

SK® 604 Non-VLP

604/41TE & 606/42LE 1989-2006

Also fits 42RLE 2003-2006

Corrects / Prevents / Reduces

Delay or No Forward or Reverse, Rough Coast Down
4-3, Stabilizes Clutch Pressure & CVI's.

Working on **604** or **42RLE VLP** model that has a Pressure Control Solenoid?
Order P/N **SK 42RLE-VLP** Fits: 2006up 604 and 42RLE **VLP** Models

Hello Mechanic -- We LOVE this trans.

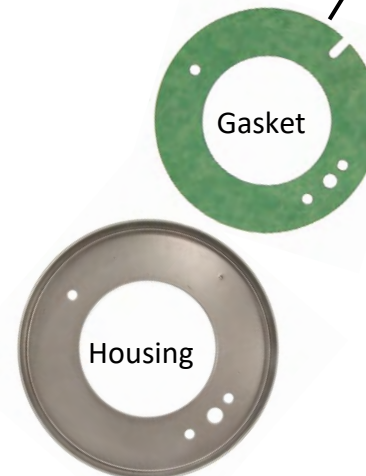
From 1989 we got hundreds of calls--The trans would go to **Limp** or **burn** OD clutches. At first we thought there must be **BIG errors** in the system that we could **find/fix**. We bought a van, installed 6 gauges, a scan tool. While installing dozens of parts we received from shops we managed to **burn** it up **20 times** in 60,000 miles of road testing.

For the first time in 35 years we had a trans control system that was *Intelligent & adaptive*. It took us two years to catch up with it. It had **no BIG** system **er-rors**, but it does have about ten things that **need** your careful **attention**. This trans loves the little things you do for it, so that it will shift good, stay out of **Limp** and please your **customer**.

If trans is in vehicle skip Step 1.

Step 1

Discard OE Housing Gasket. Install new *Non Shrinking Gasket* under Piston Housing. Gasket works with all piston housings.



This kit *does not* fit models with a **Pressure Control Solenoid!**

Models with Pressure Control Solenoid (VLP Models)
Use **SK 42RLE-VLP**
Fits 42RLE & 604 VLP Models.



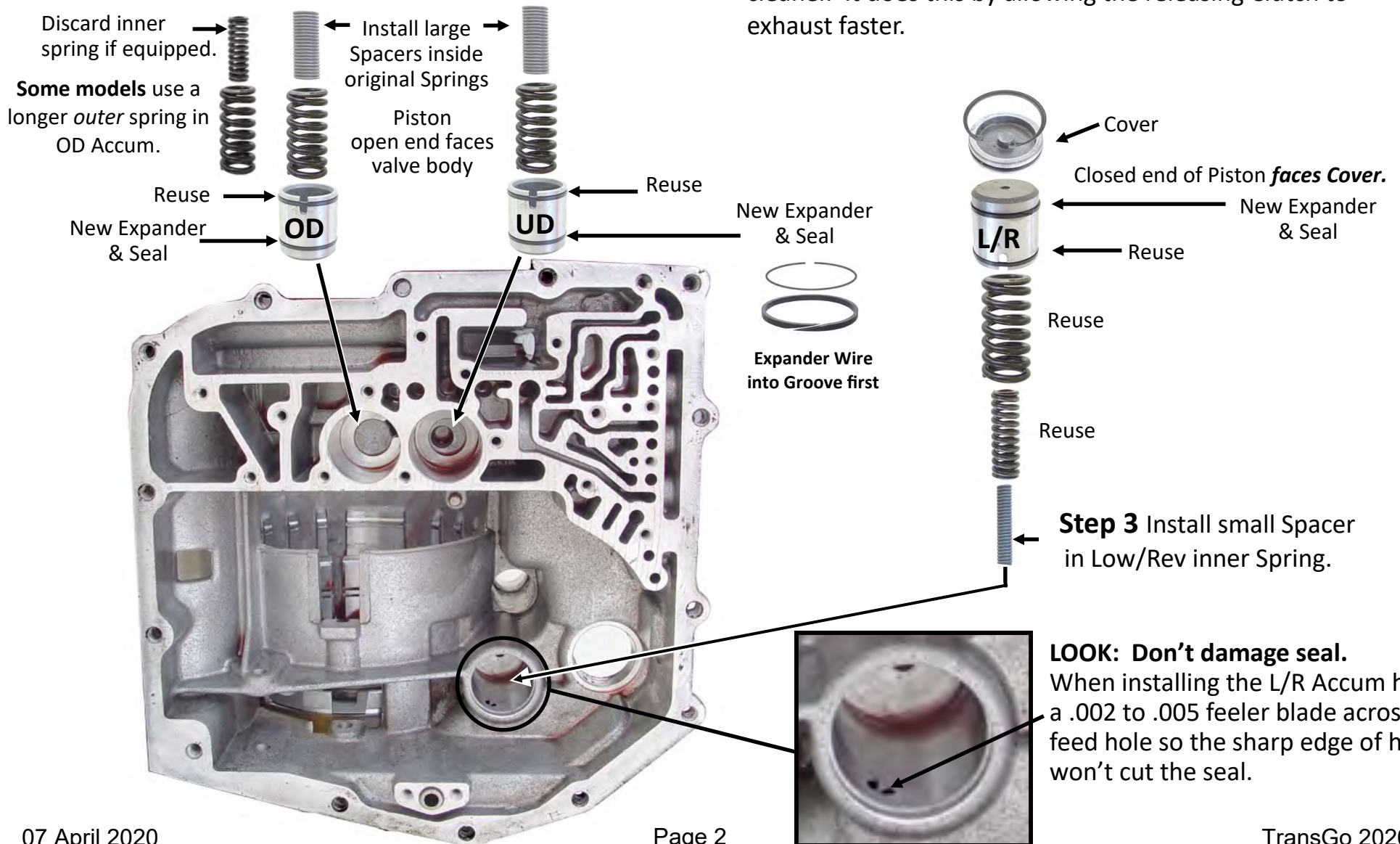
This Page 604/41TE, 606/42LE & 42RLE

Do NOT use Plastic Accumulator Pistons! All 1989-2006 must have aluminum pistons!

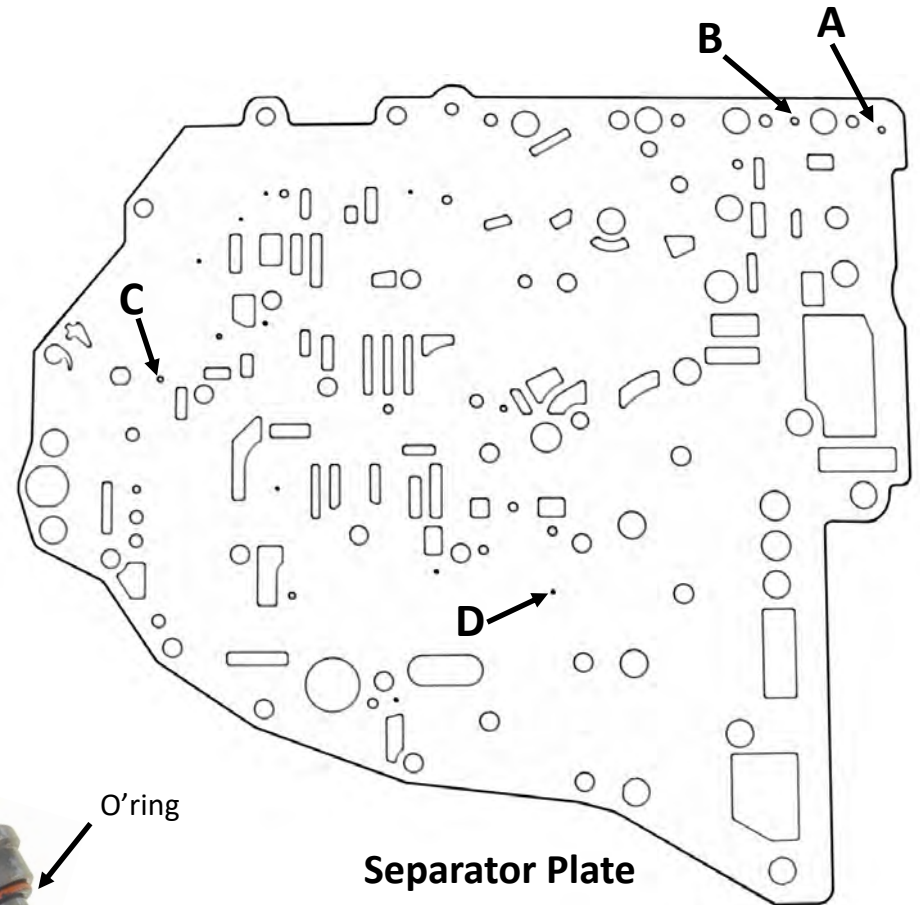
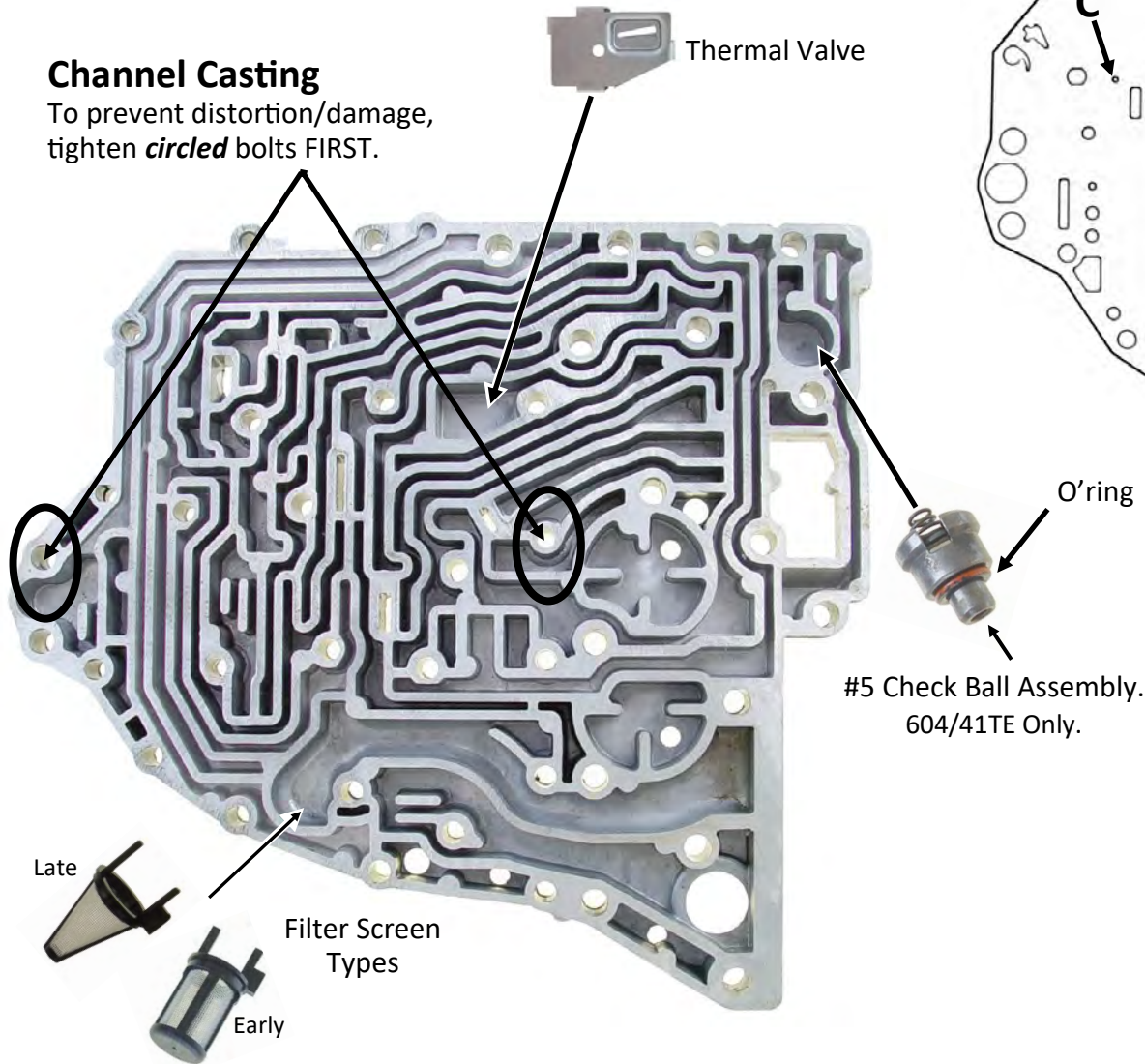
Step 1 Install new Expanders & Seals on the **CLOSED END** of **Aluminum** Accumulator Pistons.

Step 2 Install Large Spacers into OD & UD Springs.

Tech: Installing Spacers causes shifts to be shorter and cleaner. It does this by allowing the releasing Clutch to exhaust faster.

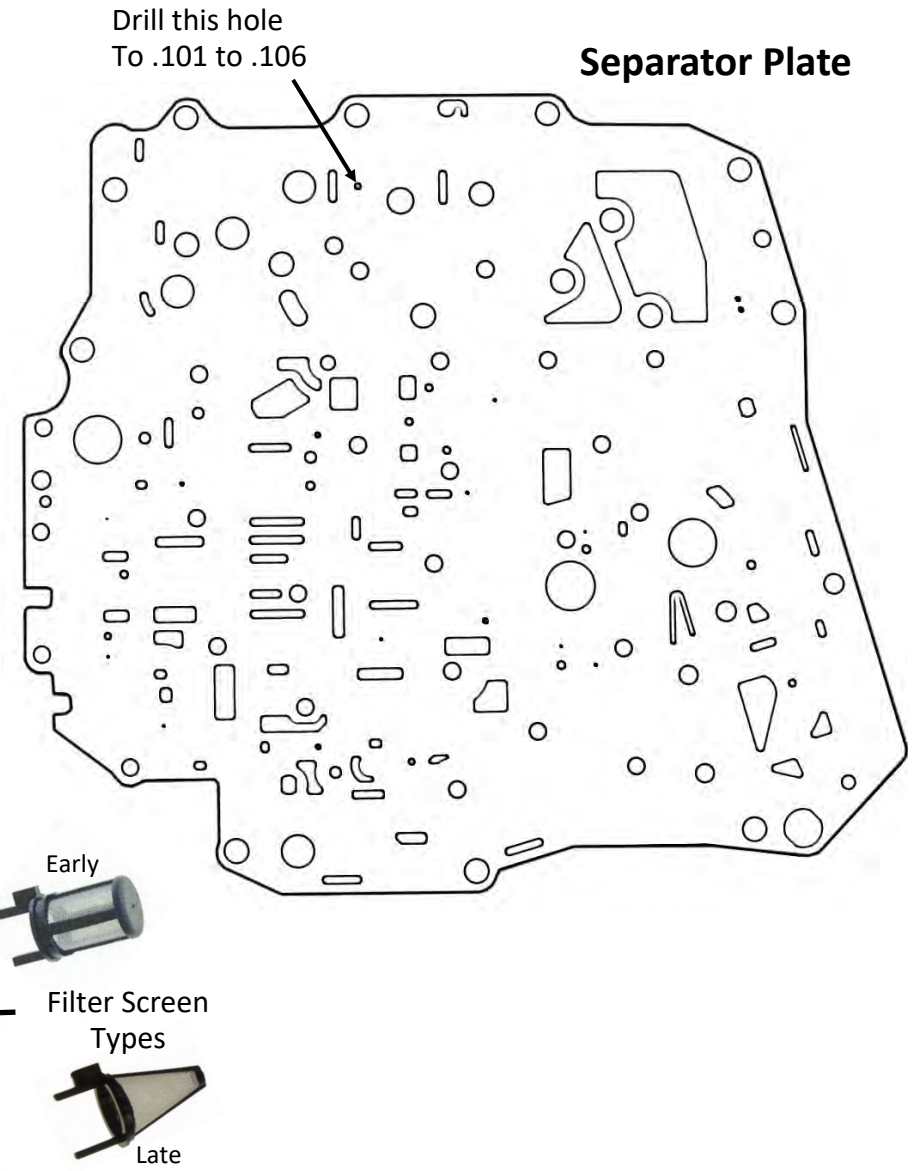
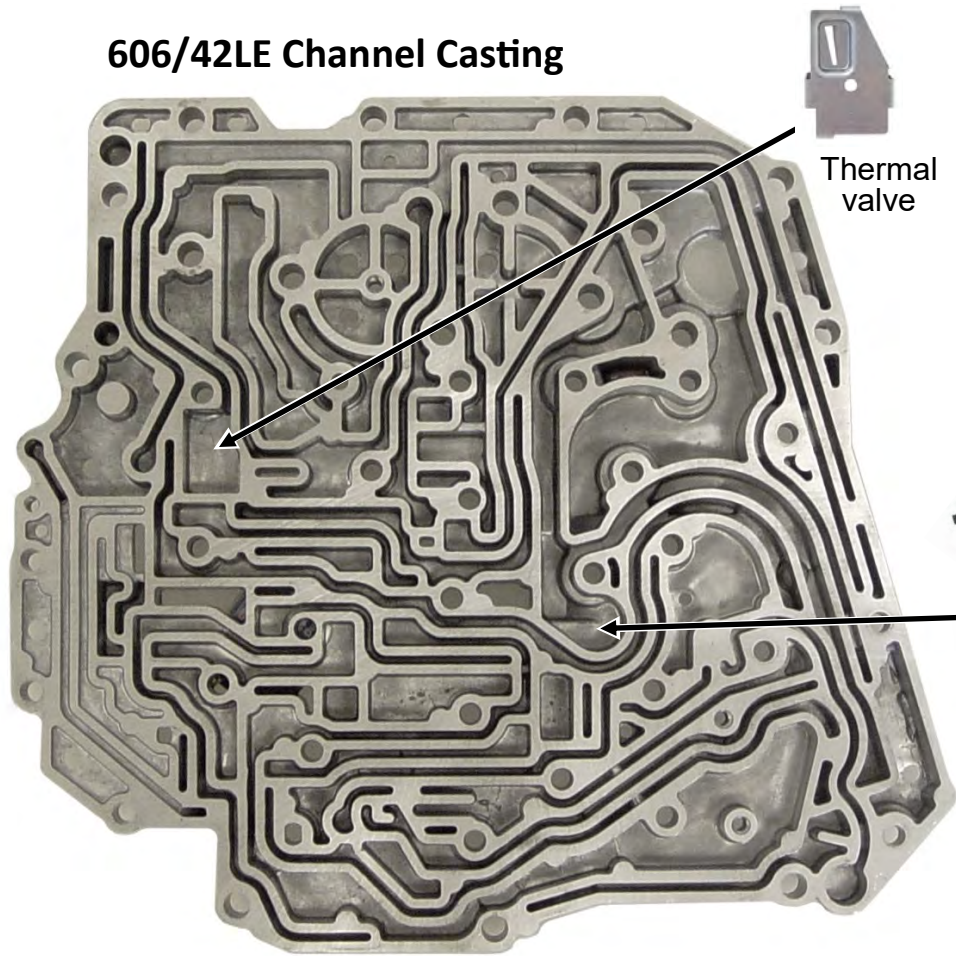


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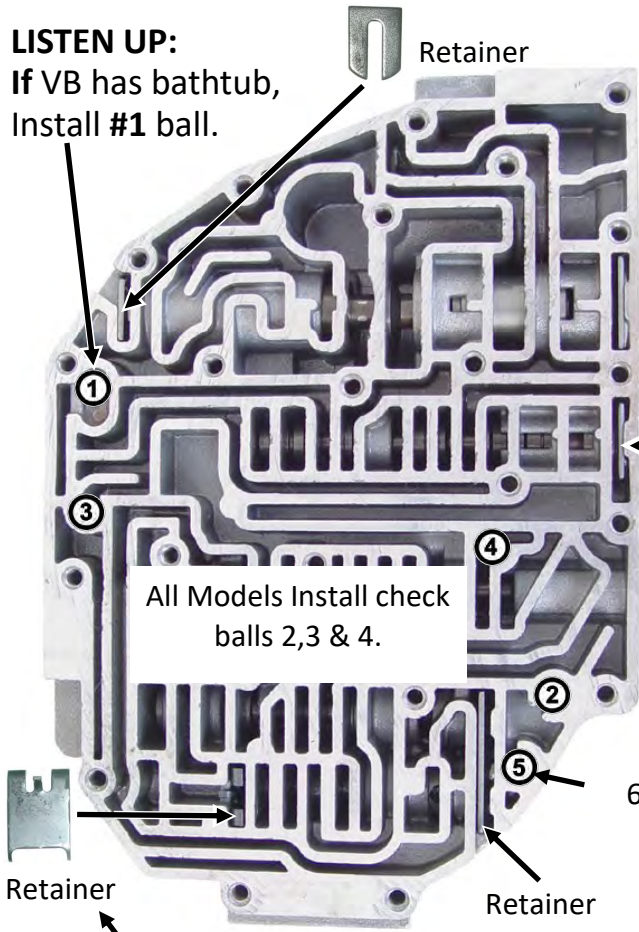


Hole A&B
Should be: .101 to .107.
Resize as needed.
Hole C: *Optional Shift feel*
Shorter high throttle 1-2
and cleaner 2-3 and 2-1.
Enlarge hole .076 to .078

This Page: 606/42LE & 42RLE Only



This Page: 604/41TE, 606/42LE & 42RLE
VLP Check-ball layout & PR lineup are different than shown.
 Use **SK42RLE** for 42RLE & 604 VLP Models.



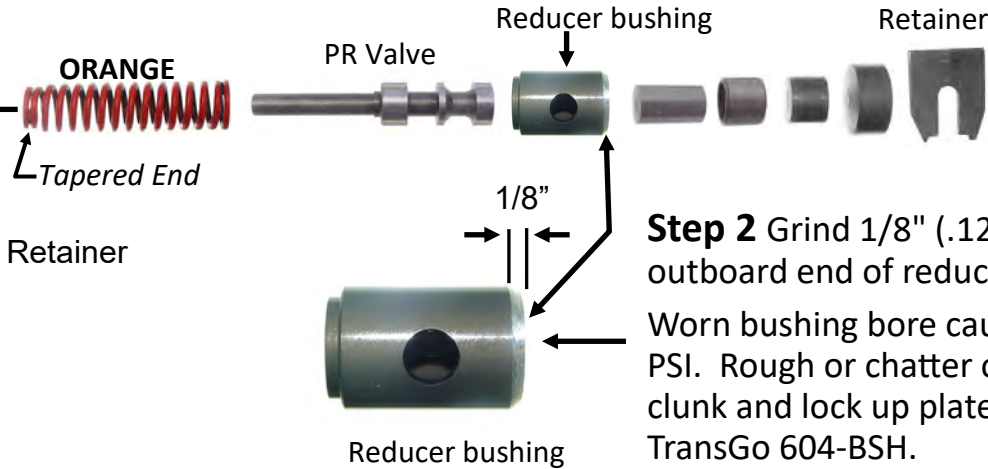
LISTEN UP:
 If VB has bathtub,
 Install #1 ball.

All Models Install check balls 2,3 & 4.

92up with a two piece lockup control valve, has a retainer here. Missing retainer causes low line and trans burn up.

**Do NOT use Plastic Accumulator Pistons!
 Aluminum Only!**

Step 1 Install Orange PR Spring, tapered end in first.

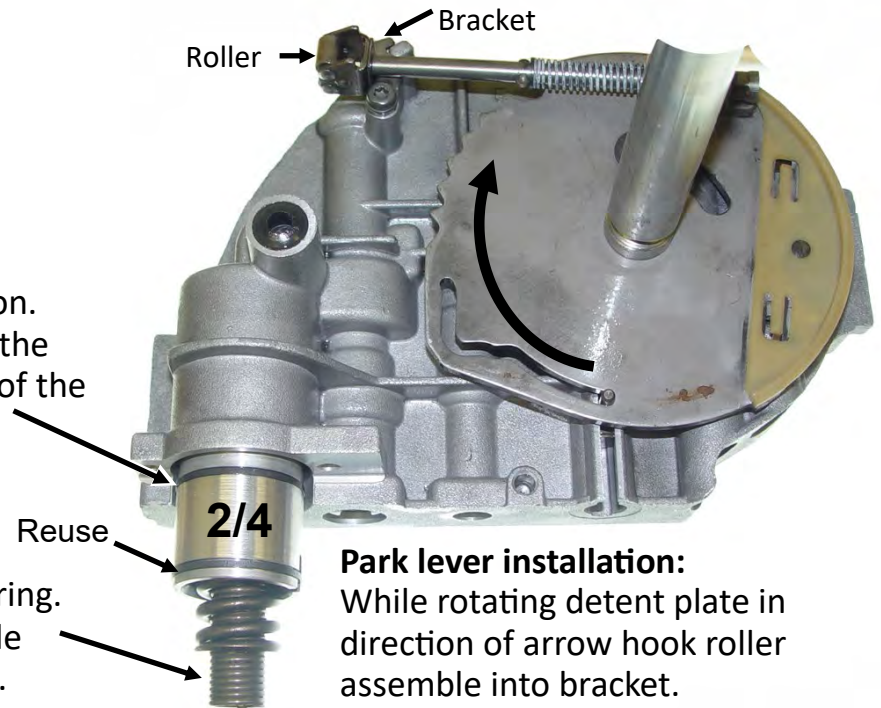


Step 2 Grind 1/8" (.125) chamfer on outboard end of reducer bushing.
 Worn bushing bore causes high line PSI. Rough or chatter on 1-2, 4-3 coast clunk and lock up plate failure. Order TransGo 604-BSH.

606, 42LE & 42RLE Install #5 Ball.
 (All others= No ball here)

Step 3 2/4 Accum Piston.
 Install Wire Expander & the new Seal on closed end of the **Aluminum** Piston.

Step 4 Discard inner Spring.
 Install **Large Spacer** inside the original outer Spring.



Park lever installation:
 While rotating detent plate in direction of arrow hook roller assemble into bracket.

604/42RLE 4th Type** Stack-up

UD clutch: Has four .073 thick frictions. High Energy/Brown Paper

OD clutch: Has four .073 thick frictions should be High Energy.

Reverse clutch: Has two .073 frictions High Energy/Brown Paper

UD stack- Start with .068 steel plate, alternate .073 clutch plates, the stack will end with a friction. Install .061" flat snap-ring, 4th design UD/OD Pressure plate then tapered .090 snap-ring.

OD stack- Start with .073 friction plate, alternate with .068 steel plate. The stack will end with a friction plate. Install waved snap-ring, OD/Rev Pressure Plate then install flat snap-ring.

***Rev stack-** Start with .073friction, .068 steel, .073 friction, Pressure Plate and flat selective snap-ring.

Selective Rev Snap Rings: 1.53-1.58mm- # 04377195, 1.77-1.83mm- # 04412871, 2.02-2.07mm- # 04412872, 2.27-2.32mm- # 04412873.

****Earlier stack-up- Types 1 through 3 can be found in the SK 604 kit Additional Information Lesson 3A**

Note: Some small engine models can come equipped with only 3 OD clutches & 1 Reverse clutch. This stack-up is not covered here. Use your specific vehicle data when ordering replacement parts.

