



## Required Modification Instructions

1996+ GM 4L80E TransKit

Part Number 70227

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The B&M TransKit you have purchased contains all the parts necessary to convert your stock transmissions to the same basic specifications found in the famous B&M Transmission. This kit has been assembled with the assumption that all of the stock parts needed will be reusable. However, upon disassembly of transmission that has excessive mileage or has been abused, you may find that certain stock parts will have to be replaced. New parts may be purchased from your GM dealer although in many instances you may wish to purchase used parts from a wrecking yard or transmission repair shop. Before proceeding with the installation please read all of the B&M 4L80E Transpak Kit installation instructions so you will be familiar with the series of steps required to install part of this kit. ***It is recommended to purchase the ATSG 4L80E manual (Not provided by B&M) for detail rebuild guidance.*** The following modifications must be done before completing the B&M TransKit installation in order to prevent any issues from occurring.

### DUAL FEEDING FOR HEAVY DUTY AND HIGH PERFORMANCE:

**STEP 1.** On center support, remove 2nd from top sealing ring:



**STEP 2.** On Direct drum, remove center lip seal:

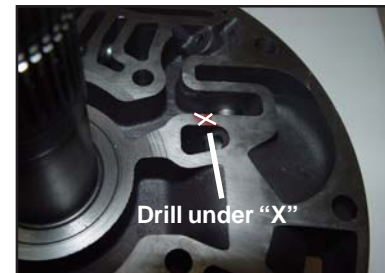


**STEP 3.** Plug top hole (reverse port):



### FOR HEAVY DUTY ONLY:

**STEP 1.** On pump, cross drill under "X" with a .050"-.055" drill bit in order to tie line and lube:



**NOTE:** Complement your B&M TransKit with some of the following products. Check the B&M website at [www.bmracing.com](http://www.bmracing.com) for various options:



**B&M Shift Plus 2  
Transmission Controller  
#120001**



**B&M Remote TPS  
(Must be used with #120001)  
#120002**



**B&M Drain Plug Kit  
#80250**



**Cast Aluminum Deep Pan  
(Adds 3 qt.)  
#70295  
For 4L80E 1993-1998**



**B&M Transmission Oil Cooler  
#70264 (SuperCooler)  
#70297 (Hi-Tek Cooler)**



**B&M Trick Shift TM  
#80259**

### **Technical Service**

A highly trained technical service department is maintained by B&M Racing and Performance to answer your technical questions, provide additional product information and offer various recommendations.

Technical service calls, correspondence, and warranty questions should be directed to the following address:

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