



## INSTALLATION INSTRUCTION FOR TURBO 400 MANUAL VALVE BODY-PRN123 (#22010)

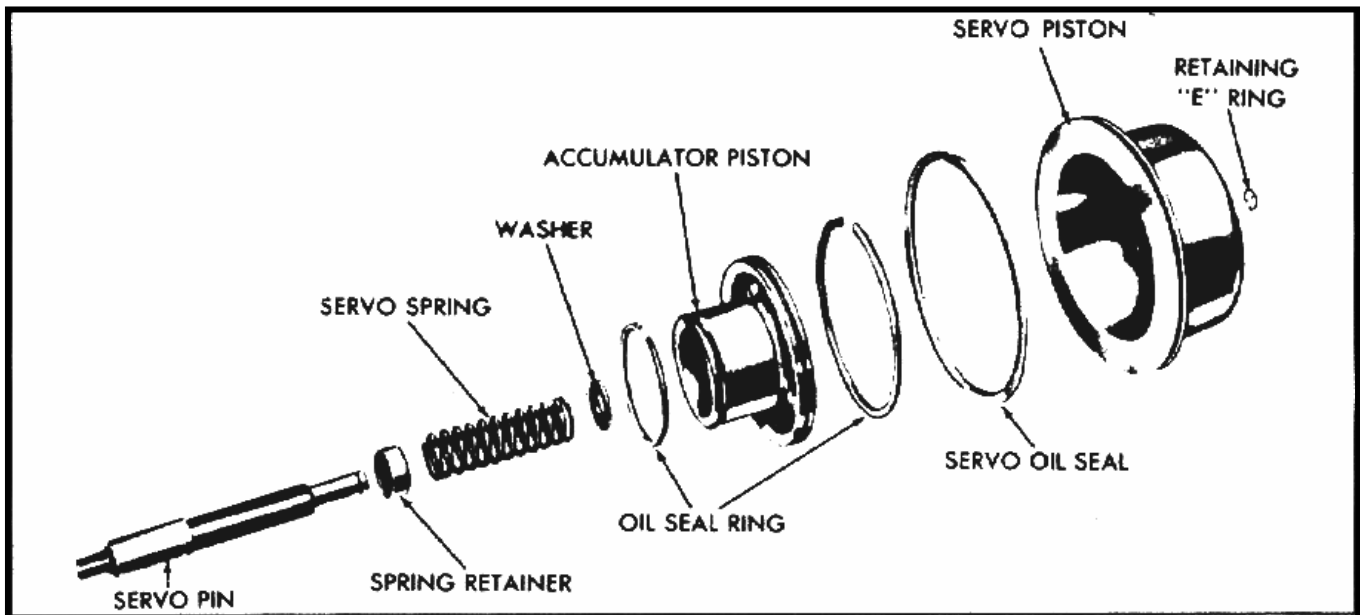
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**\* COMMITMENT \* PERFORMANCE \* RELIABILITY \***  
**\* A WINNING COMBINATION \***

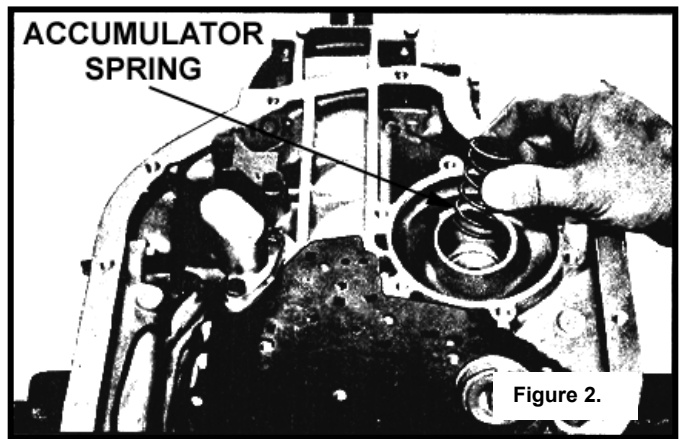
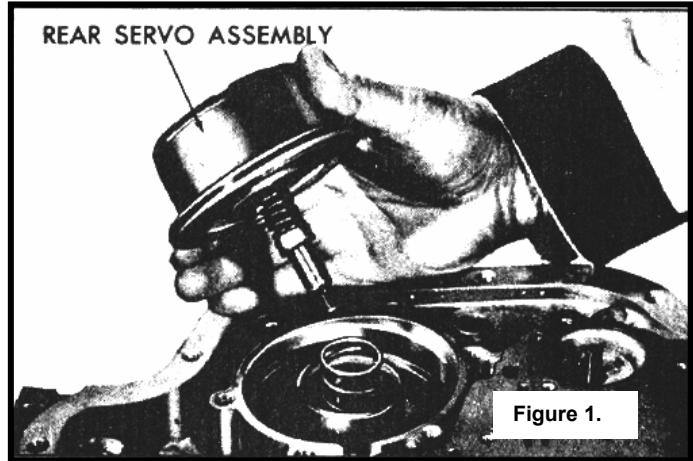
The scope of these instructions will be aimed at the installation of this kit and it is assumed that the transmission will be rebuilt properly to work with this valve body. If necessary refer to a transmission manual for detailed instructions on disassembly and reassembly of the Turbo Hydra-Matic 400 transmission.

*\*NOTE: Valve body is full manual with reversed shift pattern-PRN123.*

**Caution: DO NOT neutral or downshift transmission during shutdown – Leave in high gear only!**



1. Remove valve body, separator plate and gaskets. Discard all check balls.
2. Remove rear servo assembly (Figure 1.) Remove and discard oil-sealing rings from accumulator piston, remove and discard stock accumulator spring (Figure 2.) Install new accumulator spring furnished in kit and replace servo assembly and cover.
3. Install the new valve body and separator plate with gaskets, making sure the manual selector valve is properly aligned with the linkage pin. Tighten 1/4" valve body bolts to 72 in-lbs and 5/16" valve body bolts to 120 in-lbs. Governor tubes can be omitted, unless using old style long filter, in which case one tube can be replaced as a filter support.
4. Remove and discard modulator, replace with plug furnished.
5. Remove and discard governor.
6. If transmission has been disassembled, you may remove and discard front band. Install drum and reassemble transmission.



- **\*NOTE:** Cooler fittings should never be plugged. If a cooler is not used, connect the lines together with a loop.

#### TH400 Manual Valve Body Kit Components

Valve body  
 Separator plate  
 Gaskets  
 Special manual valve  
 Modulator plug w/o-ring  
 Rear accumulator spring

If you have any questions regarding the proper installation and/or operation of a Coan Racing product, please call (765) 456-3957. You may also fax us at (765) 456-3960, or e-mail at [coan@coanracing.com](mailto:coan@coanracing.com).

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