

TCI® 221201

Turbo 400 Full Manual Valve Body w/engine braking

Shift pattern: Park-Reverse-Neutral- First -Second -Third

This Kit Contains:

- (1) Turbo 400 Full Manual Valve Body
- (1) Manual Valve
- (1) Separator Plate
- (1) Band Release Spring
- (1) Vacuum Modulator Plug & O-Ring
- (1) 1/4" Steel Check Ball
- (16) Direct Clutch Drum Springs

CAUTION: Shifting to first gear above speeds 15 mph is not recommended

IMPORTANT: Before you begin installation allow the transmission to cool to avoid burns from hot fluid or parts. Select a well lighted work area and it is very important to keep all parts clean. Use a box or pan to keep transmission parts from getting misplaced. Wash parts thoroughly with clean solvent.

STEP 1. Drain and remove transmission from vehicle. *(Remember to dispose of fluid in a proper, safe way to protect our environment).*

STEP 2. Remove transmission oil pan and filter.

STEP 3. Remove valve body, separator plate, gaskets, governor tubes, and check balls. The front band servo piston assembly will be reused to retain engine braking in second gear.

STEP 4. Remove pump, forward drum, and direct drum.

STEP 5. Remove and discard the second sealing ring from the top of the center support. **(See Photo 1)** TCI® recommends the use of Teflon sealing rings on the center support and pump to reduce wear.

STEP 6. Direct Drum Modifications : Remove the piston assembly and discard the lip seal in the drum. Re-install the piston and replace the 16 piston return springs with the new springs provided.

Set the clutch pack clearance: .050"-.070".

STEP 7. Re-install the direct drum and forward drum assemblies.

Step 8 Remove rear servo piston. Remove and discard the two rings from the reverse accumulator and install band release spring supplied with kit. **(See Photo 2.)**

STEP 9. You are now ready to install the **TCI® Reverse Manual Valve Body.**

Make sure that the transmission case is clean and that all gasket material has been removed. The front band servo piston assembly must be re-installed in the case if it was removed previously **(photo 4).**

If your front band piston is aluminum with raised rings and your stock valve body has an aluminum piston which is flat, remove the piston from the TCI® Valve Body and replace it with the one from your original valve body (photo 5).

To align the new valve body, install two guide pins into the transmission case.

Install only one 1/4" check ball in the transmission case as shown in (photo 3).

Leave out the remaining check balls.

When installing the valve body make sure the shift lever detent is engaged with the manual valve.

After starting all the valve body bolts, torque all bolts to 120 in. lbs.

STEP 10. Re-install filter pipe and o-rings (if removed), new filter, pan gasket and transmission pan. Torque pan bolts to 120 in. lbs.

STEP 11. Remove and discard the vacuum modulator. Installed the new o-ring supplied, on the **TCI®** replacement vacuum modulator plug. The OEM valve must remain in the transmission case.

STEP 12. Install the transmission into the vehicle.

STEP 13. Adjust the shift linkage in the neutral position and then check in all ranges.

STEP 14. Fill transmission with four (4) quarts of fluid. We recommend our **MAXSHIFT™ (TCI® 950600)** formulated for performance applications. Place the shifter in park and start the engine. Check the fluid level with a correct transmission dipstick for your transmission. Do not overfill the transmission. The correct fluid level for this transmission when the transmission is cold is, at the bottom of the add mark.

STEP 15. With the vehicle jacked-up and secured properly, run transmission through each gear change and place the shifter in park and check the fluid level again.

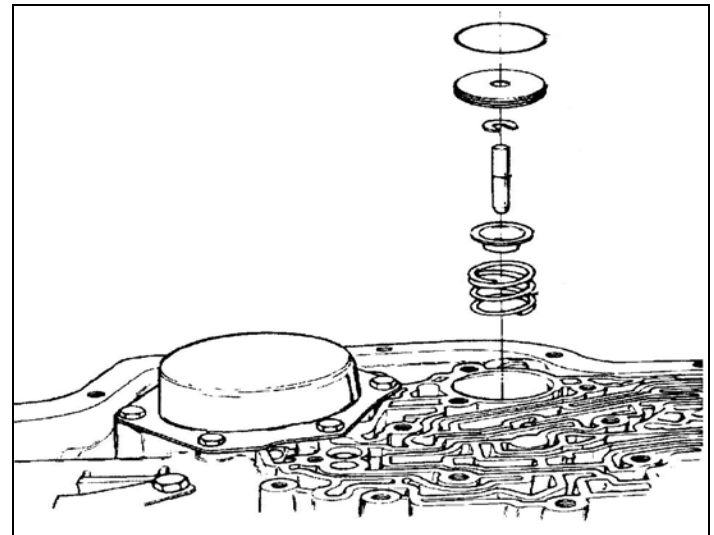


Photo 4



Photo 1

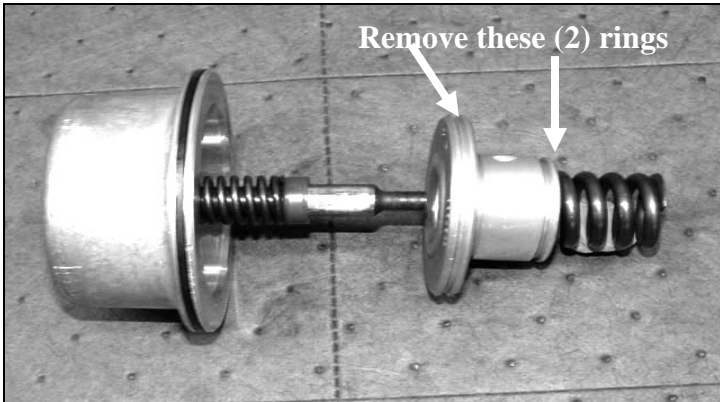


Photo 2

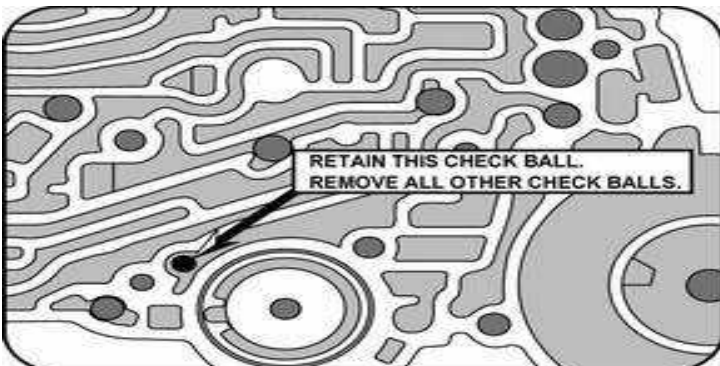


Photo 3

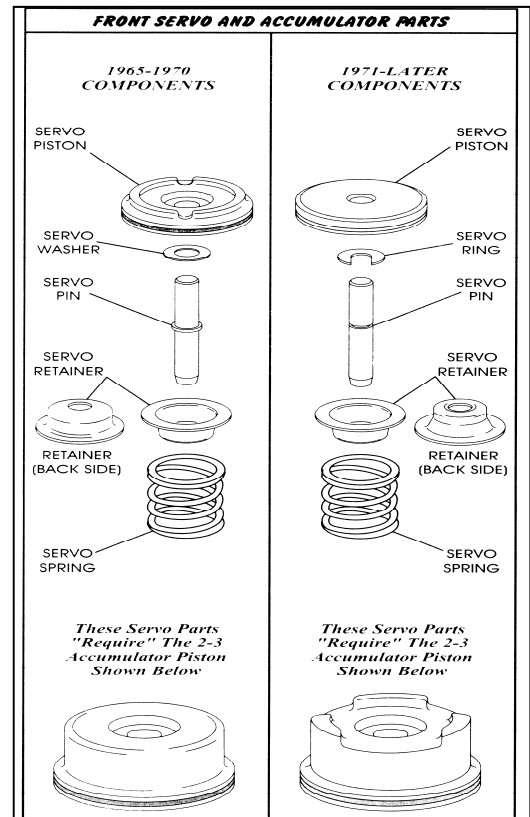


Photo5