



Installation Instructions CAST ALUMINUM TRANSMISSION PAN

2009-2020 Ford Truck/SUV with 6R80 Transmission
2017-21 Ford F-250 Models with 6R100 Transmission
Catalog # 70394



Watch our
installation video
on YouTube

WORK SAFELY! For maximum safety, perform this installation on a clean, level surface and with the engine turned off. Place blocks or wedges in front of and behind both rear wheels to prevent movement in either direction.

CAUTION: To avoid any possibility of bodily injury or damage to vehicle, do not attempt installation until you are confident that the vehicle is safely secured and will not move.

This B&M Cast Aluminum Deep Oil Pan has been designed to work on most Ford trucks and SUV's equipped with the 6R80 transmission. The B&M Cast Aluminum Deep Oil Pan provides several advantages over stock factory oil pans. The extra capacity provides increased oil volume and added cooling, while the aluminum construction increases case rigidity. The magnetic drain plug feature allows regular transmission maintenance and oil changes without the usual mess associated with dropping the pan, and limits ferrous debris from circulating in the transmission.

The pan can be installed by anyone with minimal mechanical experience. It is however, important to closely follow the instructions. We recommend that you read through the instructions completely before beginning the installation, so you can familiarize yourself with the installation procedure. Check the tool list at the end of these instructions for the tools required to install your Deep Oil Pan. When installing your Deep Oil Pan there are several other B&M products you may wish to consider:

TRANSMISSION OIL COOLER: We feel that it is very important that every vehicle should have a transmission oil cooler in addition to the radiator heat exchanger. Heat is the major cause of transmission failures, and an oil cooler is an inexpensive safeguard against overheating. B&M offers a wide range of transmission coolers to suit every need, which are available at your B&M dealer.

INTRODUCTION

This Deep Oil Pan can be installed in about an hour by carefully following the instructions. Transmission components are precision fit and dirt is the number one enemy of an automatic transmission. Cleanliness is very important, so a clean work surface from which oil can easily be removed is necessary.

CAUTION: Automatic transmissions operate at temperatures between 150°F and 250°F. It is suggested that the vehicle be allowed to cool off for a few hours to avoid burns from hot oil and parts. The vehicle should be off the ground for ease of installation – jack stands, wheel ramps or a hoist will work fine. **MAKE SURE VEHICLE IS FIRMLY SUPPORTED - DO NOT WORK UNDER A VEHICLE IF IT IS SUPPORTED BY ONLY A JACK!** Try to raise the vehicle 1-2 feet so you will have plenty of room to work. Also, have a small box to put bolts in and a drain pan to catch oil.

1. Drain the transmission fluid. Place a drain pan under the trans pan. Starting from the front of the pan, remove the bolts working your way down the sides of the pan evenly, removing them from side to side. As you work your way to the back, fluid will start to drain from the front of the pan. If the pan sticks to the old gasket, pry it down slightly with a screwdriver to break the seal. After most of the fluid is drained, remove the rest of the pan bolts. **Note:** When removing the pan from the vehicle, there will still be fluid in the pan and trans filter may fall down.



2. Remove the magnet from the stock oil pan and secure it on the B&M pan with the supplied hardware.

M6x10mm bolt, ¼” oversized washer, M6 lock washer.

Note: Use thread-lock sealant on the bolt.



3. Install the 1/8 accessory pipe plug and then install the drain plug, be sure to use thread tape on the drain plug threads.



4. Inspect and wipe clean the stock oil pan gasket. If the gasket is in good condition, it can be re-used.



5. Clean the transmission mounting surface and install the B&M pan onto the transmission with the supplied M6 allen bolts and washers, qty. 21. Torque pan bolts to factory torque specs. Then follow your stock re-fill procedure. **NOTE:** Make sure transmission filter is pushed up into place inside the transmission.



Parts List

| | |
|---------------------------|------|
| Aluminum Cast Oil Pan | (1) |
| Magnetic Drain Plug | (1) |
| 1/8 Pipe Plug | (1) |
| M6 x 10mm Allen Bolt | (1) |
| 1/4 Oversized Flat Washer | (1) |
| M6 Lock Washer | (1) |
| M6-1.00 x 25 mm Bolts | (21) |
| Flat Washers | (21) |

Tool List

| |
|----------------------------|
| Drain Pan |
| 3/8 Ratchet & 3" Extension |
| 8 mm Socket |
| 5 mm Allen Socket |
| 3/8 Allen Wrench |
| 5/32 Allen Wrench |
| 3/16 Allen wrench |
| Jack & Jack Stands |

IMPORTANT: RETAIN THESE INSTRUCTIONS FOR FUTURE REFERENCE

