

TCI[®] 229900

INSTALLATION INSTRUCTIONS 4WD Conversion Kit

Now owners of GM 4WD vehicles originally equipped with a Turbo-Hydramatic 350 and owners of Toyota Land Cruisers equipped with a Chevrolet V-8 can easily move up to the more durable and dependable Turbo-Hydramatic 400 automatic transmission.

1. Remove all internal transmission parts.
2. Drive rear case bushing flush with inside of case. (FIG. 1) Replace bushing if worn.

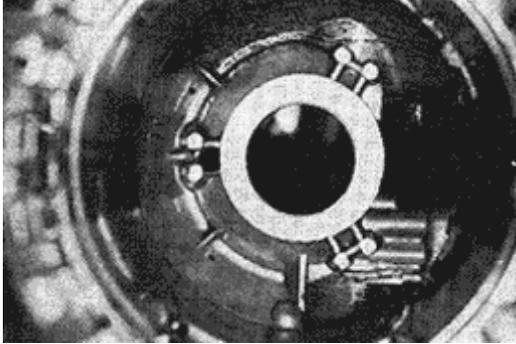


FIG. 1

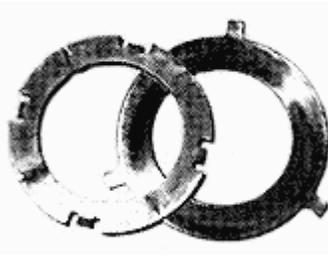


FIG. 2

3. Install modified output shaft in planetary carrier.
4. Replace rear spacer and thrust washer with Torrington bearing TCI[®] 224400.
5. Some output shafts are machined with a radius at the flange that will require grinding a bevel on the bearing race so that it will fit flush against the flange (FIG. 3). Failure to check fit can cause reduced rear unit endplay and premature bearing failure.

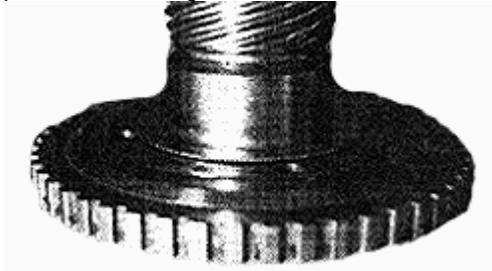


FIG. 3

6. After checking bushings, washers, and planet gears for wear, place the Torrington bearing against rear of case and assemble rear unit.
7. Check endplay (.005" to .020").
8. Check condition of clutches. If worn replace with HD waffle clutches found in TCI[®] 259000 overhaul kit. Also included in kit are special teflon sealing rings, pump bushing, gaskets, seals, and filter.
9. Assemble front unit and check endplay (.005" to .020").
10. Bolt adapter supplied in TCI[®] 229900 kit to rear of case.
11. Bolt transfer case mounting plate to transmission making sure that the six mounting bolts do not go all the way through the adapter plate. If the bolts go all the way through the adapter they could crack the adapter and/or transmission case.

Due to the added length of the Turbo 400 transmission and adapter plate, the supporting crossmembers will have to be relocated approximately 3.5 inches to the rear. The front driveshaft will have to be lengthened, the rear driveshaft will have to be shortened, and the transfer case shift lever hole will have to be elongated. The transfer case shift lever may have to be reversed in order to clear bench seats. Also, the transfer case shifter mounting bracket will have to have angles ground off in order to clear the adapter plate.