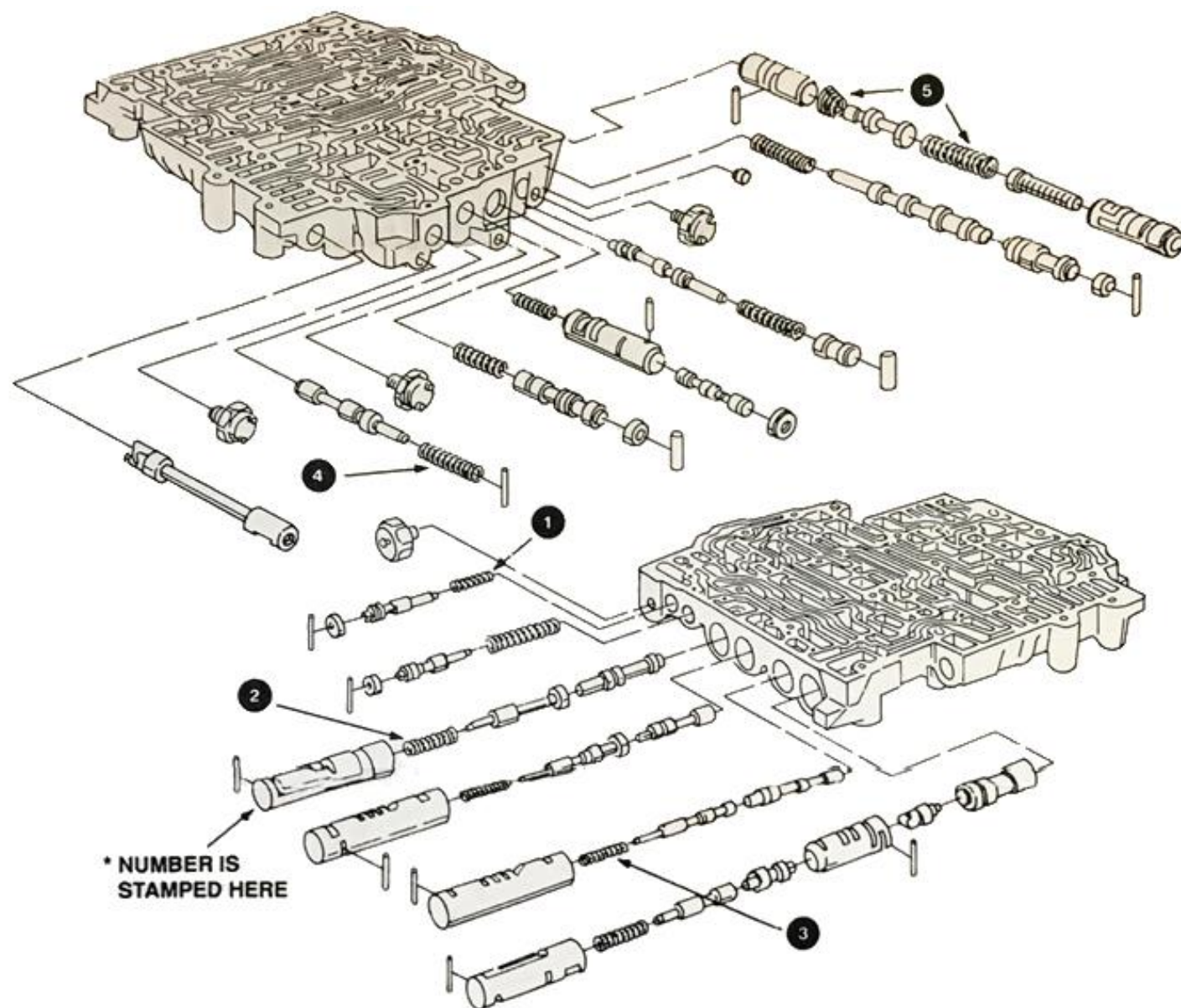


Installation Instructions for 603109

Valve Body Kit

1982-1993 GM TH700-4R/4L60

Except Electronic 4L60E



Steps 1-5

1. Replace MTV down valve spring with small red spring supplied.

2. This step is for Non-ECM vehicles only. Replace converter lock up valve springs as follows:

- With sleeves marked 1, 2 or 3 use the yellow spring supplied.
- With sleeves marked 4, 5 or 6 use the small black spring supplied.
- With sleeves marked O (zero), leave as is.

***NOTE:** The number is stamped on the sleeve facing out of the valve body.

3. Replace 2-3 shift valve spring with orange spring supplied. **NOTE:** 2.8 Blazers with a factory orange valve spring should be left as is.

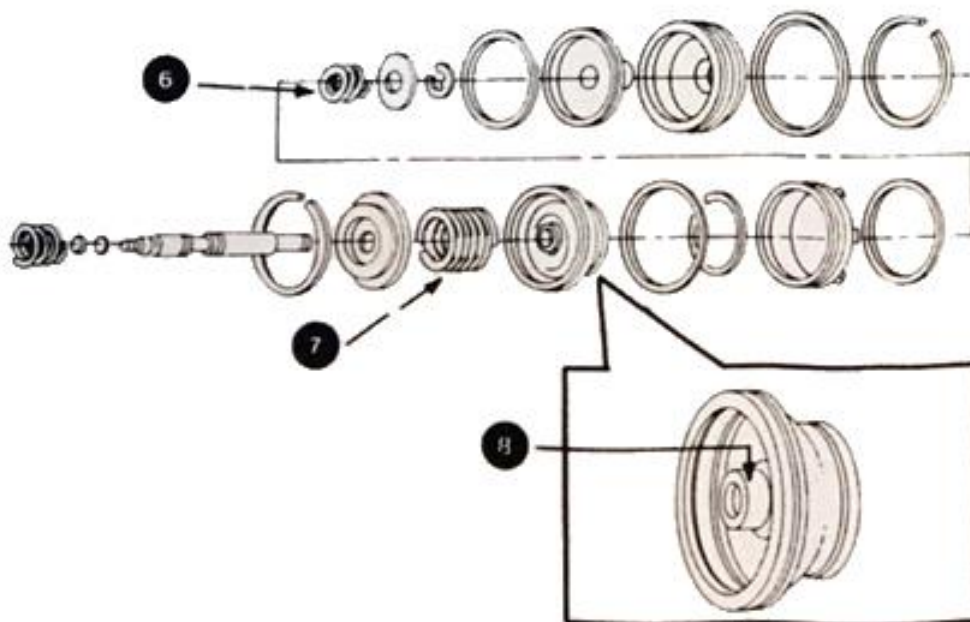
4. Replace spring on 3-2 line control valve using the small pink spring supplied. **NOTE:** If the pink spring supplied will not fit the 3-2 line control valve, reuse the O.E. spring.



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5. Replace Throttle Valve spring with the larger black spring supplied. Add small cone shaped white spring supplied in kit by putting the small end of spring on the valve stem, then installing into the throttle valve sleeve. **NOTE:** This spring is **not** in the valve body when disassembling. **Put it in all valve bodies.**

Steps 6-8



6. Replace Servo apply pin spring with light blue spring supplied.

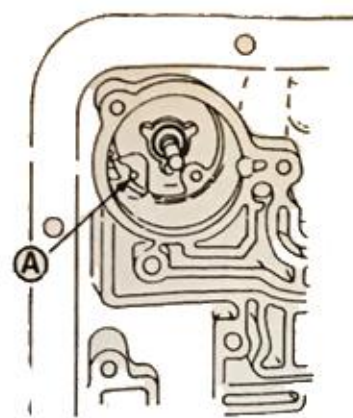
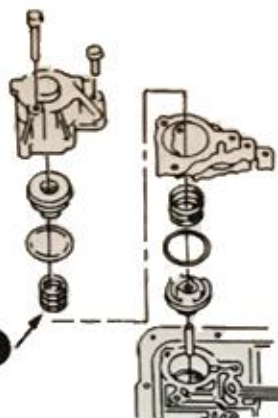
7. Replace Servo Cushion Spring with red spring supplied.

8. Grind 1/8 of an inch off the piston retainer set.

Steps 9-12

9. Replace Accumulator Spring With larger pink spring supplied. **NOTE: Police and HD factory units.** If the accumulator spring in the unit you are working on is larger than the Pink spring supplied in this kit, reuse the larger spring.

10. Install small orifice plug supplied into Hole A in the 3-4 Accumulator bore as Illustrated. Be sure to drive this plug flush. **NOTE:** This step gives you a definite 3-4 shift feel. (Not harsh.) We recommend installing this plug in your first transmission, using this kit, so you can feel the difference. This step can be skipped or plug drilled to 1/8" if a 3-4 shift feel is not desired.



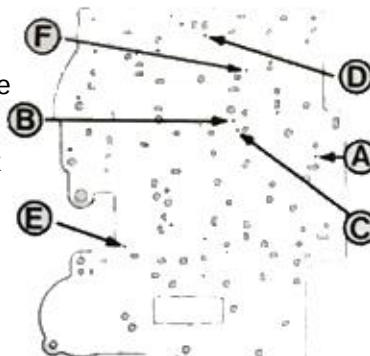
11. Drill valve body plate as shown.

Holes A, D and F, 3/32".

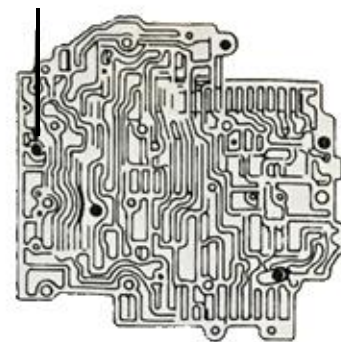
Holes B and E, 5/32". Hole C 1/8".

NOTE: Use your valve body gasket as a template & add Hole F drilling to 3/32".

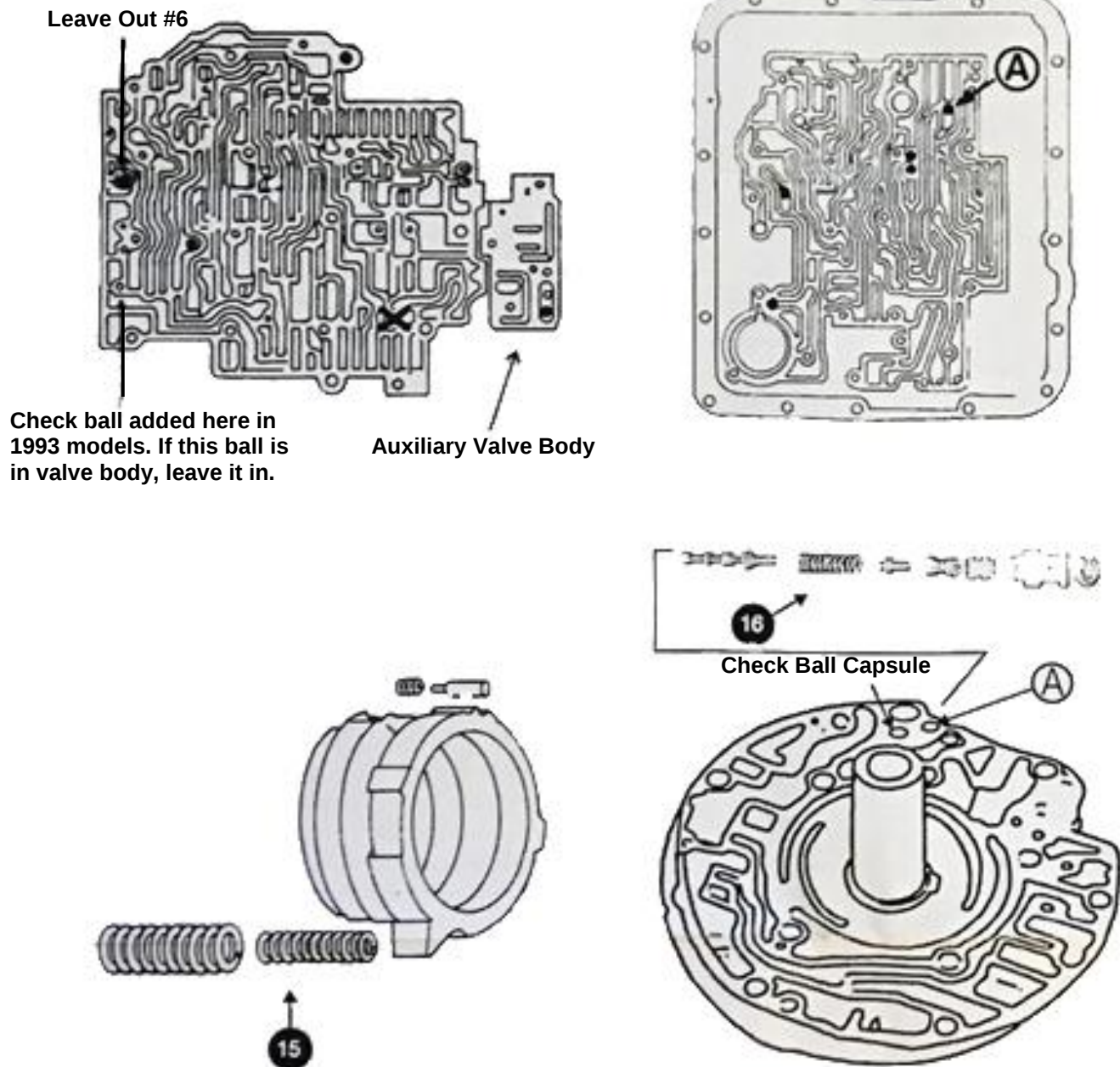
12. Models without Aux Valve body, install check balls in valve body as shown leaving #6 check ball out.



Leave out #6



Steps 13-17



13. Models with Aux Valve body, Install check balls in valve body as shown leaving #6 check ball out and being careful **not** to put one where the X is drawn. The X ball was moved with the addition of the Aux Valve body.

14. Install case check balls as shown. In 1988 models and up there is no check ball in Hole A.

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

16. Replace the spring on the Pressure Regulator Valve in the pump with the dark blue spring supplied.

17. Drive the solid cup plug provided flush into Hole A in the stator side of the pump. Hole A is located closest to the check ball capsule and goes through the pump on an angle. If your pump does not have a check ball capsule at this location it is not necessary to install the solid plug in Hole A. (Not necessary if transmission is not removed from vehicle.)

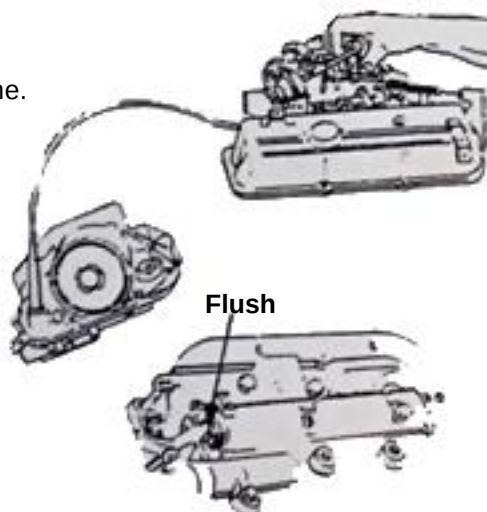
Step 18

18. Very Important: TV Cable Setting

After TV cable has been installed, open the throttle to the wide open position. The TV plunger should be flush with the TV bushing on the valve body. This will give you correct TV adjustment every time.

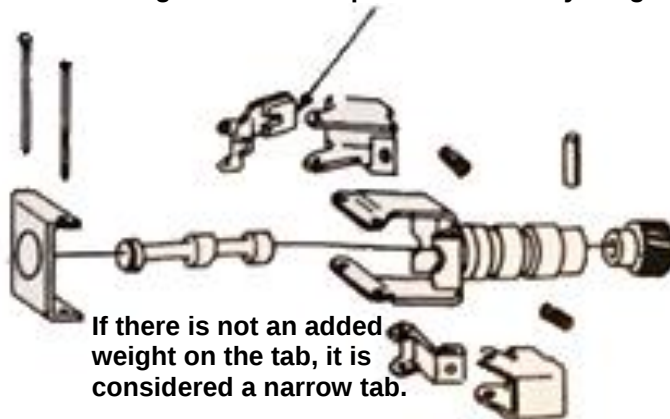
Recommendations:

1. Solid white sealing rings on input shaft.
2. Soaking of all friction materials at least 15 minutes prior to installation
3. Correct band adjustment of 1/16 to 1/8 inch pin travel.
4. Torqueing of all pump bolts to 18 foot pounds.
5. Unbreakable vane rings in the pump.
6. Use only top quality bands and seals.
7. Drilling of the drain back hole in the pump to be at least 1/4" to 5/16".



Helpful Information about Governors

Letter Designation is stamped on secondary weight.



Body	Engine	Springs	Weight I.D.
Y	Corvette 5.7L V8	red & vio/white	narrow tab
B	Police 5.7L V8	red & orange	narrow tab
F	Camaro IROC Firebird 5.7L V8	red & dark blue	narrow tab
B	Caprice 4.3L V6 5.0L V8	brown & pink	C
F	Camaro Firebird 5.0L V8	brown & pink	C
S-Truck M-vans	4.3L V6	brown & pink	C
Truck S C.K.V.	5.0L V8 5.7L V8	brown & pink	C
Vans RGM	5.0L V8 5.7L V8	brown & pink	C
S-Truck M-Van	2.5L 4 Cyl. 2.8L V6	brown & pink	No Letter
Truck C.K.V.	6.2L Diesel	red & orange	D
Vans RGM	6.2L Diesel	red & orange	D
F	Camaro Firebird 2.8L V6	brown & green	E