



## Fitting Instructions for MFK1945A 6L80E to LandCruiser HF2A Auto Transfer Case



### Important Information

This instruction booklet can be used standalone for the above stated conversion but we would also recommend having a workshop manual for your vehicle and for the engine/transmission you are installing to cover any factory torque / installation settings to complete the installation.

The instruction booklet describes the required modifications (if any) and installation process in order for our kit to fit and work properly. These instructions **make no assumption** on whether additional changes need to be considered or made. It is highly possible that other aspects of your vehicle and/or third party products, eg. Engine, transmission etc. will have an impact on all that is required for you to achieve your desired outcome.

Marks 4WD Adaptors do not and cannot take responsibility for knowing everything that may impact on your conversion. Before beginning any work, thoroughly work through the sequence of changes, work and potential impact of your conversion. You must ensure you completely understand all the factors that may impact on achieving your desired results.

## ***Transmission Preparation***

### **4wd Version**

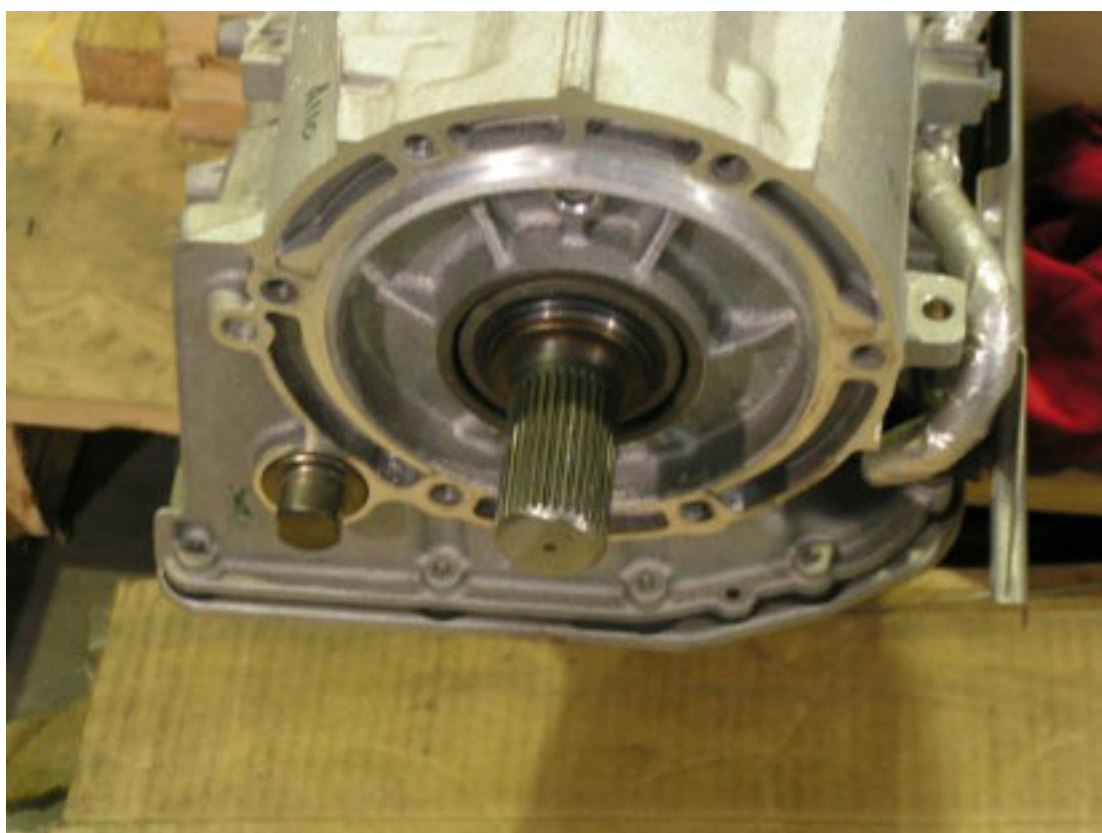
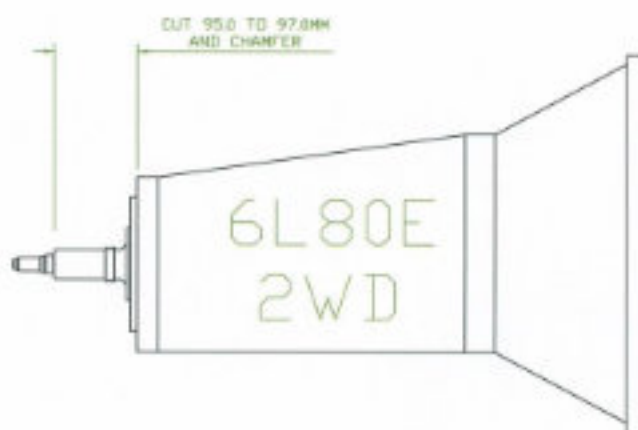
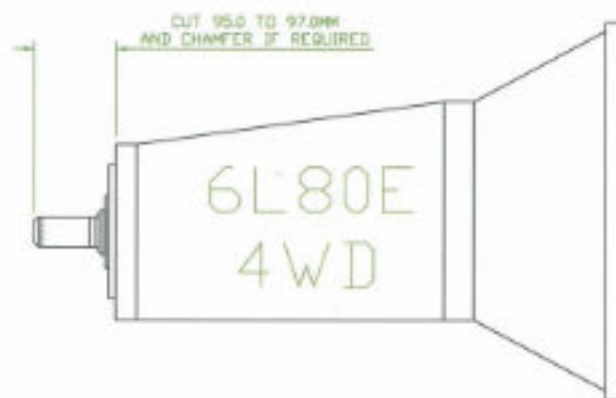
1. Remove the GM transfer case and adaptor housing if fitted.



2. Measure 95mm to 97mm from the rear face of the transmission and mark the output shaft.  
**Note:** The 4wd transmission output shaft may not need to be cut down. See photo and diagram below.

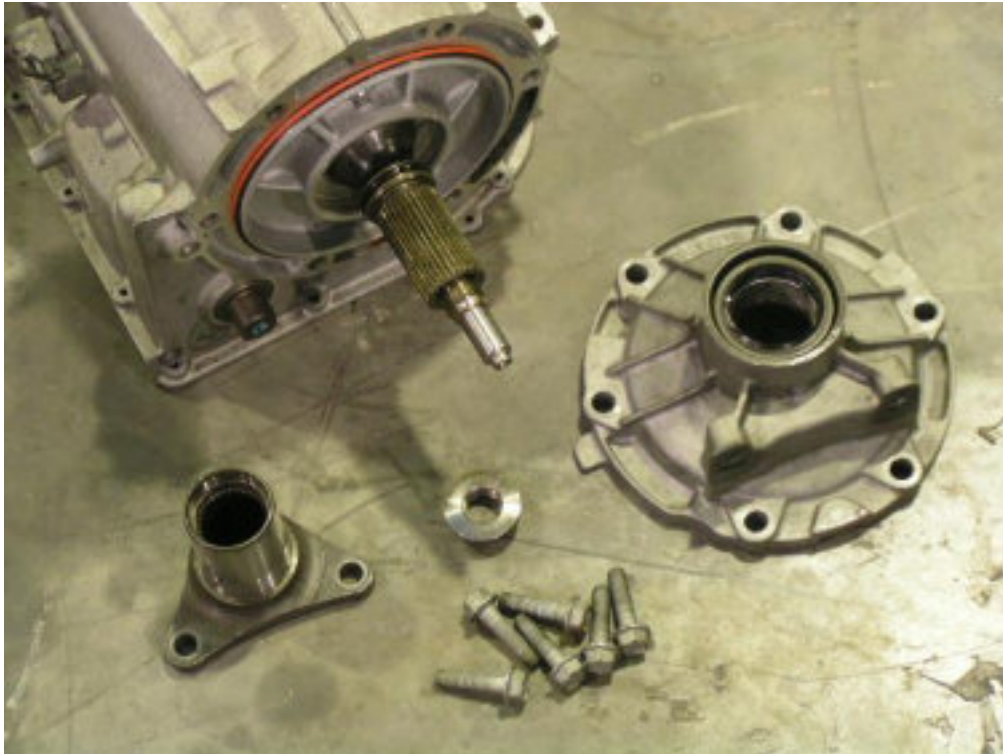


3. Cut and chamfer the output shaft as per the following diagram & photo.

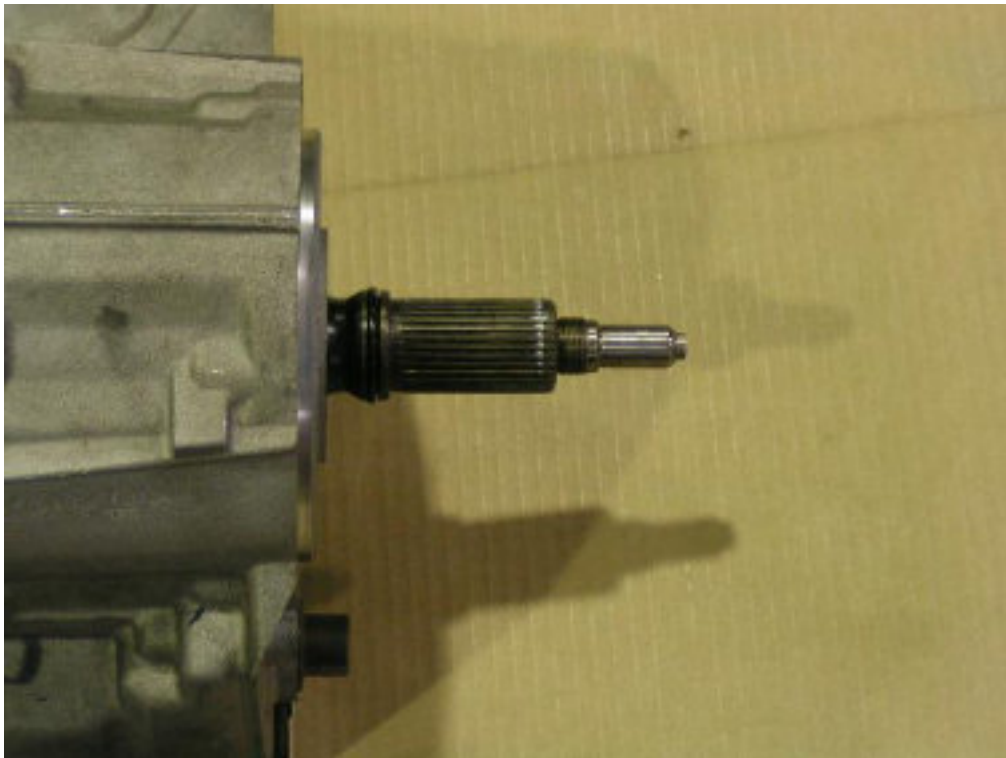


## 2wd Version

1. Remove the drive flange and the extension housing from the back of the transmission.



2. Measure 95mm to 97mm from the rear face of the transmission and mark the output shaft as per the 4wd version above.
3. Cut and chamfer the output shaft as per the following diagram & photo above for the 4wd version.





4. Check to make sure the coupler shaft fits over the previously cut and chamfered output shaft



5. Install the seal in the transfer case side of the adaptor with the spring side facing the transmission.  
**Note:** Use a hammer and a suitable drift.



6. Install the transfer case adaptor to the back of the transmission and check that it fits.  
**Making sure there is clearance at the top of the transmission, as the shifter mount sit on top.**  
**The transmission may require some grinding/sanding so there is good clearance. See Image Below.**



7. Install the transfer case adaptor to the back of the transmission and secure using the original bolts.  
**Note:** Do not use the original GM O-ring, use Threebond gasket sealer between the faces.
8. Install the transmission assembly into the vehicle, using the original Toyota transmission mounting rubber to the adaptor and install the cross member, use all of the original bolts.

9. Install the hi/low lever bracket to the top of the adaptor.

**Note:** When replacing the 4 speed automatic one of the M8 bolts on the passenger side will need to be cut down so it doesn't bottom out.

If you fail to cut the bolt down it will break the adaptor housing – we have done this – be warned!



10. Install the transfer case to the adaptor and secure it using the original bolts.

**Note:** The bolt used in the centre hole on the drivers side will need to be replaced with the supplied socket head cap screw.

11. Install the hi/low linkage.

## Terms and Conditions

Thank you for purchasing this product manufactured by Marks 4WD Adaptors. Components supplied in this kit are designed and machined for a specific conversion only as outlined in this guide. Modifications to or substitution for any of the components without the written consent of Marks 4WD Adaptors will void any possible warranty or return privileges.

The following instructions are intended as a guide and only for Marks 4WD Adaptors kits. If you do not fully understand the steps, modifications or changes required to complete the conversion, contact our sales department for more information. We recommend that you purchase a service manual pertaining to your vehicle for specific torque values, wiring diagrams and other related information.

## Contact Information

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