



ATF TH-400 TRANSBRAKE VALVEBODY 2-Speed Fwd Pattern

!!!! PLEASE READ ALL INSRTUCTIONS BEFORE PROCEEDING!!!!

CAUTION

This trans-brake valve-body should only be installed by a qualified race transmission technician. Not following these instructions may cause property or physical damage.

Shift Pattern: Park—Reverse—Neutral—2nd—1st

Your trans-brake should include the following parts:

1. 1 ATF TH-400 2-Speed Valve Body
2. 1 ATF Trans brake Solenoid (Draw .8 amps)
3. 1 ATF Separator Plate
4. 2 Valve body Gaskets
5. 1 ATF Modulator Valve
6. 1 Pressure Regulator Spring (Medium)
7. 8 Purple Direct Return Springs
8. 1 Transbrake Valve Return Spring (Small)
9. 1 Rear Servo Return Spring (Large)
10. 1 Set of Instructions
11. Set of ATF Decals

TO ENGAGE REVERSE

Move shifter into reverse position and push the trans-brake button. This will engage Reverse.

INSTRUCTIONS FOR INSTALLATION OF TH-400 TRANSBRAKE VALVEBODY

1. Disassemble and clean transmission (Discard governor and tubes)
2. Disassemble direct drum
3. Drill a 1/16 bleed hole in direct drum **(FIGURE 1)**
4. Replace piston lip seals; Discard center seal in drum **(FIGURE 1)**
5. Install piston into drum; Install 8 New Direct clutch return springs. Replacing every other one. Install new clutches (Clutch Pack Clearance should be .060" to .080")
6. Discard Intermediate brake band and apply servo
7. Replace the pressure regulator spring with the large spring supplied. **(FIGURE 2)**
8. Remove second sealing ring from top of center support (Use Teflon Rings Only) **(FIGURE 3)**
9. Remove low and reverse servo piston assembly
10. Discard inner aluminum piston
11. Reinstall servo piston with Heavy Duty return spring. (Air check to insure proper apply)
Band clearance should be .125 to .170
12. Flat file or wet stone the entire channel passage area of the case; absolutely no high spots or burrs allowed.
13. Replace modulator valve with ATF Modulator Valve
14. Install small transbrake return spring onto valve and install into case.
15. Install o-ring onto transbrake solenoid and install into case.
16. Check Proper valve phasing when solenoid is applied and released. **(FIGURE 4)**
17. Install valve body using one gasket on each side of separator plate using the larger gasket against the case.
18. Install new filter; the Allison (Brass Screen) type is preferred.
19. Install pan.

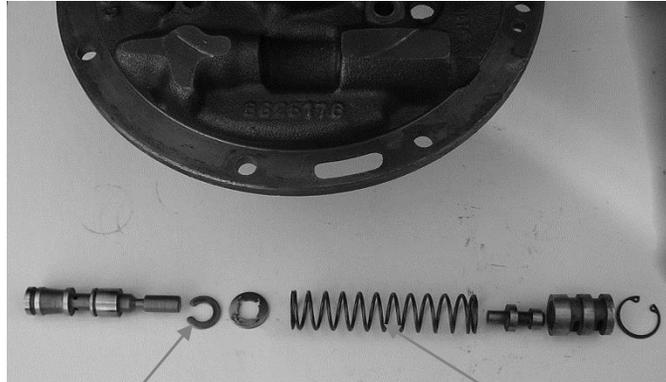
NOTES

- Use Teflon rings throughout transmission
- Make solenoid plunger bottoms out on solenoid back when applied

(FIGURE 1)



(FIGURE 2)



Shims can be used to increase line pressure

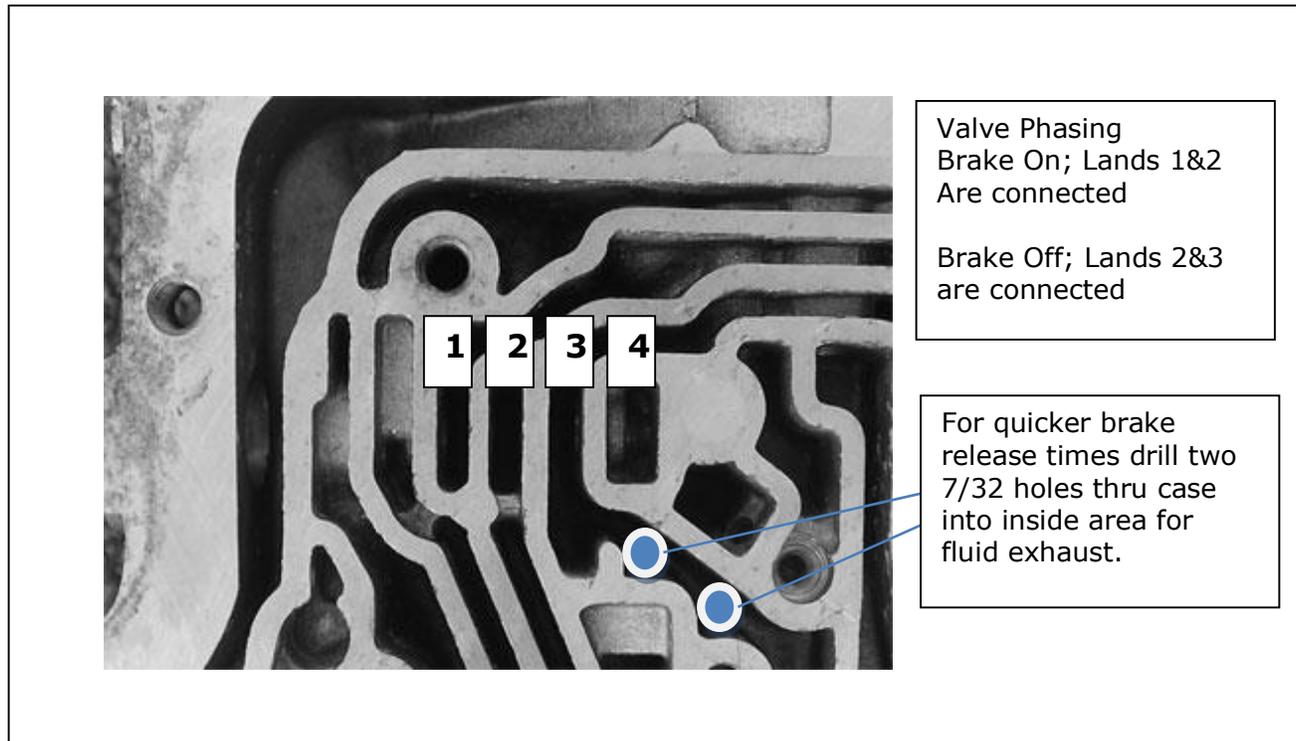
Replace Pressure Regulator Spring with supplied Medium Spring

(FIGURE 3)

Leave out this sealing ring



(FIGURE 4)



WARRANTY

This product is warranted for 12 months from date of purchase against defects in material and workmanship. This warranty does not cover damaged caused by negligence misuse or alteration. Under no circumstances will ATF be responsible for special, incidental or consequential damages or costs arising from or in conjunction with the installation or use of any product of the manufacturer