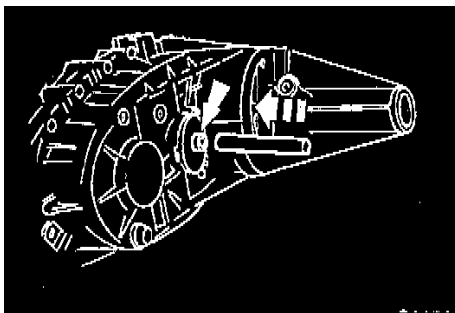
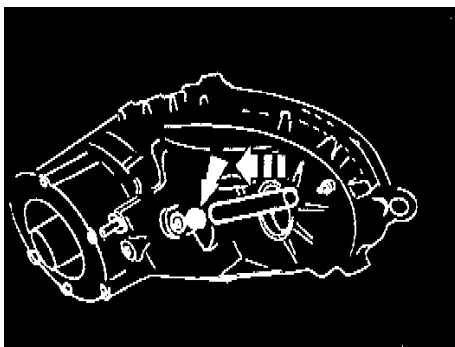


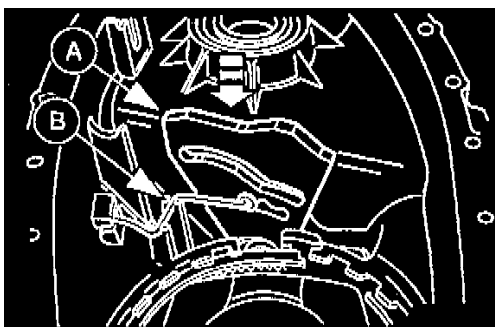
Transfer Case: Service and Repair Assembly



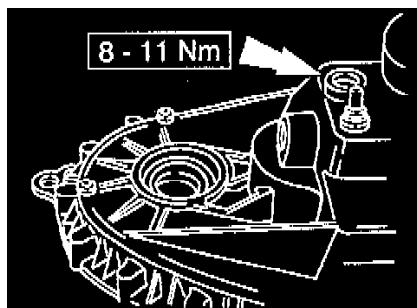
1. On electrical shift transfer case, install the electric shift motor seal.
 - Use Seal Replacer.



2. On manual shift transfer case, install the shift lever seal.
 - Use Seal Replacer.

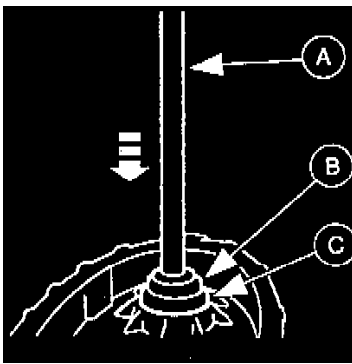


3. On manual shift transfer case, install the shift lever (from outside of case), (A) shift cam and (B) spring.

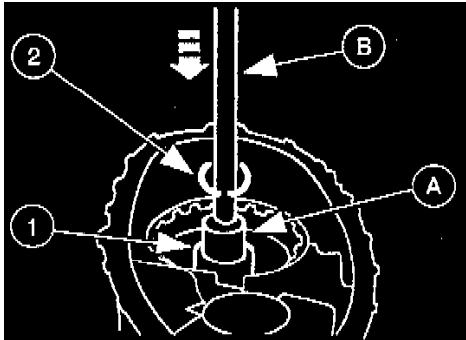


4. Tighten the shift lever set screw.

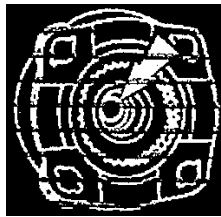
NOTE: On manual shift transfer case, access the shift lever set screw through the 4WD indicator switch hole.



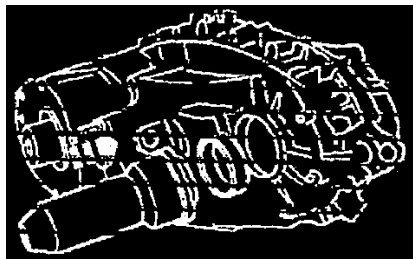
5. Install the (C) front output shaft bearing.
- Use (A) Driver Handle and (B) Bearing Replacer.



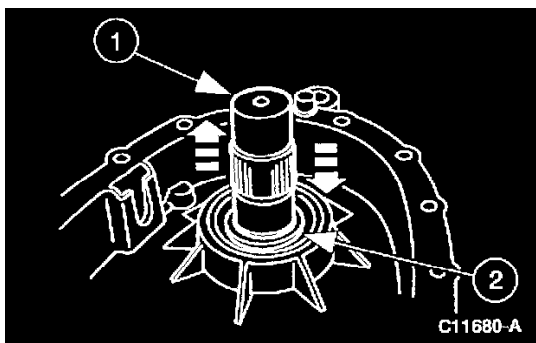
6. Install the front planet carrier bearing.
(1) Install the front planet carrier bearing. Use (A) Dust Shield Replacer and (B) Driver Handle.
(2) Install the front planet carrier bearing snap ring.



7. If removed, install the bushing and needle bearing into the front planet carrier.
- Use input shaft bearing replacer.



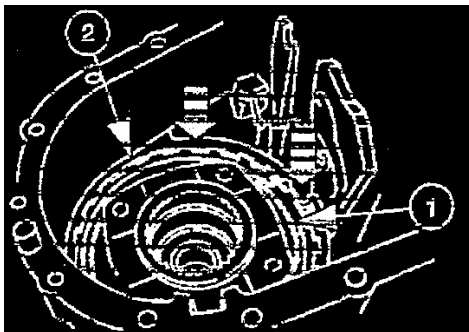
8. Install the front output shaft seal.
- Use seal replacer.



9. Install the front output shaft.

(1) Position the front output shaft.

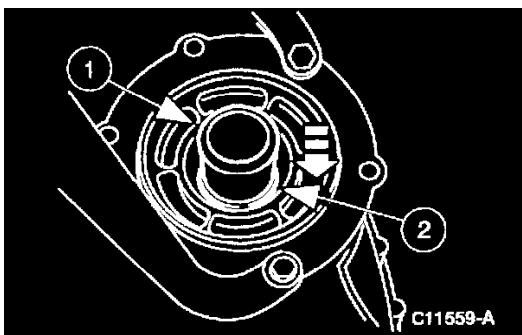
(2) Install the front output shaft snap ring.



10. Install the ring gear

(1) Position the ring gear.

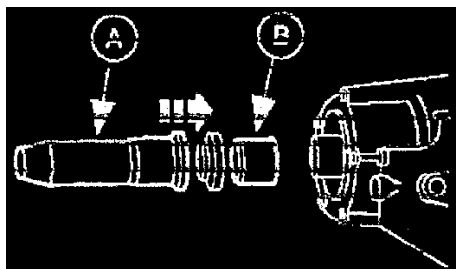
(2) Install the ring gear snap ring.



11. Install the front planet carrier.

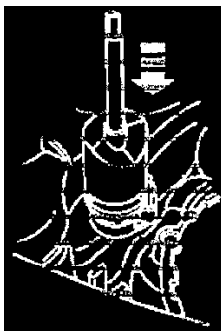
(1) Position the front planet carrier.

(2) Install the front planet carrier snap ring.

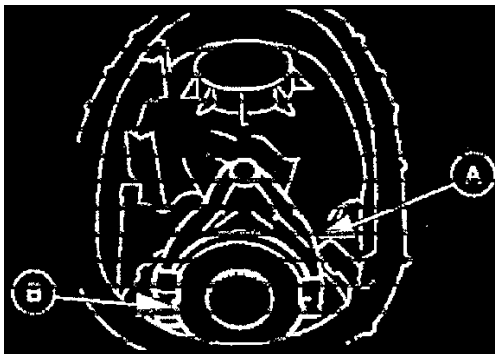


12. Install the input seal.

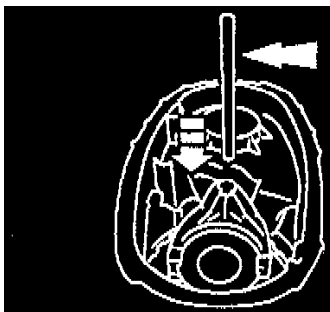
- Use (A) seal replacer and (B) seal protector.



13. On electrical shift transfer case, install the electric shift cam assembly.

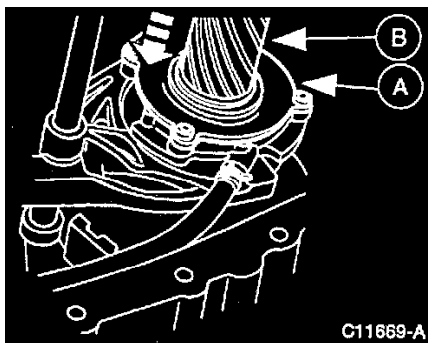


14. Install the (A) shift fork and (B) reduction hub.

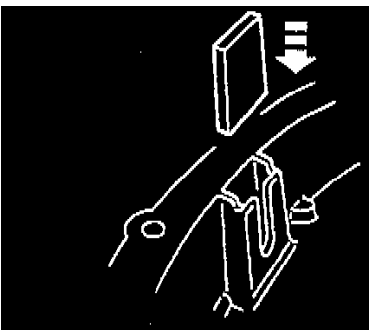


15. Install the shift fork shaft.

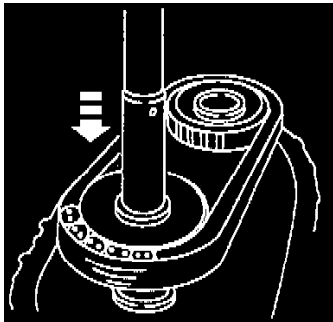
16. Install the oil pump onto the output shaft.



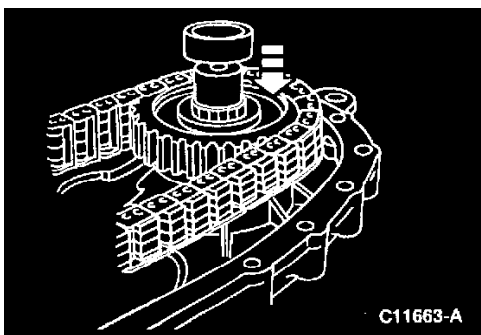
17. Install the (A) oil pump and (B) output shaft.



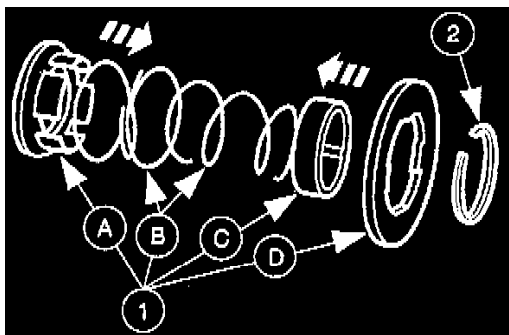
18. Install the magnet into its slot in the case.



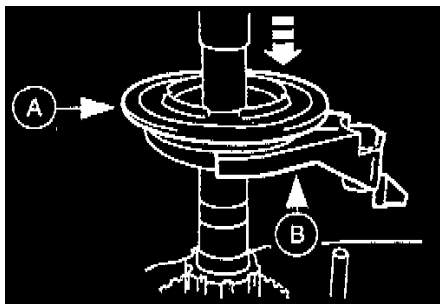
19. Install the drive chain and sprocket assembly.



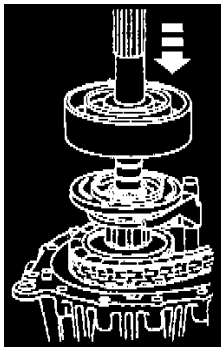
20. Install the collar.



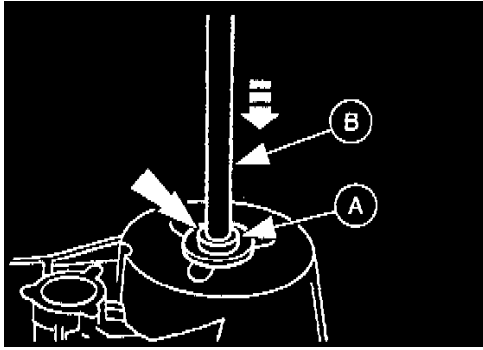
21. Assemble the lockup hub assembly.
(1) Position the (A) lockup collar, (B) two lockup springs, (C) lockup hub and (D) armature.
(2) Install the lockup hub snap ring.



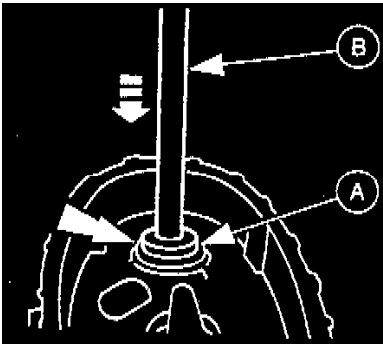
22. Install the (A) lockup hub and (B) shift fork.



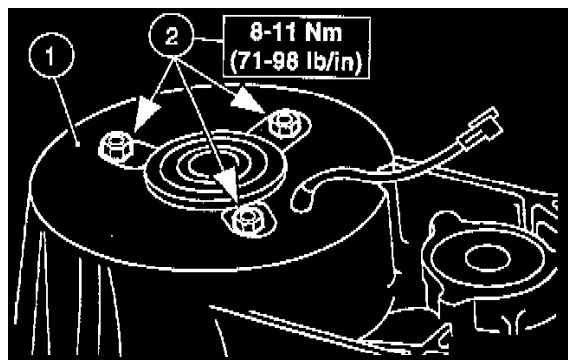
23. Install the coil housing.
24. Install the shift collar hub.
- Install the shift collar hub snap ring onto the rear output shaft.



25. Install the rear output shaft bearing.
- Use (A) Center Bearing Replacer and (B) Driver Handle.

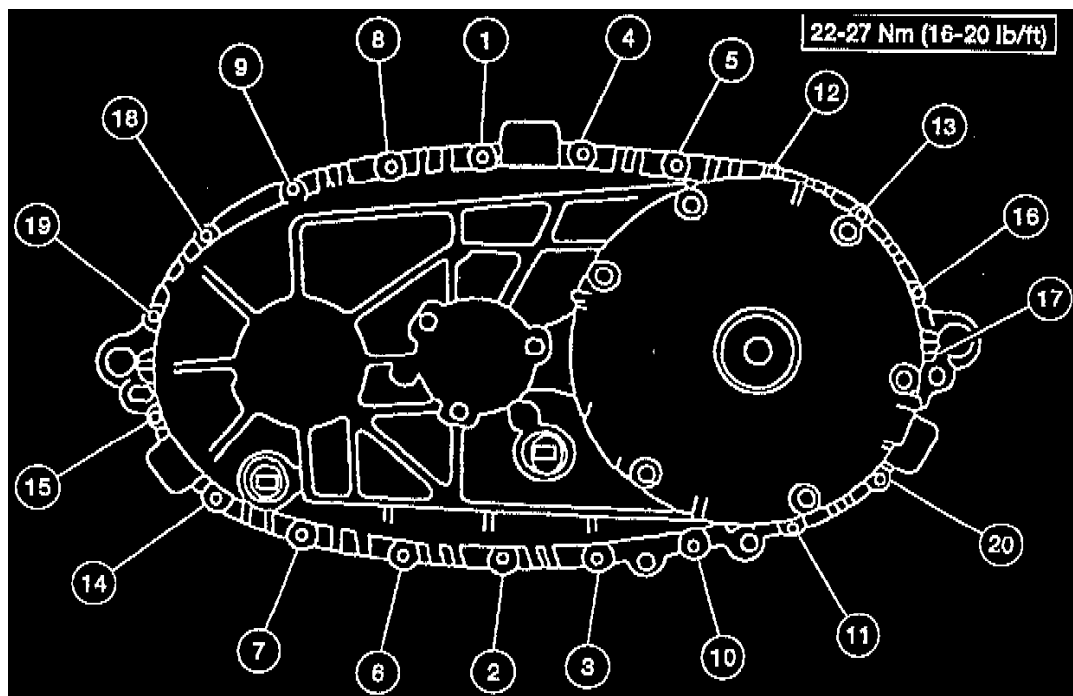


26. Install the front output shaft bearing.
- Use (A) Center Bearing Replacer and (B) Driver Handle.

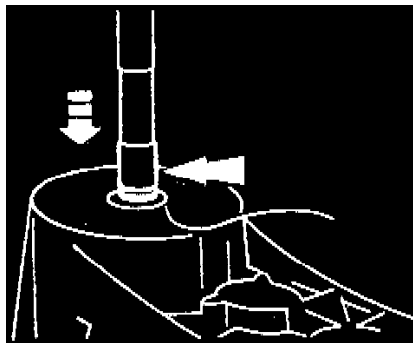


27. Install the coil.
- (1) Position the coil.
 - (2) Install the three coil nuts.
28. Coat the mating surfaces of the case and cover with a small bead of sealant.
- Use Black Non-Acid Cure Silicone Rubber E7TZ-19562-A or equivalent meeting Ford specification ESL-M4G273-A.

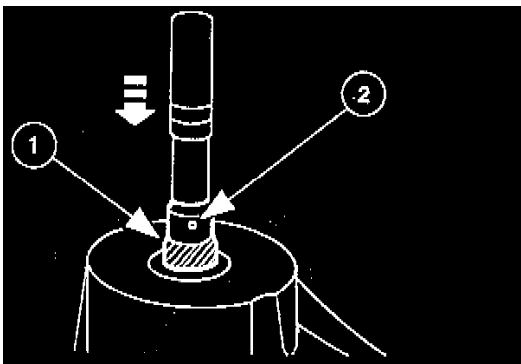
CAUTION: If too much silicone rubber is used when sealing the cover to case, the excess sealant may plug the fluid filter and cause case failure.



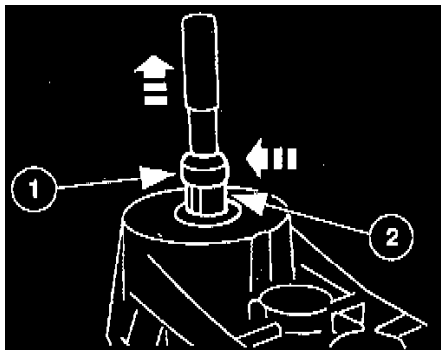
29. Position the two transfer case halves and tighten the bolts according to sequence.



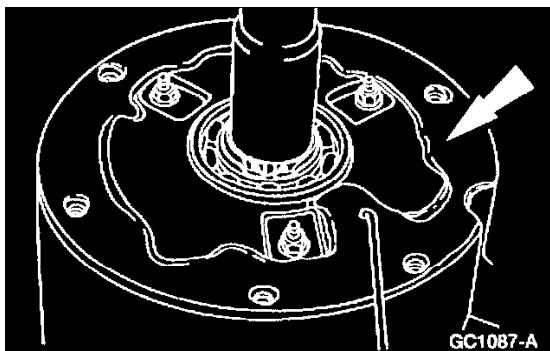
30. Install the rear output shaft snap ring.
- Lift up on the output shaft while installing the snap ring.



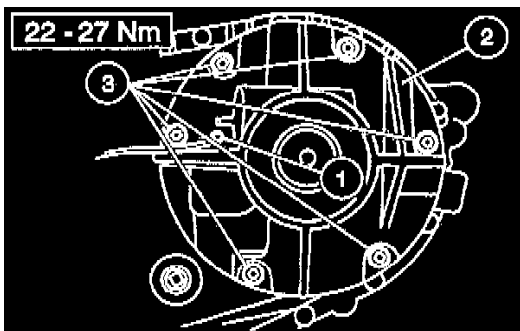
31. Install the speedometer drive gear and steel ball.
- (1) Slide speedometer gear onto output shaft until it touches the case.
 - (2) Position the steel ball.



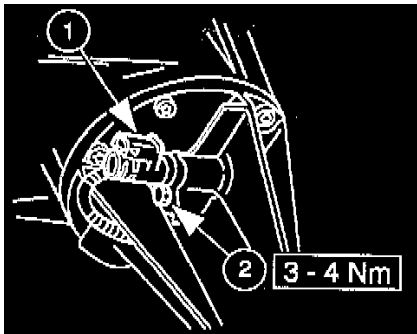
32. Install speedometer gear spacer.
- (1) Lift up on the speedometer gear.
 - (2) Install speedometer gear spacer.



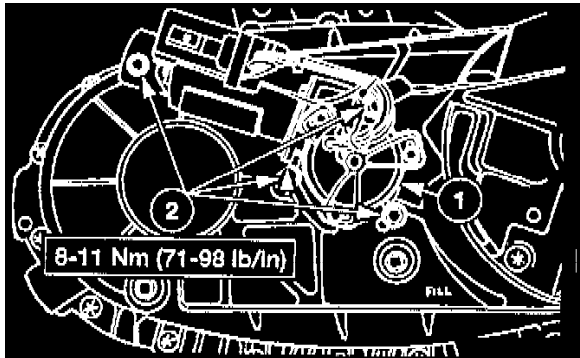
33. Apply a small bead of sealant to the transfer case cover and extension housing mating surfaces.
- Use Black Non Acid Cure Silicone Rubber E7TZ-19562-A or equivalent meeting Ford specification ESL-M4G273-A.



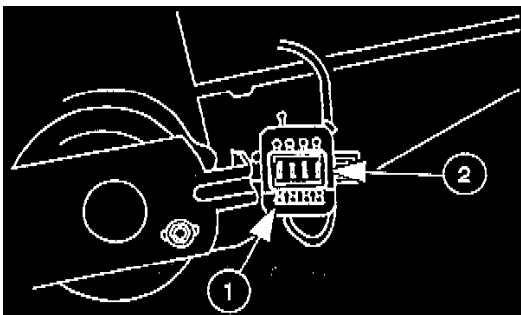
34. Install the extension housing.
- (1) Position brown clutch coil wire through its hole in the extension housing.
 - (2) Position the extension housing.
 - (3) Install the six extension housing bolts.



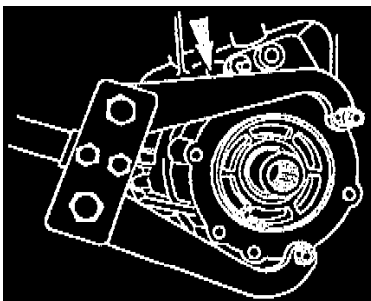
35. Install the vehicle speed sensor.
- (1) Position the VSS.
 - (2) Install the VSS bolt.



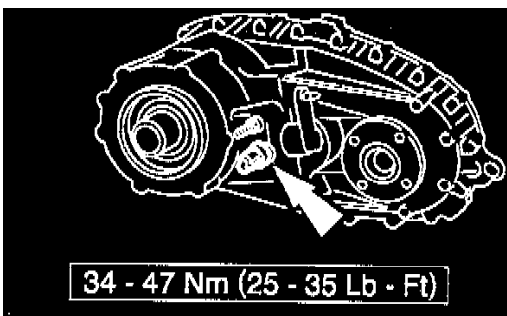
36. On electrical shift transfer case, install the electric shift motor.
- (1) Position electric shift motor.
 - (2) Install the four electric shift motor bolts.



37. Install the coil wire into shift motor electrical connector.
- (1) Install the coil wire and pin.
 - (2) Install the wire connector spacer.



38. Remove transfer case from bench holding fixture.



39. On manual shift transfer case, install the 4WD indicator switch.
40. Install the transfer case in the vehicle.