

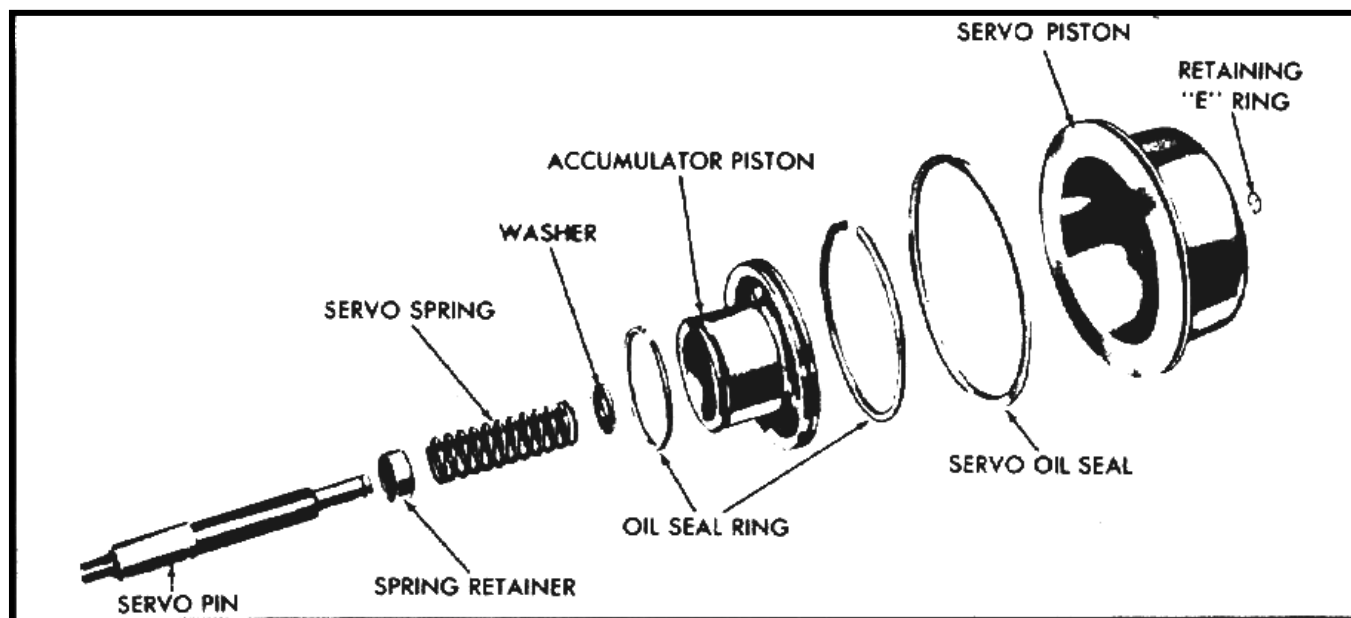
INSTALLATION INSTRUCTION FOR TURBO 400 BILLET MANUAL VALVE BODY, REVERSED PATTERN CLEAN "N" (#22015-AL)

Thank you for purchasing a Coan Racing performance product. Since 1976, Coan Engineering has been the leader in hi-performance race transmissions and converters. Our ongoing research and development assures that you have purchased the best products available.

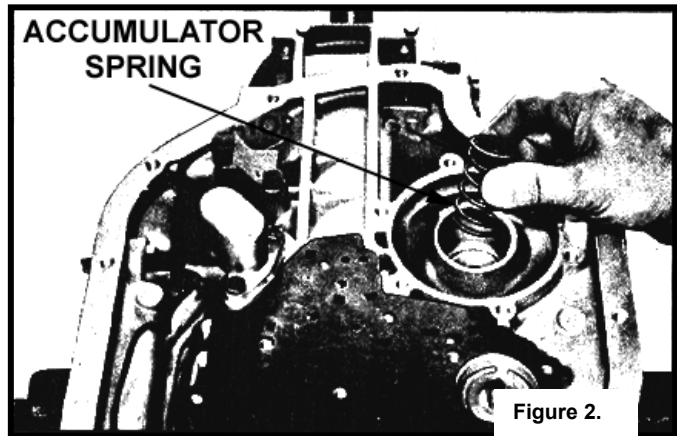
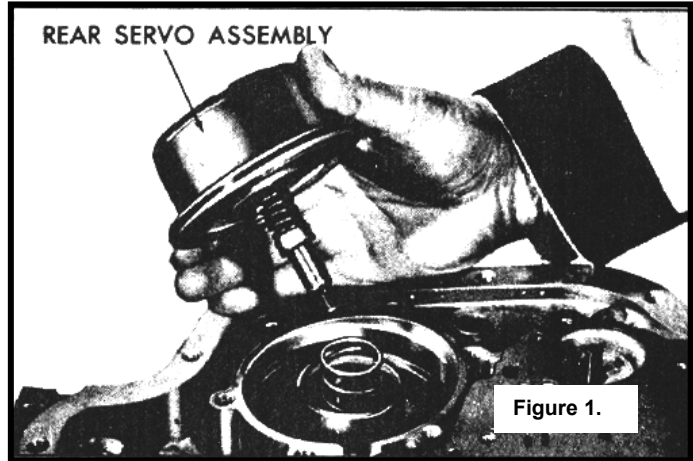
*** COMMITMENT * PERFORMANCE * RELIABILITY ***
*** A WINNING COMBINATION ***

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 including a clean neutral position for safe shutdown (P-R-1-2-3-N). This valve body requires a special shifter such as a Precision Performance Products 408 or 458.*



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 $\frac{1}{4}$ " valve body bolts to 72 in-lbs and $\frac{5}{16}$ " 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, leaving stock modulator valve in the case.
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.

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Coan Engineering offers a limited warranty covering all new products for ninety days and all repair service for thirty days from the original date of purchase to be free from flaws in material and craftsmanship. The warranty is non-transferable. Under no circumstances will Coan Engineering extend its warranty to products, new or repaired, which have been abused, misused, or incorrectly installed. Disassembly of any product by means other than a Coan Engineering technician will void any potential warranty. All

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