

# INSTALLATION METHOD FOR VALVE BODY

PCE634.1009 Series



**NOTE:** Keep the factory manual valve. The factory manual valve will be used.

## **PREPARATION**

**NOTE:** This valve body requires the case to be tapped with a 1/4-20 tap in the case passage that allows oil under the servo. You only need a few threads. There's no need to tap to the bottom of the hole. Tap enough to install the setscrews provided.

## **INTERMEDIATE SERVO**

This valve body does not have the engine braking option. Therefore, leave out the intermediate servo, servo spring parts, and intermediate band.

## **REAR LOW BAND SERVO**

1. Remove the inner spring and large return spring.
2. Install the new heavy duty spring provided. Check the seal on the servo piston for damage. Replace if needed.
3. Reinstall the rear servo.

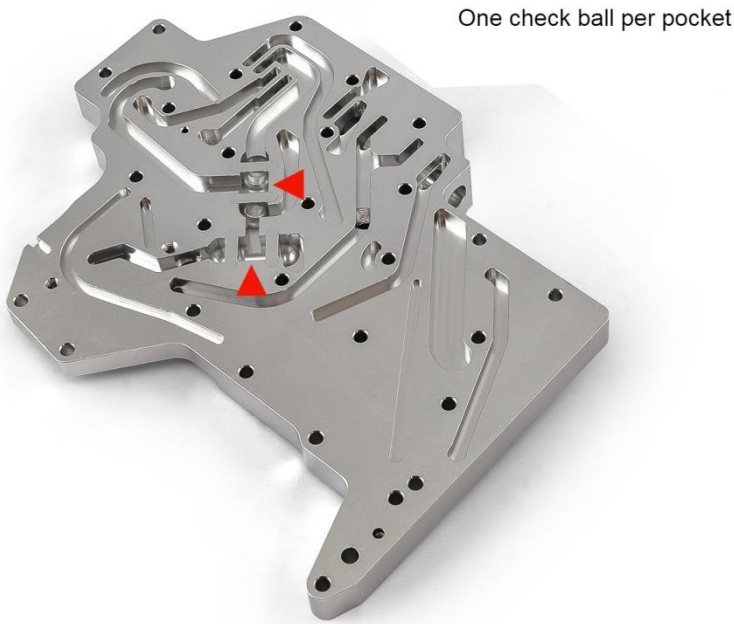


## **USE STOCK MANUAL VALVE**

In order to use the stock manual valve, please verify that the valve does not have any nicks and burrs. No prior modifications to the valve are allowed because of the tight clearance.

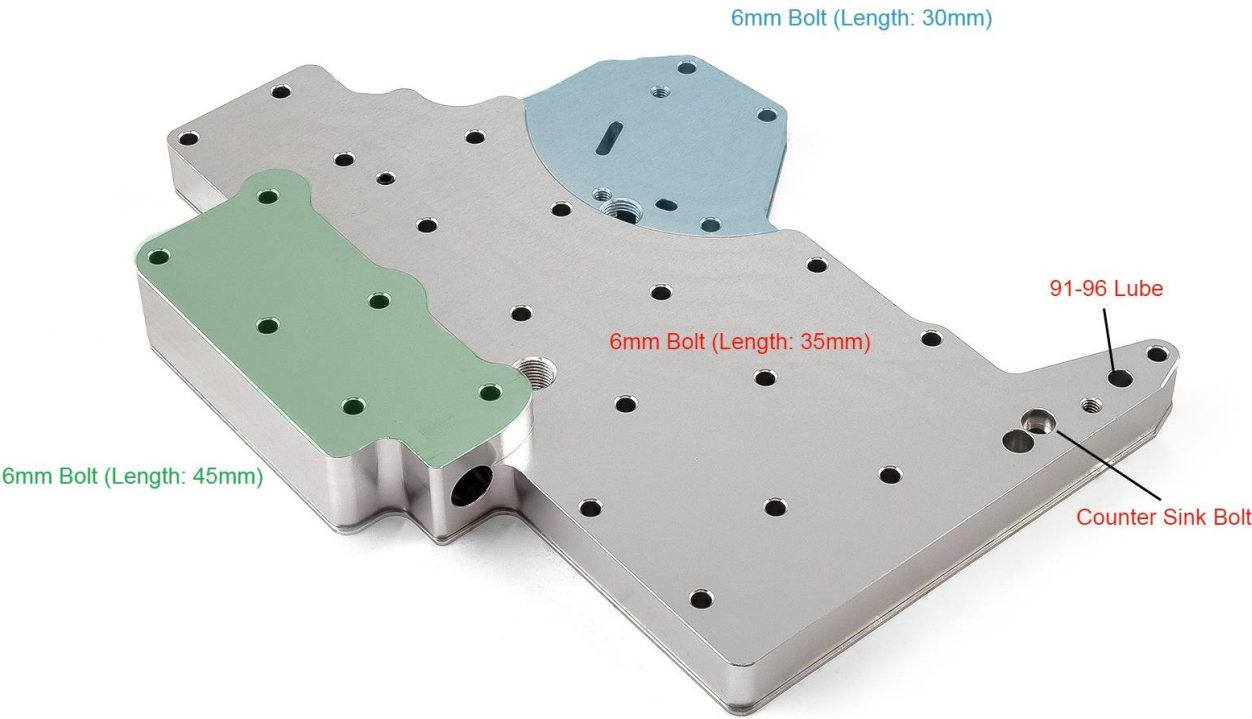
**VALVE BODY CHECK BALLS**

The 4L80 uses two Nylon check balls. Place the Nylon balls between the seats. See Figure below.



**VALVE BODY INSTALL**

The valve body is a direct bolt on. Install the factory manual valve in the new valve body. Place the separator plate between the case and valve body. Torque bolts to 100 in.-lbs.



## DIRECT DRUM

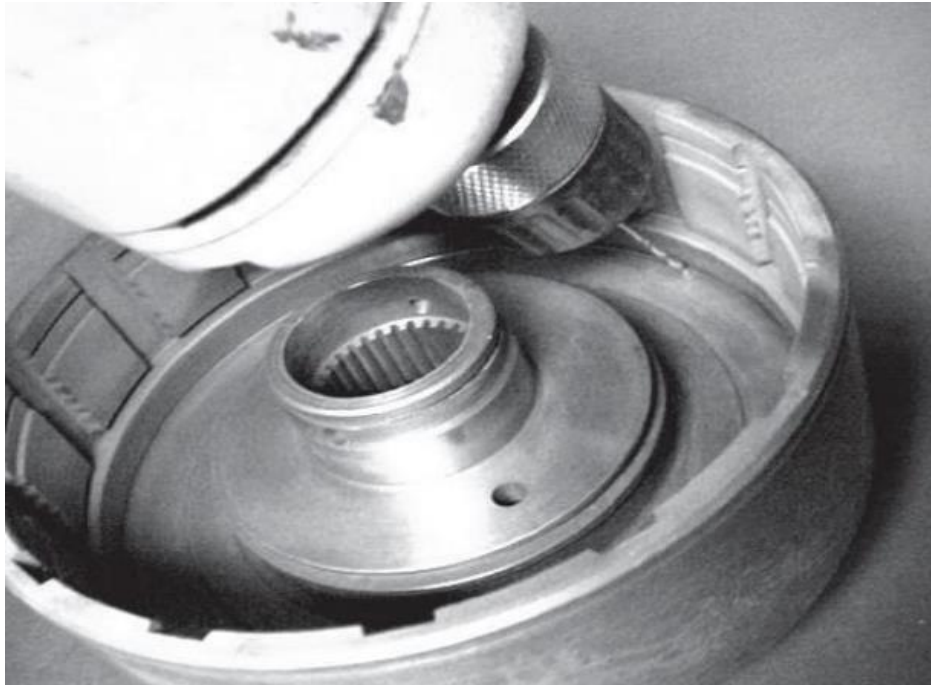
The removal of the piston is necessary. A bleed hole (0.040 in.-0.063 in.) is drilled through the drum, in the area behind the piston.

**NOTE:** It's best to drill the drum from the inside-out, placing the hole as close to the outer sealing portion of the drum. The drill may be held at an angle for more drilling clearance.

Reinstall piston in the drum using only two lip seals, the outer and the inner.

**NOTE:** Do not use the center seal on the drum.

Discard the 16 original piston springs and replace them with the springs provided with the kit.



## OPTIONAL

If the transmission is disassembled, it's preferred to have a center support with scarf cut rings. Leave out the second ring from the top.

## LUBE PIPE APPLICATIONS

**91-96 Lube Pipe:** Goes in the factory Location. Tube can be very tight. You can take a screwdriver on the step to seat tube in VB. The Tube will need to straighten at the bend where it attaches to the VB. Install the tube and you can then use the VB to straighten. Use factory hold down. The set screw provided for 97 up port is to be installed.

**97-Up Lube Pipe:** Goes in approximately factory location. The tube will need some bending but will install. Small modification to the bracket will be needed to hold pipe. When using the 97+ nothing needs to be done with the 91-96 port, leave it open.