

### **INSTALLATION INSTRUCTIONS FOR CHRYSLER 727 AND 904** **PRO BRAKE PART #42023**

#### **Special Tools Required:**

11/32" Drill Bit  
1/16" Drill Bit  
1/8" NPN Tap

#### **Parts Required:**

#3.8 or #4.2 (preferred) Intermediate Band Lever  
Four Clutch Drum  
Bolt -In Sprag Assembly

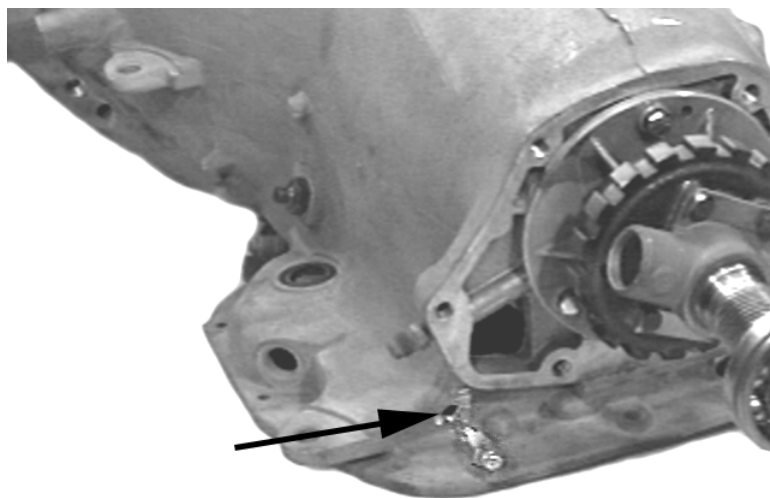
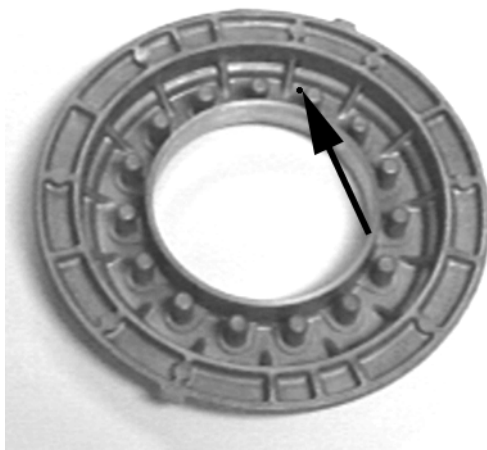
Your Chrysler 727 / 904 Pro Brake valvebody is designed to have a reverse lockout safety feature. To engage reverse, the shifter must be placed in reverse and the Trans brake switch must be depressed simultaneously.

#### **Install a good bolt-in sprag!**

If necessary, refer to a transmission manual for detailed instructions on disassembly and reassembly.

The transmission should be completely disassembled, and thoroughly cleaned.

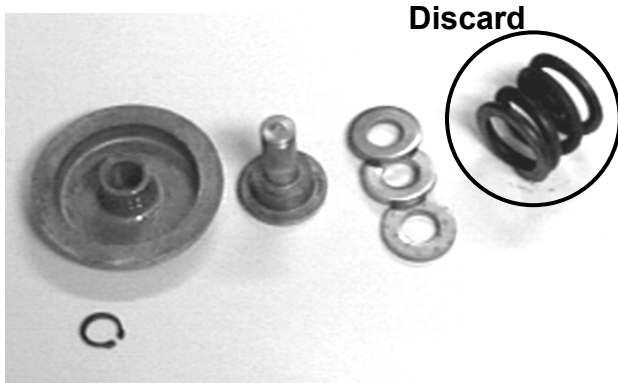
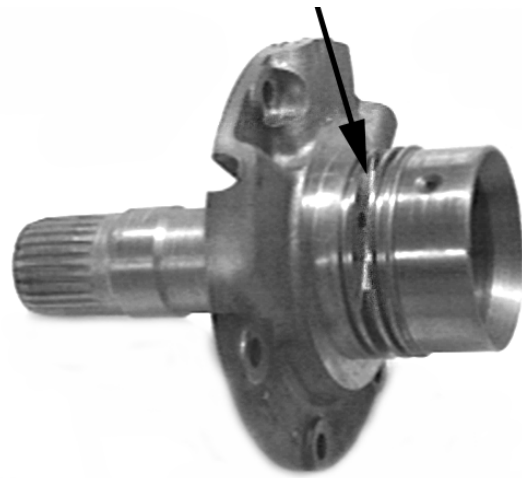
After disassembly, drill hole in case with 11/32" drill bit and then tap with 1/8" NPT TAP, then install electrical connector.



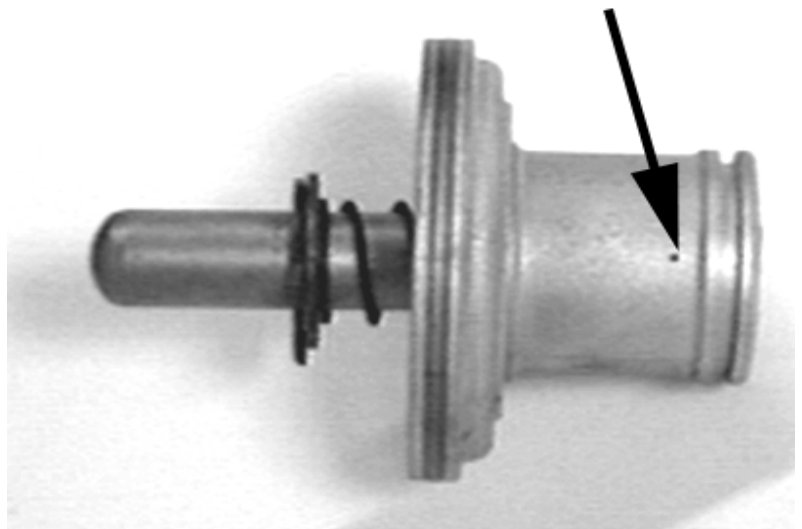
Use a 1971 and up, 4 clutch, Front Clutch Pack Drum with wide bushing (recommended). It must match the front pump support bushing area. Drill a 1/16" bleed inside the piston next to the 90-degree sealing edge between spring towers. Use a 15-spring piston; install all 15 of the 1.4 late model springs.

Set the high clutch pack clearance to .060"-.080".  
Set the Fwd. clutch pack to .030"-.040".

Take the front pump support and cut or mill opening at hole, between sealing rings that feed the drum, down to the intersecting hole. Be careful not to damage the ring landing supports.



Remove spring from rear servo piston and install 3 to 4 washers to take up space.



Find bleed hole located between sealing rings on kickdown servo piston (71' and up only). Drill and Tap for set screw to plug hole. Make sure it is flush.

Intermediate band Adjustment; flex or hard back, tighten to 75 inch lbs. then back off 1 3/4 turns on new band or 2 turns on used band.

Rear band; tighten to 75 inch lbs. then back off 1 1/2 turns on new band or 1 3/4 turns on used band.

Filter: Use screen type only, 2 screws hold it in place.

Install valve body and connect the wire to the plug. Be sure the wire does not interfere with linkage or drums.

Use 16 gauge or larger with 25 amp fuse. Solenoid draws a maximum of 7 amps.

Solenoid works off of pressure, no "clicking" will be heard.

Line pressure 135 to 145 lb. for 727, 155 to 165 lb. for 904  
Adjust by turning the 3/16" allen counter clockwise to increase. One turn = 10 pounds

**FOR TECHNICAL QUESTIONS, PLEASE FEEL FREE TO CALL (765) 456-3957**