



Fitting instructions for
MFK1195/80E
4L80E to
LANDCRUISER 80 SERIES
5-speed and Automatic Transfer Case

Thank you for purchasing a product manufactured by Marks 4WD Adaptors. The following instructions are intended as a guide. It is recommended that you purchase a workshop manual to suit your 80 series Land Cruiser.

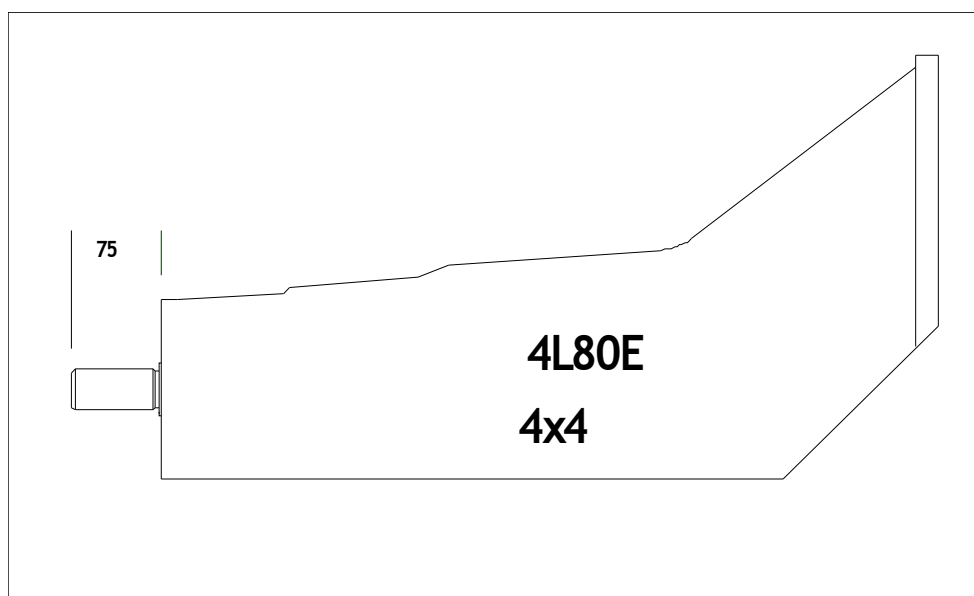
Note: The 4L80E with our adaptor kit fitted will be 794 mm long. The transfer case is further rearwards if fitted with L/C automatic transmission. Depending on the GM motor to be fitted with the 4L80E transmission, you may need to relocate the transfer case forward or rearward.

The following instructions assume the transmission is removed from the vehicle. The 4L80E can be fitted with a short output shaft as found in all the 4WD versions or from a 2 wheel drive. Refer to the diagrams below.

INSTRUCTIONS

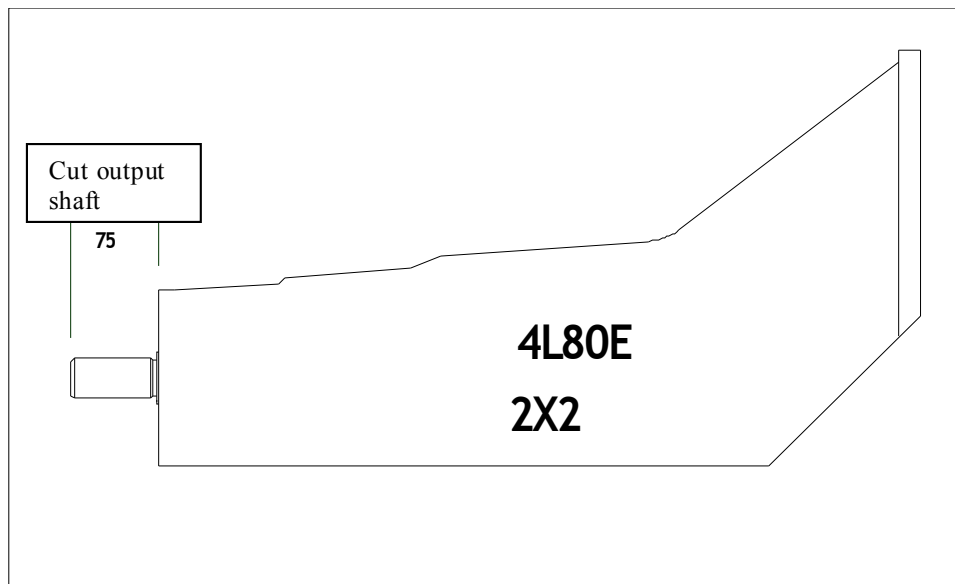
1. Drain the gearbox and transfer case oil.
2. Remove the transfer case from gearbox.

4L80E 4 wheel drive output shaft diagram.



The diagram above shows the output shaft stickout length of a 4x4 transmission for which the kit was designed to fit without any modification. However if a 2 wheel drive transmission is to be used the output shaft will need to be cut to the same length to allow the fitting of the kit. The 2 wheel drive transmission also has a sleeve fitted over the output shaft spline and will need to be removed using a small grinder and or cold chissel. Note: Be carefull when removing the sleeve as deep grooves in the shaft will weaken it substantially.

4L80E 2 wheel drive output shaft diagram.







3. Fit the 4L80E extension housing sealing ring to the steel adaptor plate.
4. Put a thin smear of silastic on the mating faces.
5. Fit the steel adaptor MFC1200 to back of the automatic transmission and secure it using the 6 M10x1.5x25 socket head cap screws supplied in the kit. ***NOTE:*** Check to make sure the socket head cap screws do not bottom out in the transmission taped holes. If they do cut or grind them down.
6. Fit a new sealing ring to the adaptor housing. ***NOTE:*** A TH700 or 4L60E sealing ring can be used.
7. Put a thin smear of silastic on the mating faces.
8. Fit the adaptor housing MFC1195 to back of the steel adaptor plate and secure it using the 4 M10x1.5x25 socket head cap screws supplied in the kit. ***NOTE:*** Check to make sure the socket head cap screws do not bottom out in the adaptor taped holes. If they do cut or grind them down.
9. Slide the coupler shaft over the output shaft on the automatic transmission. ***NOTE:*** Lubricate the spline on the output shaft using ATF.

10. Fit the new seal in the rear of the adaptor housing with the spring facing the transmission. **NOTE:** Use sealer and a suitable drift to fit the seal.
11. Fit the 2 M12x20 dowels (MFC382) to the adaptor housing.
12. Fit the transmission assembly to the transfer case and secure it using the original Toyota bolts.
13. Fit the HI/LOW lever assembly to the top of the adaptor housing and connect the linkage.
14. Fit the torque converter to the transmission and put a small amount of grease on the location spigot.
15. Fit the flex plate to the engine and secure it using the GM crankshaft bolts. **NOTE:** Use locktite on the bolts and torque to specification.
16. Apply a small amount of grease to the crankshaft pocket.
17. Lift the complete assembly into the vehicle and secure it to the engine using the GM bellhousing bolts. **NOTE:** One of the top bolts also secures the dip stick tube.
18. Fit the cross member and the transmission mounting rubber using the original bolts.
19. Fit the torque converter bolts. **NOTE:** Use locktite on the bolts and torque to specification.
20. Fit the torque converter cover plate and secure it using the GM bolts.
21. Fit the front and rear drive shafts.
22. Fit the transmission cooler and pipes. **NOTE:** Keep the pipes well clear of the exhaust system.
23. Fit the transmission shifter. **NOTE:** A B&M or Hurst type can be used.
24. Fit the HI/LOW lever and boot.
25. Connect the inhibit switch and reverse light switch.
26. Connect the transmission control module (TCM) to the transmission.
27. Fill the transmission with ATF.
28. Start the engine and allow it to warm up and check for oil leaks.
29. Before road testing check the transmission oil level.

30. Road test the vehicle for 1 to 5km.

31. Then check again for oil leaks.

The components supplied in the kit are designed for specific type conversions. Modifications to any components without the written consent from Marks 4WD Adaptors will void any possible warranty or return privileges. Should you have any further questions that are not covered in the instruction sheet, please contact our sales department for assistance.

Remember an inexpensive phone call can save a costly mistake!

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