

Installation Instructions for 603108

Valve Body Kit

GM 200-4R

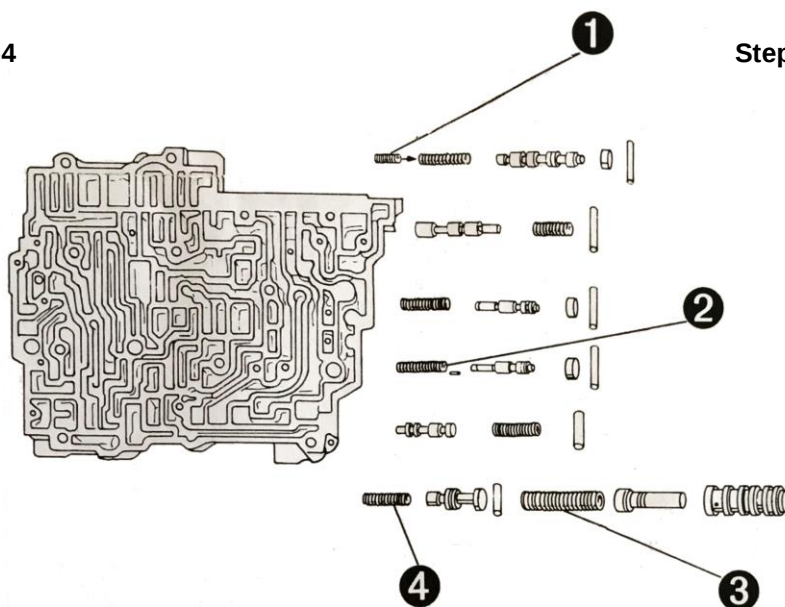
1. Install yellow spring supplied inside the existing line bias valve spring. Install both springs the into the valve body.
2. Replace the MTV down valve spring with the purple spring supplied.
3. Replace the throttle valve spring with the pink spring supplied.
4. Replace the throttle valve boost spring with the black spring supplied.
5. Replace the 1-2 accumulator spring with the red spring supplied.
6. Install case check balls as shown.
7. Since we cannot determine what shift feel will satisfy everyone, we recommend installing your first kit without drilling any feed holes. Enlarging holes will increase shift feel. Enlarge holes depending on the type vehicle and customer.

- Normal Duty (family or luxury vehicles) Do not drill plate.
- Heavy Duty and Towing. Drill the valve body plate as shown:

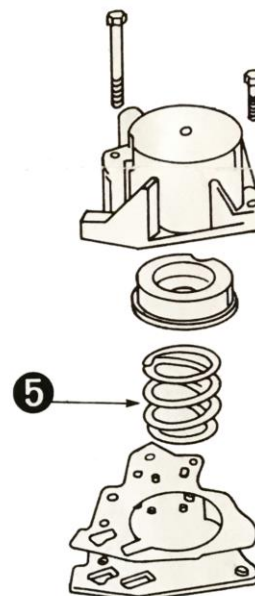
A...0.093...3/32" C...0.125...1/8"
B...0.093...3/32" D...0.093...3/32"

Note: For police or taxi, drill hole B to 1/8" (0.125).

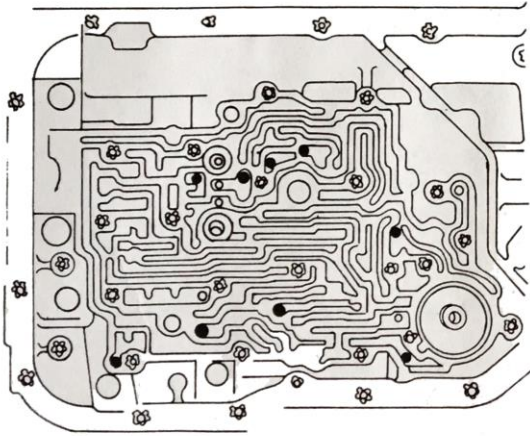
Steps 1-4



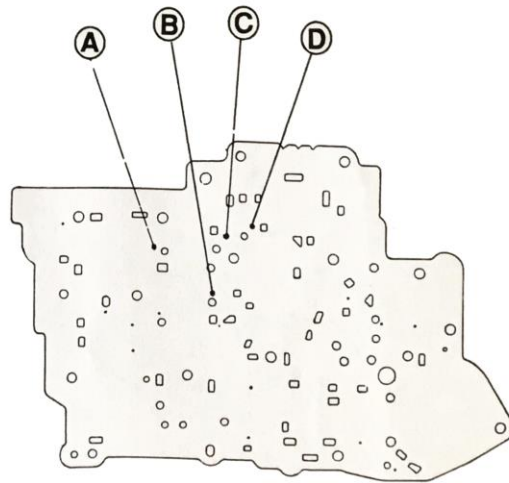
Step 5



Step 6



Step 7

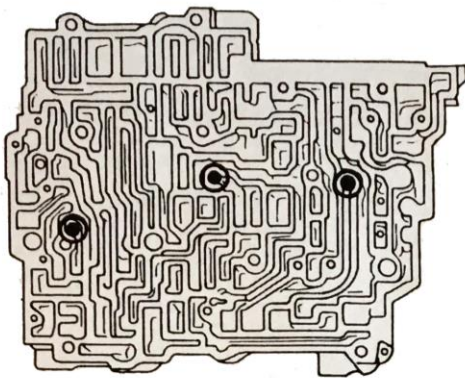


8. Install check balls in valve body as shown.

9. Replace servo cushion spring with the blue spring supplied.

10. Servo adjustment. **Note:** When using a band apply gauge, the travel on the dial indicator is reversed, causing the dial indicator to read backwards. On a dial indicator that ranges from 0-100, a .020" travel will read 0.080". A 0.060" travel will read 0.040".

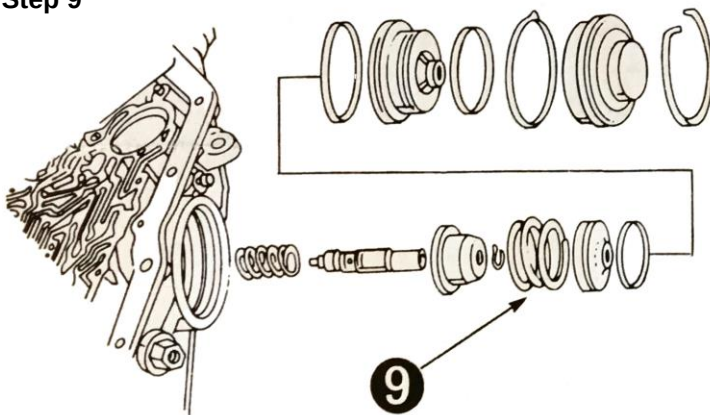
Step 8



11. Replace the pressure regulator spring with the light blue spring supplied.

12. If the front pump comes with double priming springs on the slide, leave alone. If the pump has a single priming spring, install the white spring provided inside the single spring. You should now have a dual priming spring set up.

Step 9

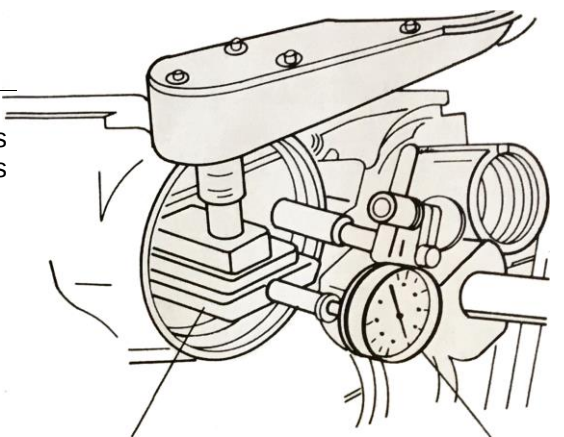


Servo Apply Pin Selection Chart (Step 10)

Dial Indicator Travel	
0.0 - 0.72 mm	(0.0" - 0.029")
0.72 - 1.44 mm	(0.029" - 0.057")
1.44 - 2.16 mm	(0.057" - 0.086")
2.16 - 2.88 mm	(0.088" - 0.114")

Apply Pin Identification

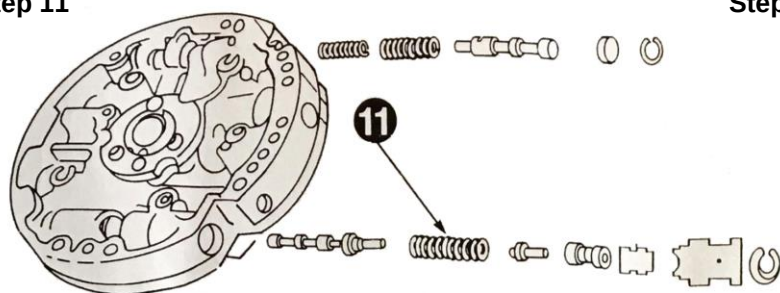
1 Groove
2 Grooves
3 Grooves
None



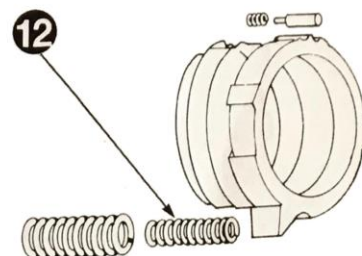
Intermediate band
apply pin gauge

Dial indicator

Step 11



Step 12



Recommendations

- A. Correct TV adjustment, see Figure A.
- B. Soak all friction materials at least 15 minutes prior to installation.
- C. Torque all pump bolts to 18 foot pounds.
- D. Drill the drainback hole in the pump to at least 1/4" to 5/16".
- E. Use unbreakable vane rings in the pump.
- F. Use only top quality bands and seals.

Wide Open Throttle

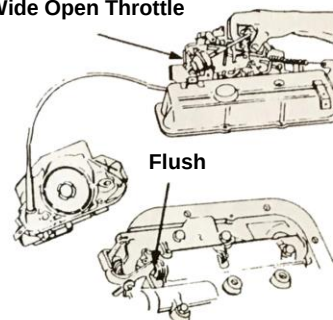


Figure A