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## Instruction Sheet

**Part Number 727-127000 A-727 Bolt-In Overrunning Clutch Kit,  
1966-1990**

### Contents:

- 1-Outer Race
- 1-Inner Race
- 1-Notched Roller Cage
- 1-Spring & Roller Kit
- 4-Grade 8 1/4-28 Bolts
- 4-Flat Washers
- 4 Lock Washers
- 4 1/4" Ferrules
- 1-Instruction Sheet

Note: Before installation, read instructions carefully. If you do not understand any part of these instructions please call our tech line at the number listed above.

### **Safety Warning!!**

**Never operate this or any other 3 speed transmission without the proper safety devices in place. This includes both an SFI approved transmission safety shield and flexplate shield.**

**Any time you experience a universal joint or rear end failure you must disassemble the transmission and inspect the overrunning clutch assembly.**

**If you are unfamiliar with transmission repair and modifications, do not install this part. Instead, have it installed by a competent transmission technician who is familiar with such devices.**

**Failure to follow these directions and follow all safety procedures can result in serious injury or death!**

## **Instructions:**

### **Step 1:**

Remove the 4 bolts holding the output shaft support from the rear of the transmission case.

### **Step 2:**

Remove the socket-head set screw from the overrunning clutch boss located inside the rear of the case.

### **Step 3:**

Drive the outer race from the rear of the case using a flat drift punch. Drive the race out evenly by alternating between the 4 holes in the case.

### **Step 4:**

Drill the 4 holes in the rear of the case out to 11/32". Lightly chamfer the drilled holes. Blow out resulting chips with compressed air.

### **Step 5:**

Install the roller cage to the rear of the outer race. Be sure the cage fits flat to the race and that the 3 tabs are in the notches on the OD of the race. Also note the location of the notches in the cage; they must align with the tapped holes in the race. The cage should stay in place when the race is placed in the case.

### **Step 6:**

Align the new outer race to the boss in the rear of the case. Note that the tapered end of the race faces the rear of the case. Set the race in place and temporarily install the 4 bolts through the rear of the case to insure proper alignment.

### **Step 7:**

The race can be tapped into the case with a drift or pressed in with a hydraulic press or arbor press. Insure that the race is bottomed out in the case.

### **Step 8:**

Remove the bolts temporarily installed in Step 6. Install the output shaft support through the rear of the case. Place the lock washers, flat washers, and ferrules over the 4 bolts. Insert the bolts through the output shaft support and into the clutch race. Tighten bolts evenly.

### **Step 9:**

Install inner race and springs and rollers. Lubricate with transmission fluid. Temporarily install the low/reverse. When assembled

correctly the low/reverse drum will spin in a clockwise direction and lock instantly when turned in a counter-clockwise direction. Remove the low/reverse drum and continue with your overhaul.

**Suggested Related Additional Components:**

727-1399HP: A-727 Handbook

727-22754M: Modified Output Shaft Support

727-22754B: Bearing Output Shaft Support