

**TURBO 400 FORWARD MANUAL VALVEBODY
INSTALLATION INSTRUCTIONS (ATD Part # 22248)**

1. OMIT DRUM SEAL IN THE DIRECT DRUM. INSTALL 2 SEALS ON THE DIRECT PISTON AND NONE IN THE DRUM.
2. USE STOCK CLEARANCES IN ALL CLUTCH PACKS.
3. USE TEFLON SEALING RINGS.
4. INSTALL 7/16" CUP PLUG IN REVERSE FEED HOLE, LOCATED TO THE RIGHT OF THE CENTER SUPPORT BOLT HOLE. INSTALL BELOW FLUSH; TORQUE CENTER SUPPORT BOLT TO 28 FT-LBS.
5. FLATTEN VALVEBODY SURFACE USING A DUAL-SIDED SHARPENING STONE OR VERY FINE FLAT FILE. LEAVE NO HIGH SPOTS. DO THIS AFTER TRANSMISSION HAS BEEN ASSEMBLED. CLEAN AREA THOROUGHLY.
6. INSTALL FRONT AND REAR SERVOS, CHECKBALLS, STOCK GASKETS, AND SEPARATOR PLATE. OMIT GOVERNOR AND TUBES. TWO CHECKBALLS ARE USED - MODULATOR AND LOW/REVERSE SERVO. SEE ILLUSTRATION BELOW.
7. START ALL VALVEBODY BOLTS BY HAND, THEN TORQUE TO 18 FT-LBS (5/16" BOLTS) AND 10 FT-LBS (1/4" BOLTS).
8. INSTALL MODULATOR VALVE AND BLOCKER PLUG.
9. INSTALL FILTER AND PAN.
10. NEVER SHIFT TO NEUTRAL AT SPEED OR THE TRANS WILL EXPLODE.
11. THIS VALVE BODY WILL NOT SHIFT UP OR DOWN WITHOUT THE DRIVER MOVING THE SHIFTER. SHIFT PATTERN: P-R-N-3-2-1.

CHECKBALL LOCATIONS:

