	320 psi

- 32) Remove gauge, recheck fluid top up if necessary.

Transmission / Converter failures require that the remote filter be returned for inspection before any claim is considered, as well you will be required to submit

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the cooler flow rate in GPM measured at the outlet of the Oil/Air transmission cooler.

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