

Automatic Transaxle/Transmission - 6R80 - Shift Solenoids (SS) - in Vehicle Repair

307-01 Automatic Transaxle/Transmission — 6R80	2013 F-150
IN-VEHICLE REPAIR	Procedure revision date: 08/30/2012

Shift Solenoids (SS)

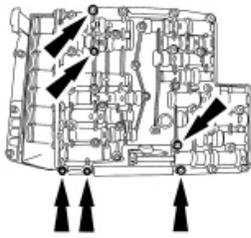
Material

Item	Specification
Motorcraft® MERCON® LV Automatic Transmission Fluid XT-10-QLVC (US); CXT-10-LV12 (Canada)	MERCON® LV

NOTE: [Refer to the on-line Workshop Manual to view this illustration as an interactive exploded view, requires Adobe® Acrobat® 8.0 or higher.](#)

NOTE: Refer to the on-line Workshop Manual to learn about using an Interactive Illustration.

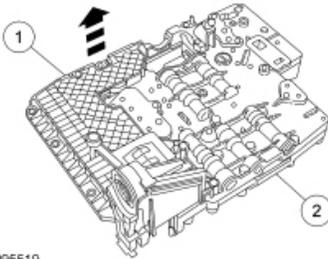
2. Remove the 6 long bolts from the molded leadframe.



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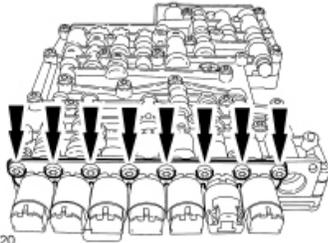
3. Carefully separate the molded leadframe from the main control assembly.

1. Molded leadframe.
2. Main control.



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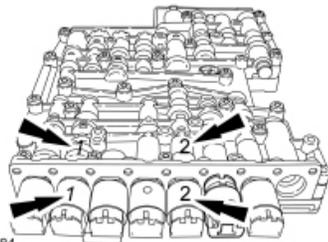
4. Remove the 8 solenoid bracket bolts and the solenoid bracket.



N0095520

5. **NOTICE: A VFS is calibrated from the factory and are not all the same. To replace a VFS , match the replacement solenoid nozzle color and the band number with the original solenoid or harsh/erratic shifts, harsh/soft engagement or damage to the transmission can occur.**

If replacing more then 1 solenoid, number the solenoids and number the main control solenoid ports to correspond to the solenoid. Pull the solenoid(s) out of the main control valve body.



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Installation

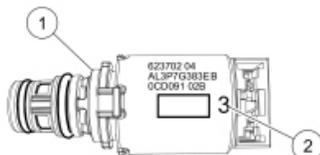
1. **NOTICE: A VFS is calibrated from the factory and are not all the same. To replace a VFS , match the replacement solenoid nozzle color and the band number with the original solenoid or harsh/erratic shifts, harsh/soft engagement or damage to the transmission can occur.**

Use the solenoid exploded view at the beginning of this procedure to identify what type of solenoid is being replaced. The solenoid can be a normally high VFS with a black nozzle, normally low VFS with a brown nozzle or an ON/OFF solenoid.

If replacing a VFS , record the band number and the solenoid nozzle color to get the correct part number for the solenoid.

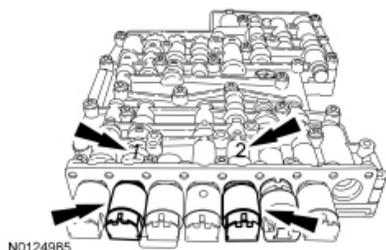
Lubricate the solenoid O-rings with clean transmission fluid.

1. Solenoid Nozzle
2. Solenoid band number

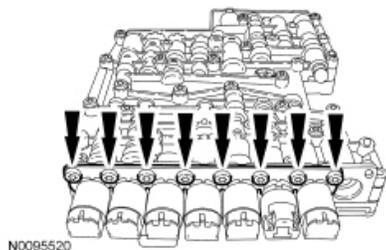


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2. Position the solenoid(s) in the main control in the correct port(s) as marked during removal.



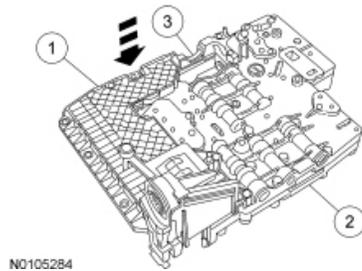
3. Position the solenoid bracket in place and install the 8 bolts.
 - Tighten to 6 Nm (53 lb-in).



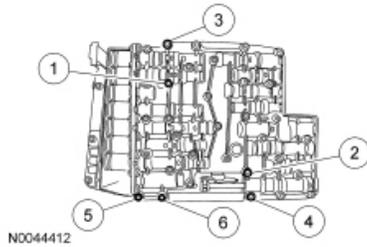
4. **NOTE:** *The TR sensor pin must be aligned with the manual control valve during installation.*

Position the molded leadframe on the main control.

1. Molded leadframe.
2. Main control.
3. TR sensor pin.



5. Install the 6 long bolts into the molded leadframe. Tighten the bolts in the sequence shown.
- Tighten to 6 Nm (53 lb-in).



6. Install the main control. Refer to [Main Control](#).

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