

**Installation**

- 01 Heat the output bearing's inner race to max. 110 °C. Place protection ring **1X56 138 187 (1)** onto the output bearing to do this.

**NOTE**

The shafts must be assembled correctly ready for installation.

**DANGER**

Only touch heated protective tool when wearing protective gloves.

- 02 Remove protection ring **1X56 138 187** and carefully insert the shafts fully into the transmission housing.
- 03 Pull the shafts into the correct axial position from the output end using a bushing (against the bearing inner race or speedometer worm) and a hex bolt (M12x1.5). Tightening torque = 120 Nm.

**NOTE****Separate clutch housing version**

Check the installation is correct by measuring distance "B", see section 10.1. Remove the bushing and hex bolt.

- 04 Remove fixtures and auxiliary strip
- 05 Coat thread of articulated bolts with sealing compound. First screw in articulated bolts of 1st/2nd gear with spring washer.

**NOTE**

Articulated bolts for 1st/2nd gear (2) = approx 48.5 mm

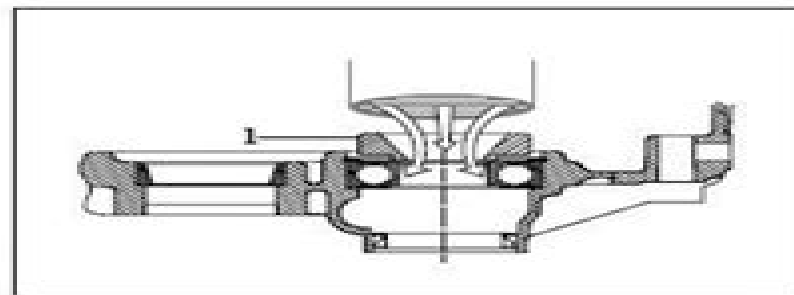
Articulated bolts for 3rd/4th gear (3) = approx 55.0 mm

Articulated bolts for 5th/6th gear (4) = approx 55.0 mm

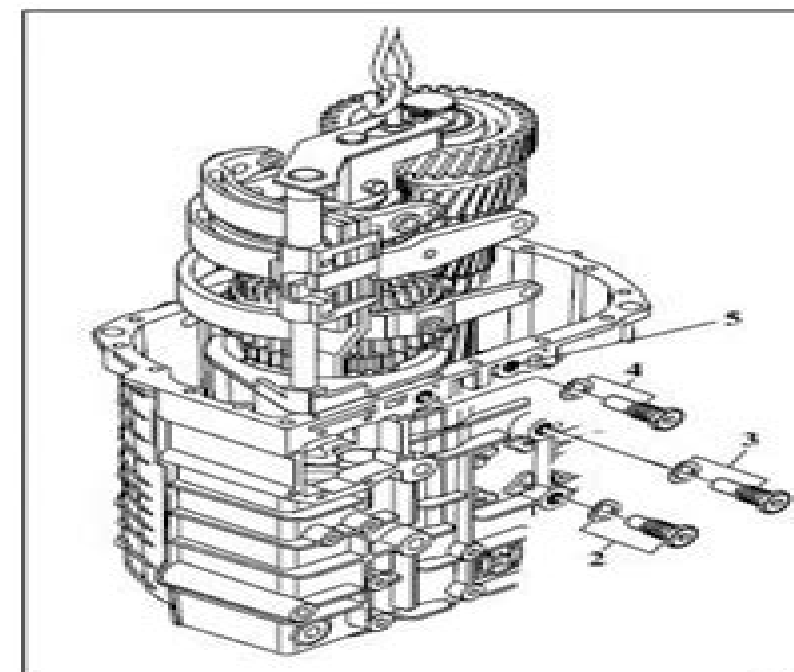
**NOTE**

Overdrive version (4),  
direct drive version (5).

- 06 Screw in and tighten the remaining articulated bolts and spring washers as previously described. Tightening torque = 160 Nm.



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# Transmission Mdk Repair Manual

**General Motors Corporation. Chevrolet  
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## **Transmission Mdka Repair Manual:**

**General Motors Automatic Transmission Overhaul** John Haynes, 2002-02-21 Covers rear wheel drive transmissions THM200 4R THM350 THM400 and THM700 R4 and front wheel drive transaxles THM125 125C THM3T40 THM440 T4 and THM4T60 *Direct and General Support Maintenance Manual*, 1971 Max Ellery's Transmission Repair Manual Holden's 1963-1988 Max Ellery, 1996-07-01 *Direct and General Support Maintenance Manual for Transmission Assembly, Automatic, Model TX 200-2A, Allison Division, GM, 2520-860-7342, Transmission Assembly, Automatic, Model TX 200-2B, Allison Division, GM, 2520-964-9207, Transmission Assembly, Automatic, Model TX 200-6, Allison Division, GM, 2520-045-3108*, 1969 **Shop Manual for Automatic Transmissions and Transaxles** Jack Erjavec, 2011 **The Haynes General Motors Automatic Transmission Overhaul Manual** Eric Godfrey, John Harold Haynes, 1996 GM Automatic Transmission Overhaul Manual Haynes In depth coverage of popular GM transmissions for the serious do it yourselfer The THM 200 4R 350 400 and 700R4 automatic transmissions are covered with complete overhaul photo sequences Also covered are theory of operation in vehicle repairs and performance modifications Sftbd 8 1 4x 10 3 4 approx 240 pgs 576 b w ill **Ford Automatic Transmission Overhaul** John Haynes, 2001-10-13 Covers rear wheel drive models C3 C4 C5 C6 and AOD and front wheel drive models ATX FLC and AXOD Included are the fundamentals diagnosis techniques and modifications **Heavy Truck Repair Manual**, 2020 **Service Manual**, 1988 **Chevrolet Powerglide Automatic Transmission** General Motors Corporation. Chevrolet Motor Division, 1952

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