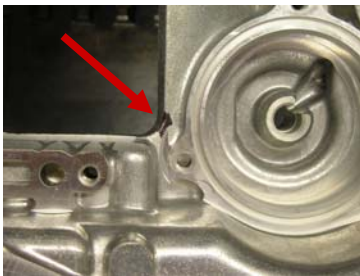


# *S799 Servo Bore Repair System:*

## 4F27 Modification Sheet

This sheet is to modify the **4F27** kit to work on **Ford FNR5 (FS5A-EL)** transaxles.

Recently, Ford has modified the four speed 4F27E transaxle into a five speed. The new five speed has an identical servo bore, but the case is shaped slightly differently. Existing 4F27 jigs can be modified to work on the new transaxle. Once the jig has been modified, no other changes are necessary. The FNR5 uses the same bushings as the 4F27E. Modifying the jig is easily accomplished with a bench top grinder. Instructions are below.



First, identify the area of the case web that interferes with the jig. The area is colored black in the picture at left, and has a red arrow pointing to it.



Now grind the jig on the edge that contacts the case.



And should sit in the case like this.

Next, mark the jig in the area where it contacts the case.



The finished jig should look like this.

# Now Available!

## **TFTV Master Kit**

Quickly and easily repairs worn Throttle Valve bores in Chrysler valve bodies. No time consuming external fixtures required.

