

## **HIPSTER TORQUEFLITE TRANSBRAKE INSTRUCTIONS**

**(TF8/ 727)**

1. Carefully inspect the condition of the roller clutch assembly in the rear of the case. The cage that positions the springs must be straight and the springs must be in perfect condition. Replace **anything** that is not like new. If the outer race is loose in the case, replace it with a bolt-in unit.
2. Install 15 HD release springs in the high clutch drum. A minimum of four clutches must be used. Replace waved snap rings with flat rings. Clearance clutch pack at .055 to .075 inch.
3. Late model stator support high clutch feed hole must be enlarged. Use a mill or die grinder to make the 3/16 inch feed a rectangular slot between the sealing ring grooves. Early stator supports are larger than 1/4 inch and can be used as is.
4. Inspect the pump assembly. Ensure the gear clearance is set to factory minimum specs. The tighter the clearance the better the transbrake apply.
5. Remove and discard the cushion spring from the rear servo piston and replace with 1/4 inch steel spacer.
6. On late model front servos (5/8 inch apply rod) remove small cushion spring and replace with 1/2 inch x 3/4 inch bushing. Install HD release spring. Early servos need no modification.
7. Set band adjustment at two turns, front and rear.
8. Position electrical connector in case approximately 1 inch behind solenoid and 3/4 inch away from solenoid. Drill 11/32 inch and tap 1/8 inch NPT.
9. Discard governor valve, weight and sealing rings.
10. Install park control rod and rooster comb assembly from your original valvebody.
11. Block accumulator piston in the case using large sleeve between piston and case.
12. Use only a screen type filter.
13. Transbrake uses reverse shift pattern: P R N 1 2 3. Use only reverse pattern shifters.
14. Engage reverse by selecting reverse or neutral and pushing transbrake button.
15. Do burnouts in second or high gear, never in first.
16. Never neutral or downshift to low at speed. Trans will explode.

**For technical help call 262) 251-7777 9am - 6pm CST**