

# A T T E N T I O N

YOUR WARRANTY DEPENDS ON YOUR ADHERENCE TO THESE GUIDELINES

## 4L80E GM Automatic Transmission

## INSTALLATION GUIDE

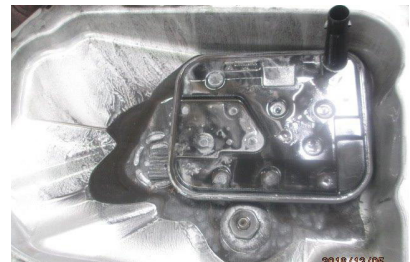
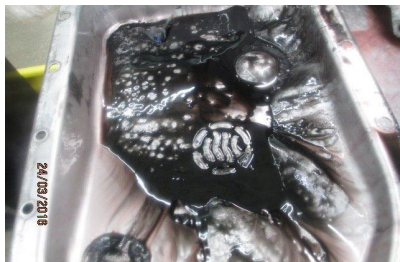
### PRE-INSTALLATION

Prior to installation of the replacement transmission, determine the cause(s) of failure of the previous unit.

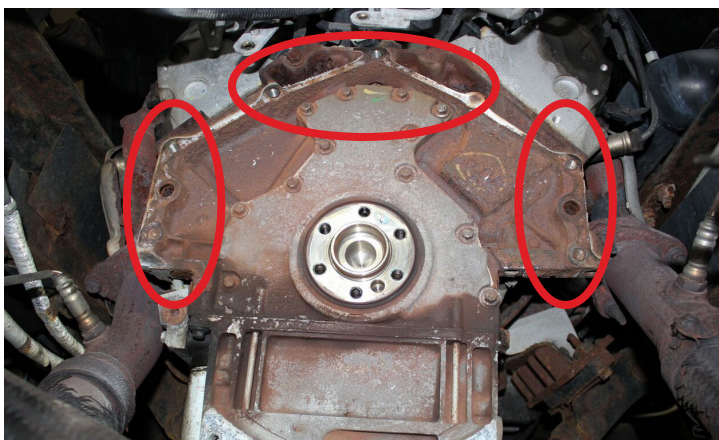
Also:

- Check transmission for glycol and/or water contamination.
- Scan vehicle computer, record any codes, and fix all causes of codes before installation of replacement transmission.

**A restricted and/or contaminated transmission cooling system is the number one cause of transmission failure after a replacement.**



- If the original transmission has a large amount of debris in the oil pan as in the photos above, the radiator and auxiliary cooler should be replaced.
- If the original transmission has a slight amount or no debris in the oil pan both the radiator and auxiliary cooler should be hot flushed and flow tested.
- Blowing the coolers out with air or using “flush in a can” will not properly clean these components.
- When properly cleaned the minimum fluid flow returning to the transmission should be 2 quarts in 30 seconds.
- **Failure to establish clean and proper fluid flow through the cooling system will void your warranty.**



**Clean all corrosion, dirt, grease, paint and oil from the engine block and transmission mounting surfaces. Contaminates on these surfaces can create resistance in the ground path resulting in damage to the transmission.**

## INSTALLATION CHECKLIST

- Inspect flex plate for cracks or any damage.
- Compare replacement transmission and torque converter to original before installation.
- Verify both dowel pins are present, clean and in good condition - these are critical for proper alignment.
- Verify torque converter is properly and completely installed onto the input shaft.
- Do not tighten bell housing bolts with force.
- Inspect transmission mounts, carrier bearing, driveshaft, yoke and u-joints. Excessive vibration due to defective mounts and other faulty driveline parts is the main cause of broken cases.

## WIRING HARNESS INSTALLATION

Pre-1994 units have been upgraded to the later style case connector. A late vehicle side connector and pigtail has been supplied to complete the upgrade. Follow the instructions included with the harness for installation.

## FLUID CHECK PROCEDURE

1. Verify vehicle is on level ground and transmission is in park.
2. Start the engine.
3. Using a scan tool verify TFT sensor reads between 180 and 200 degrees Fahrenheit.
4. Depress the brake pedal and move gear selector through each range, pausing for 3 seconds in each range.
5. Return gear selector to park.
6. Remove the transmission dipstick, wipe clean, reinsert and remove again.
7. Verify fluid level is within the cross hatched area and adjust fluid level as necessary.