

TURBO HYDRA-MATIC 400 AUTOMATIC TRANSMISSION

ALL SERIES WITH 455 CU.IN. ENGINE

CONTENTS

Subject	Page No.
DESCRIPTION AND OPERATION:	
Description	7D-102
DIAGNOSIS:	
Sequence for Turbo Hydra-Matic 400 Transmission	
Diagnosis	7D-104
Turbo Hydra-Matic 400 Transmission Oil	
Checking Procedures	7D-104
External Oil Leaks	7D-105
Vacuum Modulator Diagnosis	7D-106
Turbo Hydra-Matic 400 Transmission Oil	
Pressure Checks	7D-107
Transmission Control Spark Switch Checking	
Procedures	7D-108
Turbo Hydra-Matic 400 Transmission Trouble	
Diagnosis Chart	7D-109
MAINTENANCE AND ADJUSTMENTS:	
Detent Switch Replacement and Adjustment	7D-120
Removal of Converter and Vacuum Modulator	7D-121
Removal of Governor, Speedometer Driven	
Gear, Oil Pan and Filter	7D-121
Installation of Oil Filter	7D-122
Installation of Modulator Valve and Vacuum	
Modulator	7D-123
Installation of Governor Assembly	7D-123
Transmission Assembly Removal and Installation ..	7D-125
MAJOR REPAIR:	
Removal of Pressure Switch Assembly, Valve Body	
Assembly, Governor Pipes and Detent Spring	
Assembly	7D-128
Removal of Rear Servo, Solenoid, Connector,	
Valve Body Spacer Plate, Gasket, Front Servo,	
Manual Detent and Park Linkage	7D-129
Removal of Rear Oil Seal and Extension Housing ..	7D-132
Removal of Oil Pump, Forward Clutch,	
Direct Clutch,	
Intermediate Clutch and Gear Unit Assembly	7D-132
Gear Unit Assembly	7D-135
Governor Assembly	7D-145

Front Servo Inspection	7D-147
Rear Servo Assembly	7D-148
Valve Body Assembly	7D-149
Oil Pump Assembly	7D-152
Forward Clutch Assembly	7D-156
Direct Clutch and Intermediate Roller Clutch	7D-160
Center Support and Intermediate Clutch	7D-165
Inspection of Transmission Parts	7D-169
Assembly of Major Units	7D-171
Rear Extension Housing	7D-177
Installation of Manual Linkage	7D-177
Installation of Check Balls, Front Servo, Gaskets, Spacer Plate and Solenoid	7D-178
Installation of Rear Servo Assembly	7D-179
Installation of Valve Body Assembly and Governor Pipes	7D-180
Installation of Speedometer Driven Gear Assembly and Converter Assembly	7D-182
Installation of Governor Bushing	7D-182
SPECIFICATIONS:	
General Specifications	7D-184
Bolt Torque Specifications	7D-184

DESCRIPTION AND OPERATION

DESCRIPTION

The Turbo Hydra-matic 400 Automatic Transmission, see Figure 7D-1, is a fully automatic unit consisting primarily of a 3-element hydraulic torque converter and a compound planetary gear set. Three multiple-disc clutches, two (2) one way roller clutches and two bands provide the friction elements required to obtain the desired function of the compound planetary gear set.

The 3-element torque converter consists of a pump, turbine and a stator assembly. The stator is mounted on a one way roller clutch which will allow the stator to turn clockwise but not counterclockwise.

The torque converter housing is filled with oil and is attached to the engine crankshaft by a flywheel, thus always rotates at engine speed. The converter pump is an integral part of the converter housing, therefore the pump blades, rotating at engine speed set the oil within the converter into motion and direct it to the turbine, causing the turbine to rotate.

As the oil passes through the turbine it is traveling in such a direction that if it were not *redirected* by the stator it would hit the rear of the converter pump blades and impede its pumping action. So at low

turbine speeds, the oil is redirected by the stator to the converter pump in such a manner that it actually assists the converter pump to deliver power, or multiply engine torque.

As turbine speed increases, the direction of the oil leaving the turbine changes and flows against the rear side of the stator vanes in a clockwise direction. Since the stator is now impeding the smooth flow of oil, its roller clutch releases and it revolves freely on its shaft. Once the stator becomes inactive, there is no further multiplication of engine torque within the converter. At this point, the converter is merely acting as a fluid coupling as both the converter pump and turbine are being driven at approximately the same speed - or at a one-to-one ratio.

A hydraulic system, pressurized by a gear type pump, provides the working pressure required to operate the friction elements and automatic controls.

External control connections to transmission are:

Manual Linkage - To select the desired operating range.

Engine Vacuum - To operate a vacuum modulator unit.

12 Volt Electrical Signal - To operate an electrical detent solenoid.

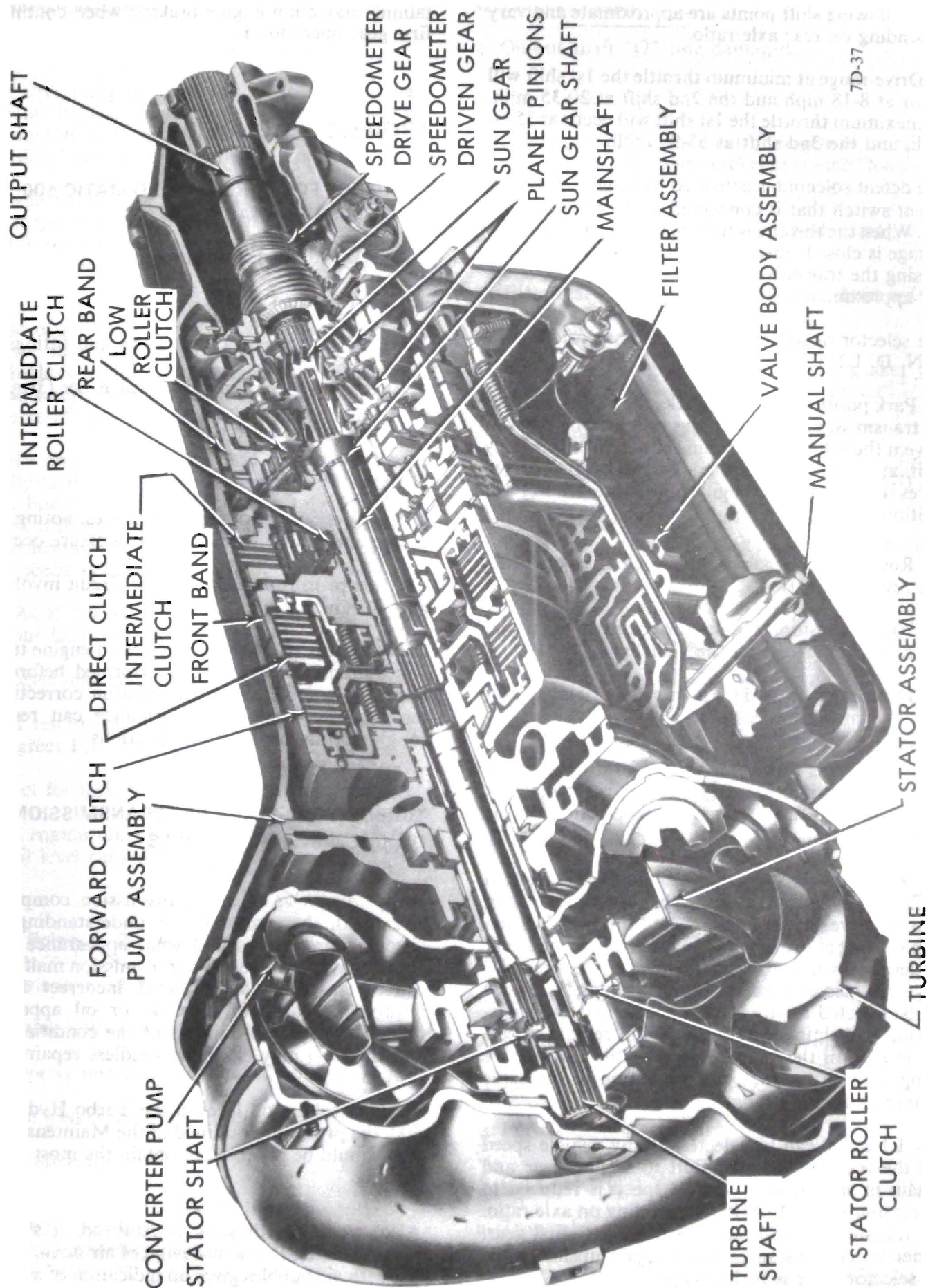


Figure 7D-1 - Cross Section of Transmission (Typical)

The following shift points are approximate and vary depending on rear axle ratio.

In Drive-range at minimum throttle the 1st shift will occur at 8-18 mph and the 2nd shift at 20-35 mph. At maximum throttle the 1st shift will occur at 35-60 mph, and the 2nd shift at 65-90 mph.

The detent solenoid is activated by a signal from the detent switch that is connected to the throttle linkage. When the throttle is fully open, the switch on the linkage is closed, energizing the detent solenoid and causing the transmission to downshift at speeds below approximately 70 MPH.

The selector quadrant has six selector positions: P, R, N, D, L2, L1.

P. - Park position positively locks the output shaft to the transmission case by means of a locking pawl to prevent the vehicle from rolling either direction. This position should be selected whenever the driver leaves the vehicle. The engine may be started in Park position.

R. - Reverse range enables the vehicle to be operated in a reverse direction.

N. - Neutral position enables the engine to be started and run without driving the vehicle.

D. - Drive range is used for all normal driving conditions and maximum economy.

Drive range has three gear ratios, from the starting ratio to direct drive. Detent downshift is available for safe passing by depressing the accelerator to the floor.

L2 - L2 range adds new performance for congested traffic or hilly terrain. L2 range has the same starting ratio as drive range, but prevents the transmission from shifting above second gear to retain second gear acceleration when extra performance is desired. L2 range can also be used for engine braking. L2 range can be selected at any vehicle speed, and the transmission will shift to second gear and remain in second gear until the vehicle speed or the throttle are changed to obtain first gear operation in the same manner as in drive range.

L1 - L1 range can be selected at any vehicle speed and the transmission will shift to second gear and remain in second until vehicle speed is reduced to approximately 30-40 MPH, depending on axle ratio. The transmission will then downshift into first gear. Under no circumstances will it again upshift while the selector lever is in L1 range.

L1 range prevents the transmission from shifting out of first gear. This is particularly beneficial for main-

taining maximum engine braking when continuous first gear operation is desirable.

TROUBLE DIAGNOSIS

SEQUENCE FOR TURBO HYDRO-MATIC 400 TRANSMISSION DIAGNOSIS

1. Check and correct oil level.
2. Check detent switch.
3. Check and correct vacuum line and fittings.
4. Check and correct manual linkage. See Group 73.
5. Install oil pressure gage.
6. Road test car.
 - a. Road test using all selective ranges, noting when discrepancies in operation or oil pressure occur.
 - b. Attempt to isolate the unit or circuit involved in the malfunction.
 - c. If engine performance indicates an engine tune up is required, this should be performed before road testing is completed or transmission correction attempted. Poor engine performance can result in rough shifting or other malfunctions.

TURBO HYDRA-MATIC 400 TRANSMISSION OIL CHECKING PROCEDURES

Before diagnosis of any transmission complaint is attempted, there must be an understanding of oil checking procedures and what appearance the oil should have. Many times a transmission malfunction can be traced to low oil level, incorrect dipstick, improper reading of dipstick, or oil appearance; therefore, a careful analysis of the condition of oil and the level may eliminate needless repairs.

When checking oil level in the Turbo Hydra-matic 400, the procedure outlined in the Maintenance Section should be observed to obtain the most accurate reading.

Also, when the dipstick is removed, it should be noted whether the oil is devoid of air bubbles or not. Oil with air bubbles gives an indication of an air leak in the suction lines, which can cause erratic operation and slippage. Water in the oil imparts a milky, pink cast to the oil and can cause slipping.

EXTERNAL OIL LEAKS

Determining Source of Oil Leak

Before attempting to correct an oil leak, the actual source of the leak must be determined. In many cases, the source of the leak can be deceiving due to "wind flow" around the engine and transmission.

The suspected area should be wiped clean of all oil before inspecting for the source of the leak. Red dye is used in the transmission oil at the assembly plant and will indicate if the oil leak is from the transmission.

The use of a "Black Light" to locate the point at which the oil is leaking is helpful. Comparing the oil from the leak to that on the engine or transmission dipstick, when viewed by black light, will determine the source of the leak - engine or transmission.

Oil leaks around the engine and transmission are generally carried toward the rear of the car by the air stream. For example, a transmission oil fill pipe to case leak will sometimes appear as a leak at the rear of the transmission. In determining the source of a leak, proceed as follows:

A "BLACK LIGHT" testing unit can be obtained from your local service tool supplier.

1. Degrease underside of transmission.
2. Road test to get unit at operating temperature. (180 degrees F.)
3. Inspect for leak with engine running.
4. With engine off, check for oil leaks due to the raised oil level caused by drain back.

Possible Points of Oil Leaks

1. Transmission Oil Pan Leak

- a. Attaching bolts not correctly torqued.
- b. Improperly installed or damaged pan gasket.
- c. Oil pan gasket mounting face not flat.

2. Case Extension

- a. Attaching bolts not correctly torqued.
- b. Rear seal assembly damaged or improperly installed.
- c. Extension to case, gasket damage or improperly installed.

d. Porous casting.

e. Output shaft "O" ring damaged.

3. Case Leak

- a. Filler pipe "O" ring seal damaged or missing; misposition of filler pipe bracket to engine "loading" one side of "O" ring.
- b. Modulator assembly "O" ring seal damaged or improperly installed.
- c. Electrical connector "O" ring seal damaged or improperly installed.
- d. Governor cover bolts not torqued, gasket damaged or leak between case face and gasket.
- e. Speedometer gear "O" ring damaged.
- f. Manual shaft lip seal damaged or improperly installed.
- g. Parking pawl shaft cup plug damaged, improperly installed.
- h. Line pressure band release tap plug loose.
- i. Vent pipe.
- j. Porous casting.

4. Leak at Front of Transmission

- a. Front pump seal leaks.
 - (1) Seal lip cut. Check converter hub for nicks, etc.
 - (2) Bushing moved forward and damaged.
 - (3) Garter spring missing from seal.
- b. Front pump attaching bolts loose or bolt seals damaged or missing.
- c. Front pump housing "O" ring damaged or cut.
- d. Converter leak in weld area.
- e. Porous casting (pump).

5. Oil Comes Out Vent Pipe

- a. Transmission over-filled.
- b. Water in oil.
- c. Foreign matter between pump and case or between pump cover and body.

- d. Case - porous, front pump cover mounting face shy of stock near breather.
- e. Pump to case gasket mispositioned.
- f. Incorrect dipstick.
- g. Cut "O" ring or grommet on filter.
- h. Pump - shy of stock on mounting faces, porous casting, breather hole plugged in pump cover.

Case Porosity Repair

Turbo Hydra-Matic 400 transmission leaks caused by case porosity have successfully been repaired with the transmission in the car by using the following recommended procedures:

1. Road test and bring the transmission to operating temperature, approximately 180 degrees.
2. Raise car on a hoist or jack stand, engine running and locate source of oil leak. See subparagraph B.

Use of a mirror is helpful in finding leaks.

3. Shut engine off and thoroughly clean area to be repaired with a cleaning solvent and a brush (air dry).
4. Using instructions of the manufacturer, mix a sufficient amount of epoxy, Group 0.423, Part No. 1360016, or equivalent to make repair.

Observe cautions of mfg. in handling.

5. While the transmission case is still HOT, apply the epoxy to the area to be repaired. A clean, dry soldering acid brush can be used to clean the area and also to apply the epoxy cement.

Make certain the area to be repaired is fully covered.

6. Allow cement to cure for *three hours* before starting engine.
7. Road test and check for leaks.

VACUUM MODULATOR DIAGNOSIS

The vacuum modulator, see Figure 7D-2, has three areas to be checked. If any one of the three (3) areas fail to pass the prescribed checks, the modulator must be replaced.

1. Bellows Comparison Check

Using a comparison gage, J24466, compare the load of a known good modulator *of the same part number*

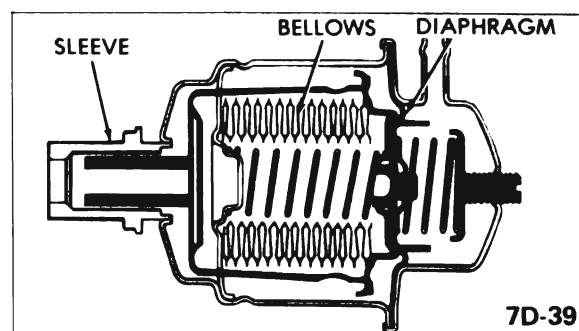
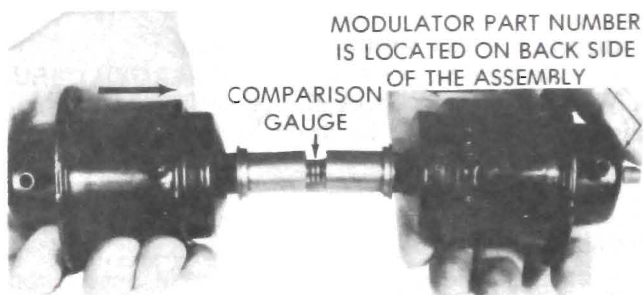


Figure 7D-2 - Vacuum Modulator Assembly

with the modulator in question. Refer to modulator usage chart in back of this section.

To check bellows load proceed as follows:

- a. Insert one end of the comparison gage into the suspected modulator sleeve. Insert the opposite end of the gage into a known good modulator of the same part number as the suspected modulator. The part number of the modulator assembly is located on the back side of the modulator.
- b. Holding the modulators in a horizontal position, see Figure 7D-3, bring them slowly together under pressure. The modulator bellows in question, if bad, will reach the center line of the comparison gage before the known good modulator lines up with the outer gage line. See Figure 7D-4.



HOLD MODULATORS IN A HORIZONTAL POSITION, AS SHOWN, BRING THEM SLOWLY TOGETHER UNDER PRESSURE. 7D-40

Figure 7D-3 - Holding Modulators in Horizontal Position

If the modulator bellows in question is good, both modulator assemblies will be within the outer gage lines as the assemblies are slowly brought together. See Figure 7D-5.

2. Vacuum Diaphragm Leak Check

Turn modulator so vacuum line stem points downward. If transmission oil comes out, the vacuum dia-

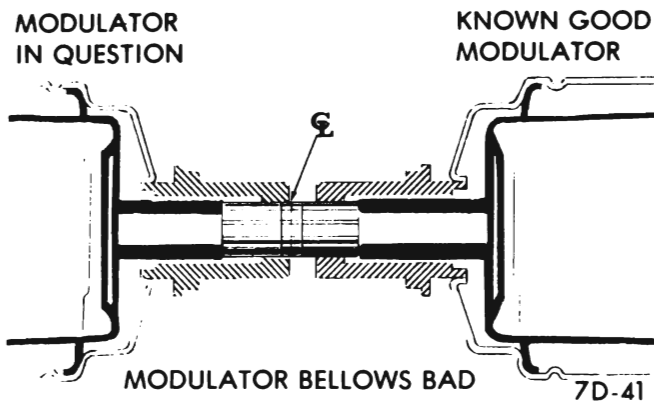


Figure 7D-4 - Modulator Bellows (Bad)

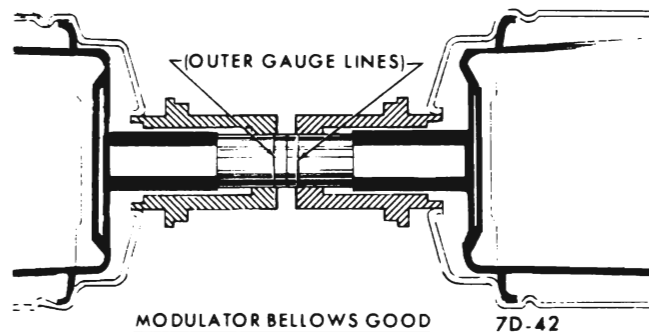


Figure 7D-5 - Modulator Bellows (Good)

phragm is bad. Gasoline and/or water vapor may settle in the vacuum side of the modulator. If this is found **WITHOUT** the presence of oil, the modulator **MUST NOT BE CHANGED**.

Check solution that comes out of the modulator for evidence of lubricity. If the solution does not have the feel of oiliness it can be assumed the solution is a mixture of gas and/or water. The only way transmission oil can be on the vacuum side of the modulator is by a leak in the vacuum diaphragm.

If oil is found, the modulator must be replaced. If oil is not found in the vacuum side of the modulator but the transmission oil level is continually low, *and No external leaks are found*, there is a possibility that a pin hole leak exists in the diaphragm and the modulator should be replaced.

3. Inspection for External Damage

- Check for dents or cracks in modulator.
- Check modulator valve sleeve alignment. Roll modulator on a flat surface to determine if the sleeve is concentric to the modulator can. See Figure 7D-6. If the sleeve is bent, runout will be visible, and modulator must be replaced.

If the modulator passes the above checks, the following items should also be checked as a possible cause of the problem.

- Check freeness of modulator valve in modulator.
- Check freeness of modulator valve in transmission case.
- Check the vacuum line from the manifold to modulator for holes, cracks or dents. Check the rubber hose connections at the modulator and at the intake manifold for leaks.

TRANSMISSION OIL PRESSURE CHECK TURBO HYDRA-MATIC 400

1. Oil Pressure Check - Road or Normal Operating Conditions

While road testing (with the transmission oil pressure gage attached and the vacuum modulator tube connected) the transmission pressures should check approximately as follows:

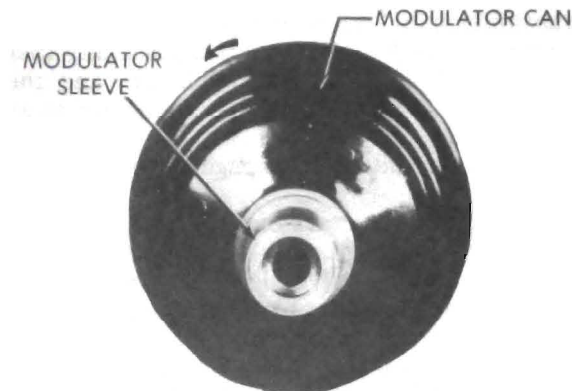
L2 Range		Minimum		Maximum	
2nd Gear - Steady Road Load		150 (5 psi)		150 (5 psi)	
Gear	Selector Lever Position	Minimum		Maximum	
1st	Drive	60		150	
2nd	Zero Throttle to Full Throttle	60		150	
3rd	Drive Range - Zero Throttle 30 mph	60			
Rev.	Reverse - Full Throttle	220		260	

2. Oil Pressure Check - Vacuum Modulator Check

The vacuum modulator assembly can be checked by making an oil pressure check as described in parts "A" and "B" of this section. The pressures given are approximate and can vary with changes in atmosphere pressure, but if this method is used as an indication of a source of malfunction, it can be a valuable service tool.

Using procedure "A" the oil pressures should be approximately as shown. Oil pressures taken in this manner, that vary appreciably from the chart, indicate further inspection of the following:

- Vacuum lines and fittings.
- Vacuum modulator.



ROLL MODULATOR ON FLAT SURFACE TO DETERMINE IF THE SLEEVE IS CONCENTRIC TO THE MODULATOR CAN. IF THE SLEEVE IS BENT, RUNOUT WILL BE VISIBLE.

7D-43

Figure 7D-6 - Checking Modulator Sleeve Alignment

3. Modulator valve.
4. Governor.
5. Pressure regulator.
6. Oil pump.

If the results of procedure "A" indicate further inspection is required, procedure "B" should be followed. If the pressures are appreciably different from those given in "B", a second check should be made with a new modulator assembly or one from a vehicle that is known to be operating standard. On the second check, if the pressures changed and were as shown on the chart, or closer to them, it would indicate a faulty modulator assembly and it should be suspected as a cause or part of the cause of the malfunction.

A. Car Stationary

Transmission oil pressure gage and engine tachometer should be connected. Pressures indicated are with the vacuum line connected for normal modulator operation and service brakes holding vehicle with engine at 1000 rpm.

Drive	L1 or L2	Reverse
Neutral Park 60-90	150	95-150

Pressures are approximate.

B. Oil pressures indicated are at zero output speed with the vacuum line disconnected from the modulator assembly and with the engine at 1200 RPM.

Alt. of Check*	Drive Neutral Park	L2 Or L1	Rev.
0	150	150	244
2,000	150	150	233
4,000	145	150	222
6,000	138	150	212
8,000	132	150	203
10,000	126	150	194
12,000	121	150	186
14,000	116	150	179

* Feet Above Seal Level

Altitude and pressures are approximate.

TRANSMISSION CONTROL SPARK SWITCH CHECKING PROCEDURES ON MODEL BB 455 STAGE I ONLY

The pressure switch in the Turbo Hydra-matic 400 transmission may be easily checked with a continuity tester which uses either the vehicle's battery or a separate source to power the test lamp or meter.

To prevent damaging the pressure switch, the tester used must have sufficient resistance that it does not supply the switch with more than .8 amp of current at 12 volts. Test lamps which use size 1893 or smaller bulb, will not damage the switch.

1. Disconnect electrical wire harness from transmission electrical connector. If using a continuity tester

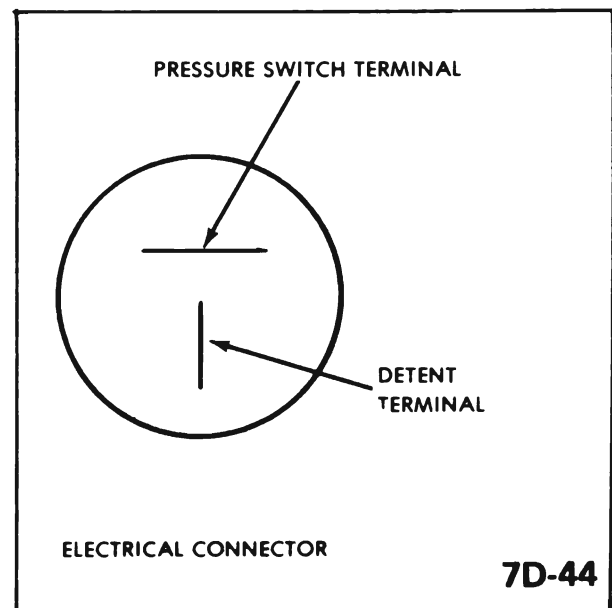


Figure 7D-7

which has a self-contained power source, connect one tester lead to pressure switch terminal of transmission connector (See Figure 7D-7), and connect other lead to ground. Tester should show current flowing through the switch (switch closed).

If the vehicle's battery is to be used to power a simple light blub type tester, connect one lamp lead to pressure switch terminal of transmission connector and connect other lead to a "hot" terminal of the car wiring harness. Check that vehicle's battery cables are connected.

2. Set parking brake, apply service brakes, start engine and let it idle. Move transmission selector to

"Drive" and tester should show current flowing through switch to ground (switch closed).

3. With brakes still applied, move transmission selector to "Reverse" (which supplies transmission oil pressure to pressure switch) and tester should show no current flowing through switch to ground (switch open).

4. If above test indicates a failed pressure switch circuit, the transmission bottom pan must be removed to service the pressure switch or lead wire assembly.

TURBO HYDRA-MATIC 400 TROUBLE DIAGNOSIS CHART

Problem	Possible Cause	Possible Condition
No Drive in Drive Range - install pressure gauge.	1. Low oil level.	1. Correct level - check for external leaks or vacuum modulator (leaking diaphragm will evacuate oil from unit).
	2. Manual linkage adjustment.	2. See Section 7E.
	3. Low oil pressure.	3a) Filter assembly - "O" ring missing or damaged, neck weld leaking, filter blocked. b) Pump assembly - pressure regulator, pump drive gear - tangs damaged by converter. c) Case - porosity in intake bore.
	4. Control valve assembly.	4. Manual valve disconnected from manual lever.
	5. Forward clutch.	5a) Forward clutch does not apply - piston cracked; seals missing, damaged; clutch plates burned look for cause. See Problem "Burned Clutch Plates". b) Pump feed circuit to forward clutch oil seal rings missing or broken on pump cover; leak in feed circuits; pump to case gasket mispositioned or damaged. Clutch drum ball check stuck or missing.
	6. Roller clutch assembly.	6. Broken spring or damaged cage.

Problem	Possible Cause	Possible Condition
Oil Pressure High or Low	1. High oil pressure.	1a) Vacuum line or fittings leaking. b) Vacuum modulator. c) Modulator valve. d) Pressure regulator. e) Oil pump.
	2. Low oil pressure.	2a) Vacuum line or fittings obstructed. b) Vacuum modulator. c) Modulator valve. d) Pressure regulator. e) Governor f) Oil pump.
1-2 Shift - Full Throttle Only	1. Detent switch.	1. Sticking
	2. Detent solenoid.	2a) Loose b) Gasket leaking. c) Stick open.
	3. Control valve assembly.	3a) Valve body spacer plate to cover gasket - leaking, damaged, incorrectly installed. b) Detent valve train stuck. c) 3-2 valve stuck.
	4. Case assembly.	4. Porosity.
First Speed Only - No 1-2 Shift	1. Governor assembly.	1a) Governor valve sticking. b) Driven gear loose, damaged or worn (check for pin in case and length of pin showing): also, check output shaft drive gear for nicks or rough finish, if driven gear shows damage.
	2. Control valve assembly.	2a) 1-2 shift valve train stuck closed. b) Governor feed channels blocked, leaking, pipes out of position. c) Valve body spacer plate to cover gasket - leaking, damaged, incorrectly installed.
	3. Case	3a) Intermediate clutch plug leaking or blown out. b) Porosity between channels. c) Governor feed channel blocked, governor bore scored or worn allowing cross pressure leak.

Problem	Possible Cause	Possible Condition
	4. Intermediate clutch.	4a) Clutch piston seals - missing, improperly assembled, cut. b) Center support - oil rings missing or broken, orifice plug missing.
First and Second Speeds Only, No 2-3 Shift	1. Detent solenoid.	1a) Stuck open (detent shifts only - the 2-3 shift would occur at very high speeds, being interpreted as No. 2-3 shifts).
	2. Detent switch.	
	3. Control valve assembly.	3a) 2-3 shift train stuck. b) Valve body spacer plate to cover gasket - leaking, damaged, incorrectly installed.
	4. Direct clutch.	4a) Center support - oil rings missing or broken. b) Clutch piston seals - missing, improperly assembled, cut, piston ball check stuck or missing.
Drive in Neutral	1. Manual linkage.	1. Maladjusted
	2. Forward clutch.	2. Clutch does not release - this condition will also cause "No Reverse".
No Drive in Reverse or Slips in Reverse - installed pressure gauge.	1. Low oil level.	1. Add oil.
	2. Manual linkage.	2. Misadjusted.
	3. Oil pressure.	3a) Vacuum modulator assembly. b) Vacuum modulator valve - sticking. c) Restricted filter leak at intake pipe grommet, or "O" ring. d) Pump assembly - regulator or boost valve sticking.
	4. Control valve assembly.	4a) Valve body spacer plate to cover gasket - leaking, damaged, incorrectly installed (other malfunctions may also be indicated). b) Low reverse ball check - missing from case. This will also cause no overrun braking in L1 range. c) 2-3 valve train stuck open. This will also cause 1-3 up-shift in Drive range. d) Reverse feed passage - missing check case passages.

Problem	Possible Cause	Possible Condition
	5. Rear servo and accumulator.	5a) Servo piston seal ring, damaged or missing. b) Short band apply pin. This may also cause no overrun braking or slips in overrun braking - L1 range.
	6. Reverse or low band.	6. Burned, loose lining, apply pin or anchor pins not engaged, band broken.
	7. Direct clutch.	7a) Outer seal damaged or missing. b) Clutch plates burned - may be caused by stuck ball check in piston. See Problem "Burned Clutch Plates".
	8. Forward clutch.	8. Clutch does not release - will also cause Drive in Neutral.
Slips in All Ranges, Slips on Start - install pressure gauge.	1. Oil level low.	1. Add oil.
	2. Oil pressure.	2a) Vacuum modulator. b) Vacuum modulator valve sticking. c) Filter assembly - plugged or leaks; grommet "O" ring missing or damaged. d) Pump assembly - regulator or boost valve sticking, cross leak. e) Pump to case gasket damaged or incorrectly installed.
	3. Case	3. Cross leaks, porosity.
	4. Forward and direct clutches slipping.	4a) If burned, look for cause. Problem "Burned Clutch Plates". b) Oil seal rings on pump cover broken worn.
Slips 1-2 Shift - install pressure gauge.	1. Oil level low.	1. Add oil.
	2. Oil pressure.	2a) Vacuum modulator assembly failed. b) Modulator valve sticking. c) Pump pressure regulator valve.
	3. Front accumulator.	3. Oil ring damaged or missing.

Problem	Possible Cause	Possible Condition
	4. Control valve assembly.	4a) 1-2 accumulator valve train sticking. b) Porosity in valve body or case. c) Valve body attaching bolts not properly torqued.
	5. Rear accumulator.	5. Oil ring missing or damaged, case bore damaged.
	6. Pump to case gasket.	6. Mispositioned
	7. Case	7a) Intermediate clutch plug - leaking excessively. b) Porosity between channels.
	8. Intermediate clutch.	8a) Piston seals missing or damaged; clutch plates burned, look for cause. See Problem "Burned Clutch Plates". b) Center support leak in feed circuit (oil rings or grooves damaged), excessive leak between tower and bushing, orifice bleed plug hole (0.20 dia.) blocked. Center support bolt not seated properly in case. c) Extra waved steel plate - should have only one waved steel plate. No waved plate in "BB" models.
Rough 1-2 Shift - install pressure gauge.	1. Oil pressure.	1a) Vacuum modulator - check for loose fittings, restrictions in line, modulator assembly inoperative. b) Modulator valve stuck. c) Pump - regulator or boost valve stuck. d) Pump to case gasket - off location or damaged.
	2. Control valve assembly.	2a) 1-2 accumulator valve train. b) Valve body to case bolts loose. c) Valve body spacer plate to cover gasket off location, wrong gasket or damaged.
	3. Case	3a) Intermediate clutch ball missing or not sealing. b) Porosity between channels.
	4. Rear servo accumulator assembly.	4a) Oil rings damaged. b) Piston stuck. c) Broken or missing spring. d) Bore damaged.

Problem	Possible Cause	Possible Condition
	5. Intermediate clutch.	5. Extra waved steel plate. No waved plate in "BB" models.
Slips 2-3 Shift - install pressure gauge.	1. Oil level low.	1. Add oil.
	2. Oil pressure low.	2a) Modulator assembly. b) Modulator valve. c) Pump pressure regulator valve or boost valve; pump to case gasket off location.
	3. Control valve assembly.	3. Accumulator piston pin - leak at swedge end.
	4. Case	4. Porosity
	5. Direct clutch.	5a) Piston seals leaking, or ball check leak. b) Center support - oil seal rings damaged; excessive leak between tower and bushing. c) Extra waved steel plate - should have only one waved plate. No waved plate in "BB" model.
Rough 2-3 Shift - install pressure gauge.	1. Oil pressure - high.	1a) Modulator assemble. b) Modulator valve sticking. c) Pump - pressure regulator or d) boost valve inoperative.
	2. Front servo accumulator or assembly.	2a) Front accumulator spring missing, broken. b) Accumulator piston stuck.
	3. Direct clutch.	3. Extra waved steel plate. No waved plate in "BB" models.
No Engine Braking - L2 - 2nd Gear	1. Front servo and accumulator.	1a) Servo or accumulator oil rings or bores leaking. b) Servo piston stuck.
	2. Front band.	2. Front band broken, burned. Check for cause; not engaged on anchor pin and/or servo pin.
No Engine Braking - L2 - 1st Gear	1. Control valve assembly.	1. Lo-reverse check ball missing from case.
	2. Rear servo.	2a) Oil seal ring, bore or piston damaged; leaking apply pressure. b) Rear band apply pin short, improperly assembled.

Problem	Possible Cause	Possible Condition
	3. Rear band. NOTE: Items 1, 2, and 3 will also cause slips in Reverse or no Reverse.	3. Rear band - broken, burned. Check for cause; not engaged on anchor pins or servo pin.
No Part Throttle Downshift - install pressure gauge.	1. Oil pressure.	1. Vacuum modulator assembly, modulator valve, pressure regulator may also be noticed.
	2. Control valve assembly.	2. 3-2 valve stuck, spring missing or broken.
No Detent Downshifts	1. Control valve assembly.	1. 3-2 valve stuck, spring missing or broken.
	2. Detent switch.	2. Adjustment, connections fuse.
	3. Solenoid	3. Inoperative, connections.
	4. Control valve assembly.	4. Detent valve train, sticking.
Low or High Shift Points - install pressure gauge.	1. Oil pressure.	1a) Engine vacuum - check at transmission end of the modulator pipe. b) Vacuum modulator assembly vacuum line connections at engine and transmission, modulator valve, pressure regulator valve train.
	2. Governor	2a) Valve sticking. b) Feed holes restricted or leaking, pipes damaged or mispositioned. c) Feed line plugged.
	3. Detent solenoid.	3. Stuck open, loose, etc. Will cause late shifts.
	4. Control valve assembly.	4a) Detent valve train. b) 3-2 valve train. c) 1-2 shift valve train. 1-2 regulator valve stuck - this would cause a constant 1-2 shift point, regardless of throttle opening. d) Valve body spacer plate to cover gasket - mispositioned, spacer plate orifice holes missing or blocked.
	5. Case	5. Porosity: intermediate plug leaking, missing.

Problem	Possible Cause	Possible Condition
Won't Hold in Park	1. Manual linkage.	1. Maladjusted
	2. Internal linkage.	2a) Parking brake lever and actuator assembly. Check for chamfer on actuator rod sleeve. b) Parking pawl broken or in-operative.
Transmission Noisy	1. Pump noise.	1a) Oil low or high. b) Cavitation due to plugged filter, "O" ring damaged, porosity in intake circuit, water in oil. c) Pump gears - driving gear assembled backwards, gears damaged or, crescent interference.
	2. Gear noise - 1st, 2nd, and/or Reverse.	2a) Transmission grounded to body. b) Planetary gear set. c) Thoroughly clean thrust bearings and thrust races, and closely inspect for pitting or roughness.
	3. Clutch noise - during application.	1a) Forward clutch - Neutral to Drive, Park to Drive. Check the clutch plates. b) Intermediate clutch - 1-2 shift in L2 and Drive range. Check clutch plates. c) Direct clutch - 2-3 shift in Drive range and in Neutral to Reverse, Park to Reverse. Check clutch plates.
	4. Converter noise.	4. This condition will occur in R-D-L2-L1 due to damaged needle bearings in converter. Noise level is generally lower in Park and Neutral.
Burned Clutch Plates	1. Forward clutch.	1a) Check ball in clutch housing damaged, stuck, or missing. b) Clutch piston cracked, seals damaged or missing. c) Low line pressure. d) Manual valve mispositioned. e) Restricted oil feed to forward clutch. Examples: Clutch housing to inner and outer areas not drilled, restricted or porosity in pump. f) Pump cover oil seal rings missing, broken or undersize: ring groove oversize. g) Case valve body face not flat or porosity between channels. h) Manual valve bent and center land not ground properly.

Problem	Possible Cause	Possible Condition
	2. Intermediate clutch.	2a) Constant bleed orifice in center support missing. b) Rear accumulator piston oil ring damaged or missing. c) 1-2 accumulator valve stuck in control valve assembly. d) Intermediate clutch piston seal damaged or missing. e) Center support bolt loose. f) Low line pressure. g) Intermediate clutch plug in case missing. h) Case valve body face not flat or porosity between channels. i) Manual valve bent and center land not ground properly.
	3. Direct clutch.	3a) Restricted orifice in vacuum line to modulator - poor vacuum response. b) Check ball indirect clutch piston damaged, stuck or missing. c) Failed modulator bellows. d) Center support bolt loose. Bolt may be tight in support but not holding support tight to case. e) Center support oil rings or grooves damaged or missing. f) Clutch piston seals damaged or missing. g) Front and rear servo pistons and seals damaged. h) Manual valve bent and center land not cleaned up. i) Case valve body face not flat or porosity between channels. j) Intermediate roller clutch installed backwards. k) 3-2 valve, 3-2 spring or 3-2 spacer pin installed in wrong location in 3-2 valve bore.

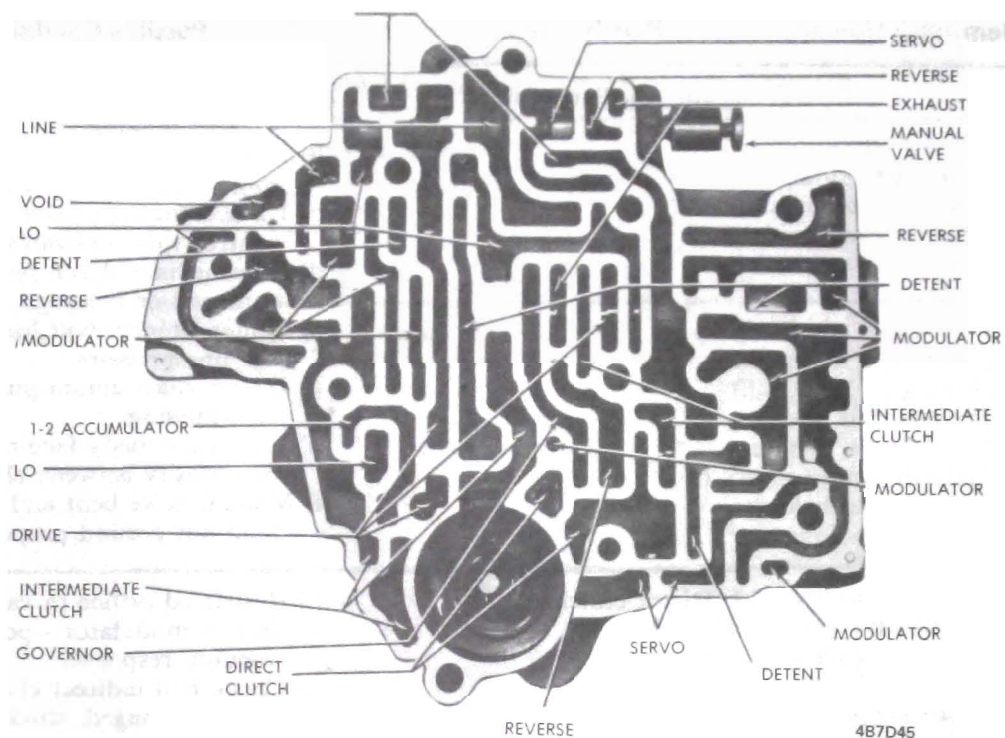


Figure 7D-8 Valve Body

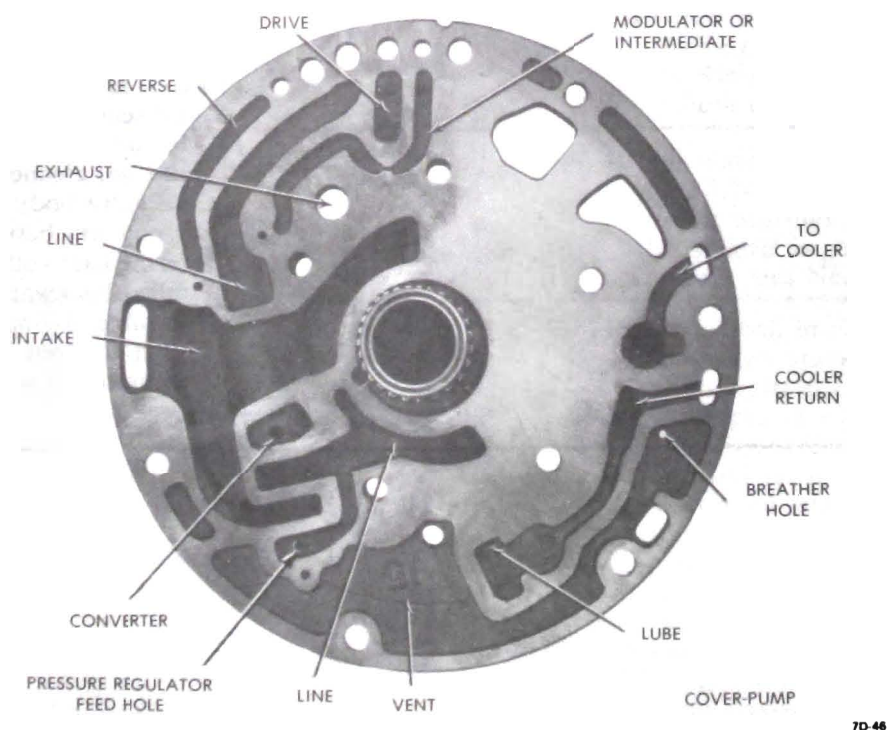


Figure 7D-9 Oil Pump Cover

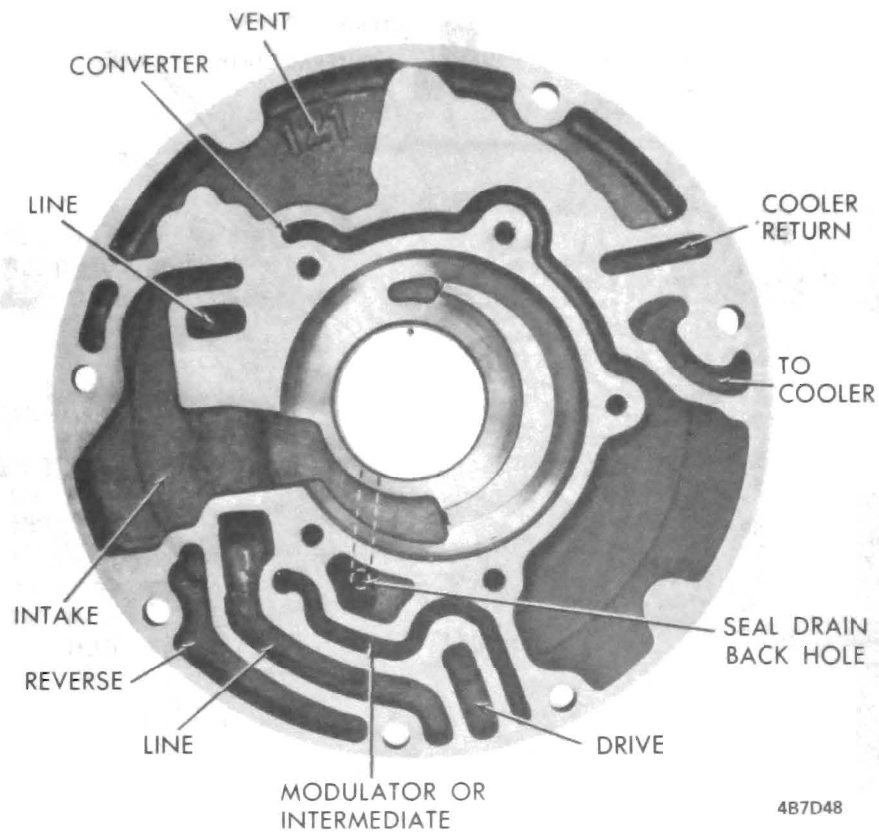


Figure 7D-10 Oil Pump Body

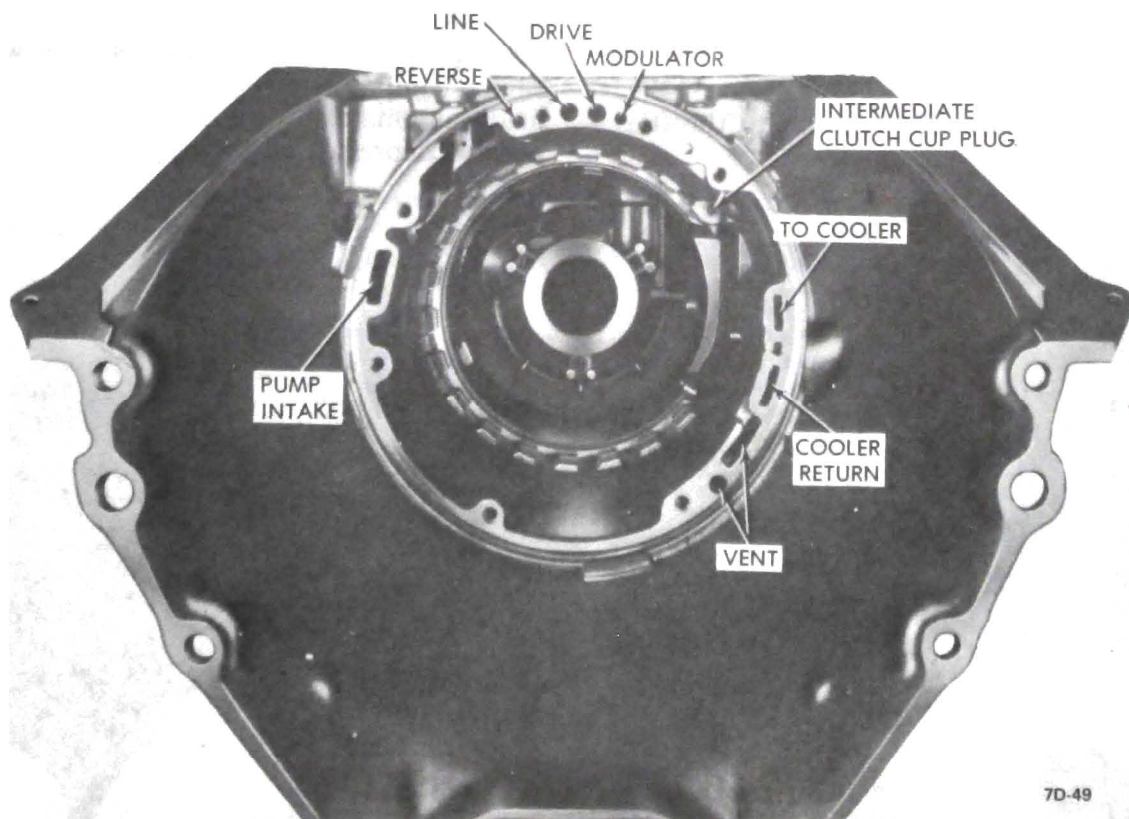


Figure 7D-11 Front of Case

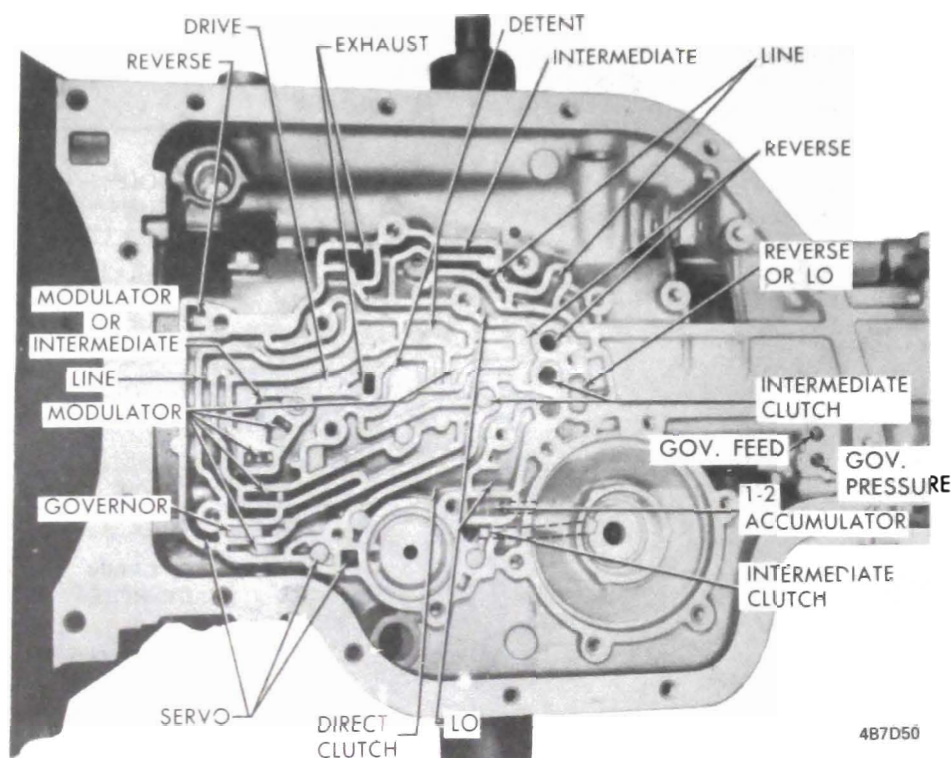


Figure 7D-12 Bottom of Case

MAINTENANCE AND ADJUSTMENTS

DETENT SWITCH REPLACEMENT AND ADJUSTMENT

The detent switch is located on the inside of the engine compartment bulkhead adjacent to throttle lever. See Figure 7D-14.

To replace, detach electrical connection and remove one screw. Position new switch on bracket with electrical connection toward left side of car. Install screw and electrical connection. Primary adjustment is made by pushing switch lever all the way toward engine compartment bulkhead. Final adjustment is made automatically the first time the accelerator pedal is depressed all the way to the floor.

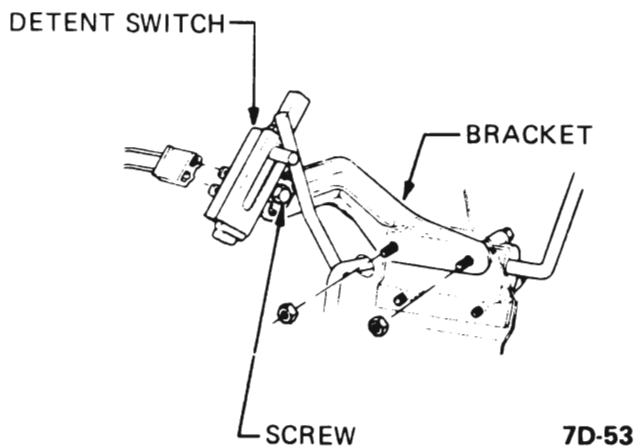


Figure 7D-14 Detent Switch



Figure 7D-15

REMOVAL OF CONVERTER AND VACUUM MODULATOR

1. With transmission in portable jack, remove J-21366. The converter contains a large amount of oil. Remove converter assembly, by pulling straight out.
2. Install Holding Fixture J-8763-01 on the transmission so that the modulator assembly will be located on the side of the holding fixture that is nearest the bench.
3. Install fixture and transmission into Holding Tool Base, J-3289-20, with bottom pan facing up. See Figure 7D-15.

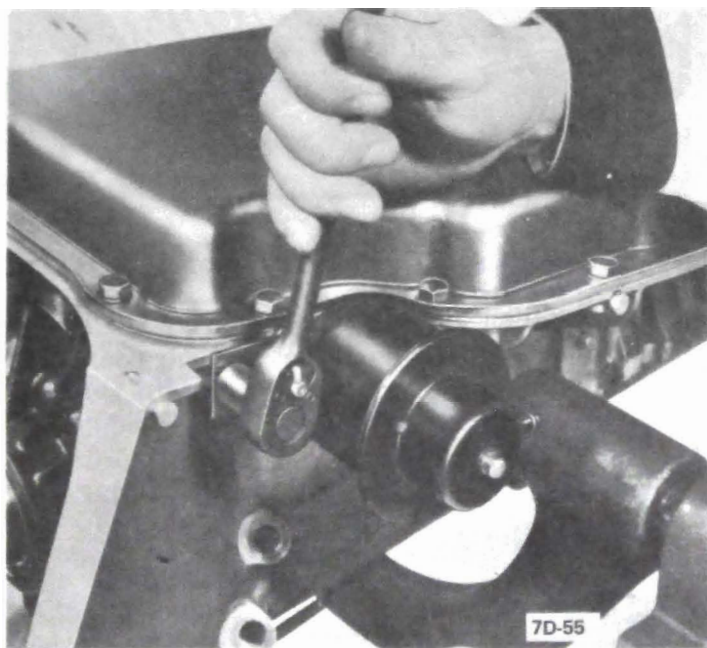


Figure 7D-16

4. Remove modulator assembly attaching bolt and retainer. See Figure 7D-16.
5. Remove modulator assembly and "O" ring seal from case. See Figure 7D-18.
6. Remove modulator valve from transmission case.

REMOVAL OF GOVERNOR, SPEEDOMETER DRIVEN GEAR, OIL PAN, FILTER, AND PRESSURE REGULATOR VALVE

The following operations can be performed with transmission in vehicle:

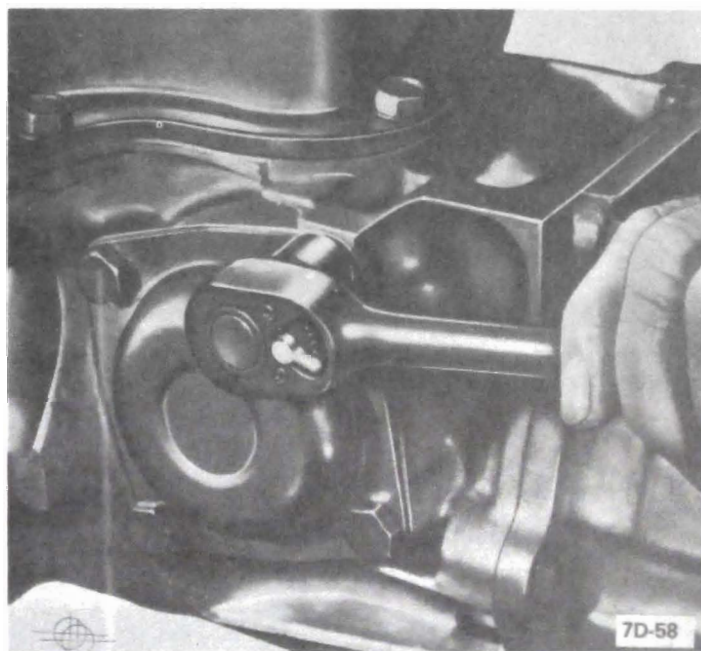


Figure 7D-19

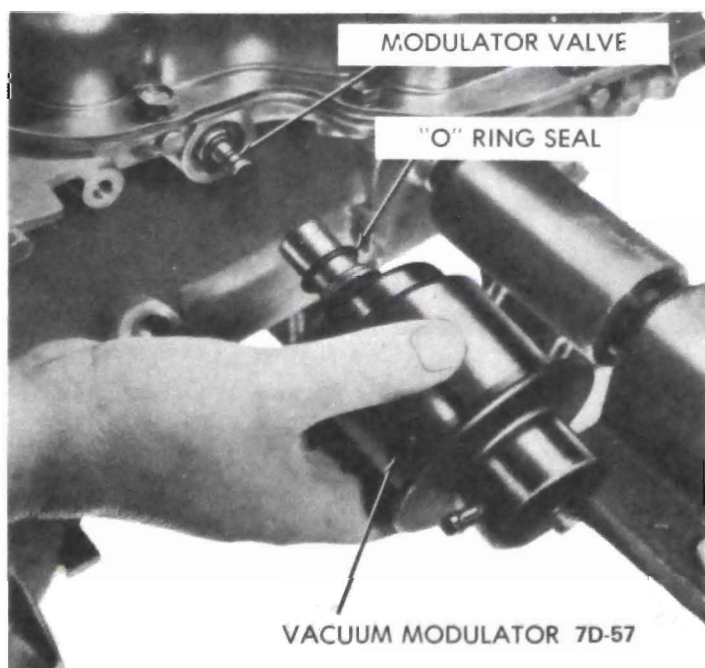


Figure 7D-18

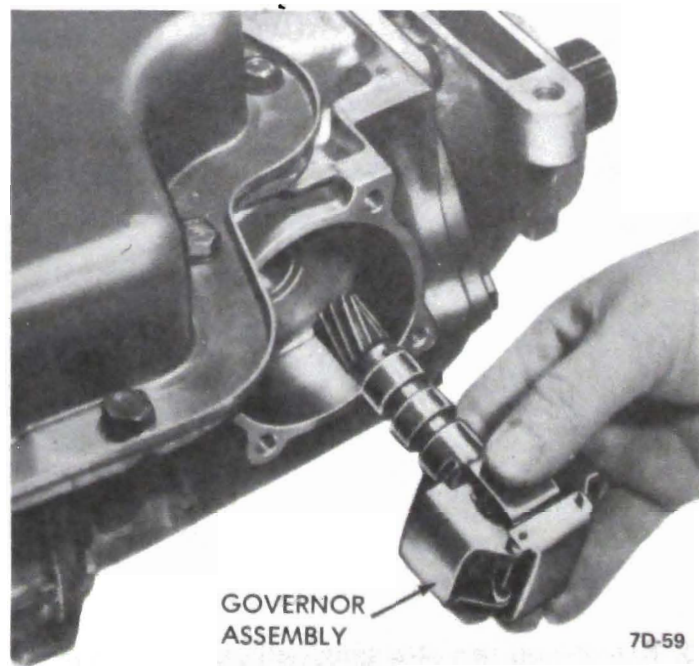


Figure 7D-20

1. Remove attaching bolts, governor cover and gasket. See Figure 7D-19.
2. Withdraw governor assembly from case. See Figure 7D-20.
3. Remove speedometer driven gear attaching bolt and retainer. See Figure 7D-21.

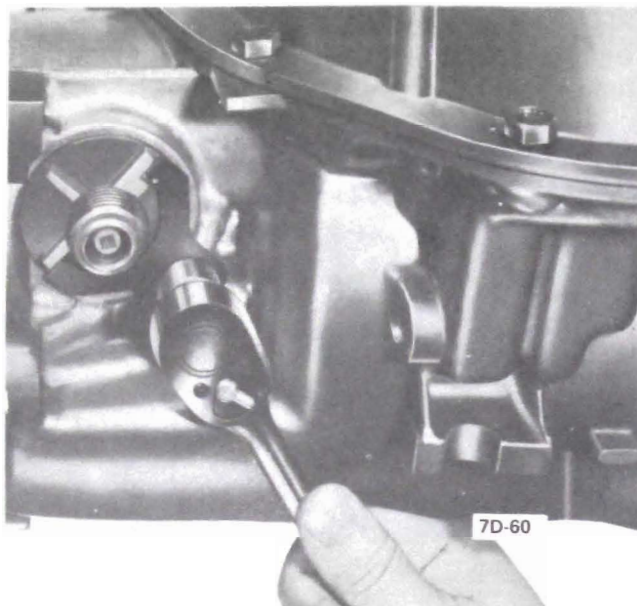


Figure 7D-21

4. Withdraw speedometer driven gear assembly from case. See Figure 7D-22.



Figure 7D-22

5. Remove oil pan attaching bolts.
6. Remove oil pan and gasket. Discard gasket.

7. Remove the filter assembly retainer bolt. See Figure 7D-23.

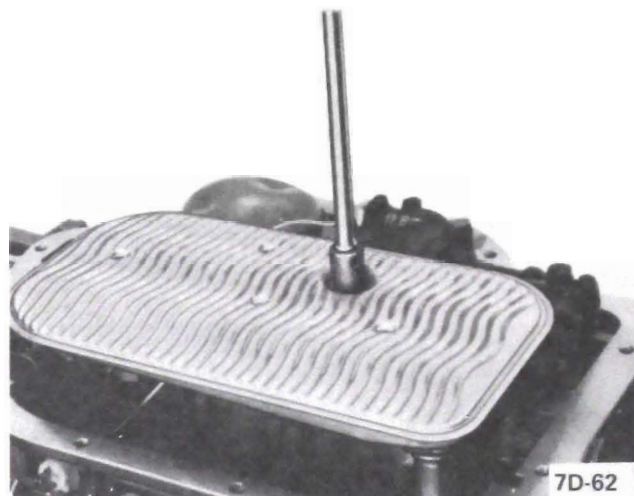


Figure 7D-23

8. Remove filter and intake pipe assembly. Discard filter. See Figure 7D-24.

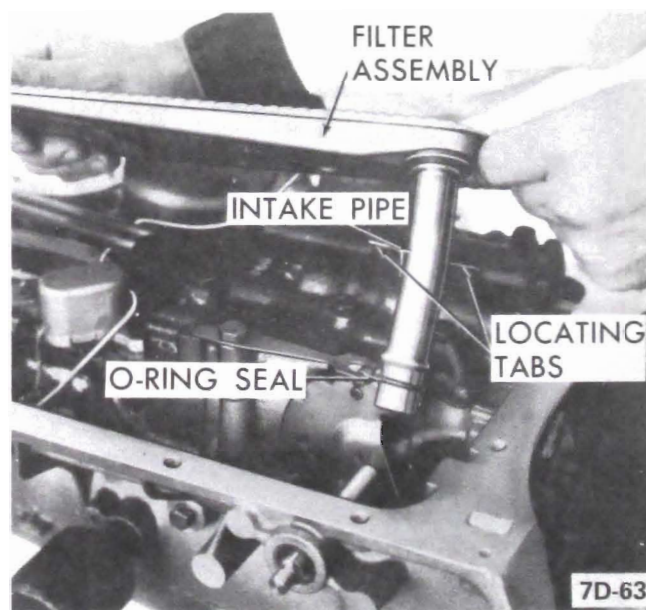


Figure 7D-24

9. Remove intake pipe to case "O" ring seal and discard. See Figure 7D-24.

INSTALLATION OF OIL FILTER

1. Install new case to intake pipe "O" ring on intake pipe and new filter assembly. See Figure 7D-24.

2. Install filter and intake pipe assembly attaching filter to valve body assembly with retainer bolt. Torque to 10 lb. ft. See Figure 7D-23.

3. Install a new pan gasket on oil pan. Install attaching bolts and torque 10-13 lb. ft.

INSTALLATION OF MODULATOR VALVE AND VACUUM MODULATOR

1. Install modulator valve into the case, stem end out. See Figure 7D-18.

2. Install the "O" ring seal on the vacuum modulator.

3. Install the vacuum modulator into the case.

4. Install the modulator retainer and attaching bolt. Torque bolt to 15-20 lb.ft. See Figure 7D-16.

INSTALLATION OF GOVERNOR ASSEMBLY

1. Install governor assembly into case. See Figure 7D-20.

2. Attach the governor cover and new gasket with four (4) attaching bolts. Torque bolts to 15-20 lb.ft. See Figure 7D-19.

PRESSURE REGULATOR VALVE

Removal

1. Remove bottom pan and filter. Discard pan gasket.

2. Compress regulator boost valve bushing against pressure regulator spring and remove snap ring, using snap ring pliers and tool as shown in Figure 7D-25.

3. Remove regulator boost valve bushing and valve.

4. Remove pressure regulator spring.

5. Remove regulator valve, spring retainer and spacer(s) if present.

INSTALLATION

Installation of the pressure regulator valve is the reverse of the removal. Affix new gasket to bottom pan and adjust oil level.

TURBO HYDRA-MATIC 400 FLUID RECOMMENDATIONS

Use DEXRON[®] or DEXRON[®]-II Automatic Transmission Fluid or equivalent only in all 1974

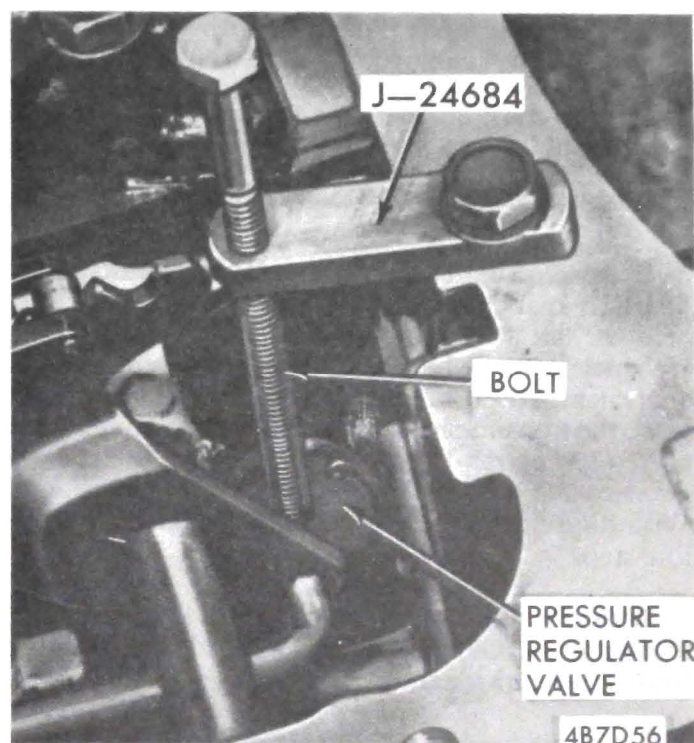


Figure 7D-25

model Turbo Hydramatic 400 automatic transmissions (GM Part No. 1050568-69-70 or other fluid having DEXRON identifications).

DEXRON is an especially formulated automatic transmission fluid designed to improve transmission operation.

The oil pan should be drained and the filter replaced every 24,000 miles and fresh fluid added to obtain the proper level on the dipstick. See sub-paragraph 2 for proper refill procedures. For cars subjected to heavy city traffic during hot weather, or in commercial use, when the engine is regularly idled for prolonged periods, the oil pan should be drained and the filter replaced every 12,000 miles.

1. Checking and Adding Fluid

Fluid level should be checked at every engine oil change. The "FULL" and "ADD" marks on the transmission dipstick indicate one pint difference.

To determine proper fluid level, proceed as follows:

The full mark on the dipstick is an indication of transmission fluid at normal operating temperature of 180 degrees F. This temperature is only obtained after at least 15 miles of expressway driving or equivalent of city driving.

1. With manual control lever in Park position start engine. DO NOT RACE ENGINE. Move manual control lever through each range.

2. Immediately check fluid level with selector lever in Park, engine running, and vehicle on LEVEL surface.

At this point, when a reading is made, fluid level on the dipstick should be at the "FULL" mark.

3. If additional fluid is required, add fluid to the "FULL" mark on the dipstick.

If vehicle can not be driven 15 expressway miles or equivalent, and it becomes necessary to check fluid level, the transmission fluid must be at room temperature (70 degrees F.).

With fluid at room temperature (70 degrees F.) follow steps 1, 2, and 3 below.

1. With manual control lever in Park position start engine. DO NOT RACE ENGINE. Move manual control lever through each range.

2. Immediately check fluid level with selector lever in Park, engine running, and vehicle on LEVEL surface.

At this point, when a reading is made, fluid level on the dipstick should be 1/4" below the "ADD" mark.

3. If additional fluid is required add fluid to bring level to 1/4" below the "ADD" mark on the dipstick.

Do not Overfill, as foaming and loss of fluid through the vent pipe might occur as fluid heats up. If fluid is too low, especially when cold, complete loss of drive may result which can cause transmission malfunctions.

If transmission fluid level is correctly established at 70 degrees F it will appear at the "FULL" mark on the dipstick when the transmissions reaches normal operating temperature (180 degrees F). The fluid level is set 1/4" below the "ADD" mark on the dipstick to allow for expansion of the fluid which occurs as transmission temperatures rise to normal operating temperature of 180 degrees F.

2. Draining Oil Pan and Replacing Filter

(a) Raise car on hoist or place on jack stands, and provide container to collect draining fluid.

(b) Remove oil pan and gasket. Discard gasket.

(c) Drain fluid from oil pan. Clean pan with solvent and dry thoroughly with clean compressed air.

(d) Remove oil filter retainer bolt, oil filter, intake pipe assembly and innake pipe to case "O" ring. Discard the filter and intake pipe to case "O" ring.

(e) Install new "O" ring seal on intake pipe and place pipe assembly into grommet on new filter assembly. With new "O" ring on intake pipe, install pipe and filter assembly into case, attaching filter to valve body assembly with retainer bolt. Torque to 10 lb. ft.

(f) Install new gasket on oil pan and install pan. Tighten attaching bolts to 12 lb. ft.

(g) Lower car and add 5 pints of transmission fluid through filler tube.

(h) With manual control lever in Park position, start engine. DO NOT RACE ENGINE. Move manual control lever through each range.

(i) Immediately check fluid level with selector lever in Park, engine running, and vehicle on LEVEL surface.

(j) Add additional fluid to bring level to 1/4" below the "ADD" mark on the dipstick.

The fluid level is set 1/4" below the "ADD" mark on the dipstick to allow for expansion of the fluid which occurs as transmission temperatures rise to normal operating temperature.

Do not overfill.

3. Adding Fluid to Fill Dry Transmission and Converter Assembly

The fluid capacity of the Turbo Hydra-matic 400 transmission and converter assembly is approximately 23 pints, but correct level is determined by the mark on the dipstick rather than by amount added. In cases of transmission overhaul, when a complete fill is required, including a new converter proceed as follows:

The converter should be replaced only if the converter itself fails. On any major failure, such as a clutch or gearset, the filter must be replaced.

(a) Add 10 pints of transmission fluid through filler tube.

If installation of a new converter is not required add only 6 pints of transmission fluid.

(b) With manual control lever in Park position start engine and place fast idle screw on middle of fast idle cam. DO NOT RACE ENGINE. Move manual control lever through each range.

(c) Immediately check fluid level with selector lever in Park, engine running, and vehicle on LEVEL surface.

(d) Add additional fluid to bring level to 1/4" below the "ADD" mark on the dipstick.

Fluid level is set at 1/4" below the "ADD" mark on the dipstick to allow for expansion as fluid heats up.

Do not overfill.

Turbo Hydra-matic 400 Towing Instructions

If a Buick equipped with Turbo Hydra-matic 400 transmission must be towed, the following precautions must be observed: The car may be towed safely on its rear wheels with the shift lever in neutral position at speeds of 35 miles per hour or less under most conditions.

However, the drive shaft must be disconnected or the car towed on its front wheels if:

Tow speeds in excess of 35 mph are necessary,

Car must be towed for extended distances (over 50 miles) or,

Transmission is not operating properly.

If car is towed on its front wheels, the steering wheel should be secured to keep the front wheels in a straight-ahead position.

E. Rocking Car

If it becomes necessary to rock the car to free it from sand, mud or snow, move the selector lever from "D" to "R" in a repeat pattern while simultaneously applying moderate pressure to the accelerator. Do not race engine. Avoid spinning wheels when trying to free the car.

TRANSMISSION ASSEMBLY - REMOVAL AND INSTALLATION

Removal

1. Raise vehicle and provide support for front and rear of car.
2. Disconnect front exhaust crossover pipe if necessary.
3. Disconnect propeller shaft.
4. Place suitable jack under transmission and fasten transmission securely to jack.
5. Remove vacuum line from vacuum modulator. See Figure 7D-26.
6. Loosen cooler line nuts and separate cooler lines from transmission. See Figure 7D-27.
7. Remove transmission mounting pad to cross member bolts.

8. Remove transmission cross member support to frame rail bolts. Remove cross member.

9. Disconnect electrical wire harness from transmission electrical connector.

10. Disconnect speedometer cable.

11. Disconnect shift linkage from transmission.

12. Disconnect transmission filler pipe at engine. Remove filler pipe from transmission.

13. Support engine at oil pan.

14. Remove transmission flywheel cover pan to case tapping screws. **REMOVE FLYWHEEL COVER PAN.**

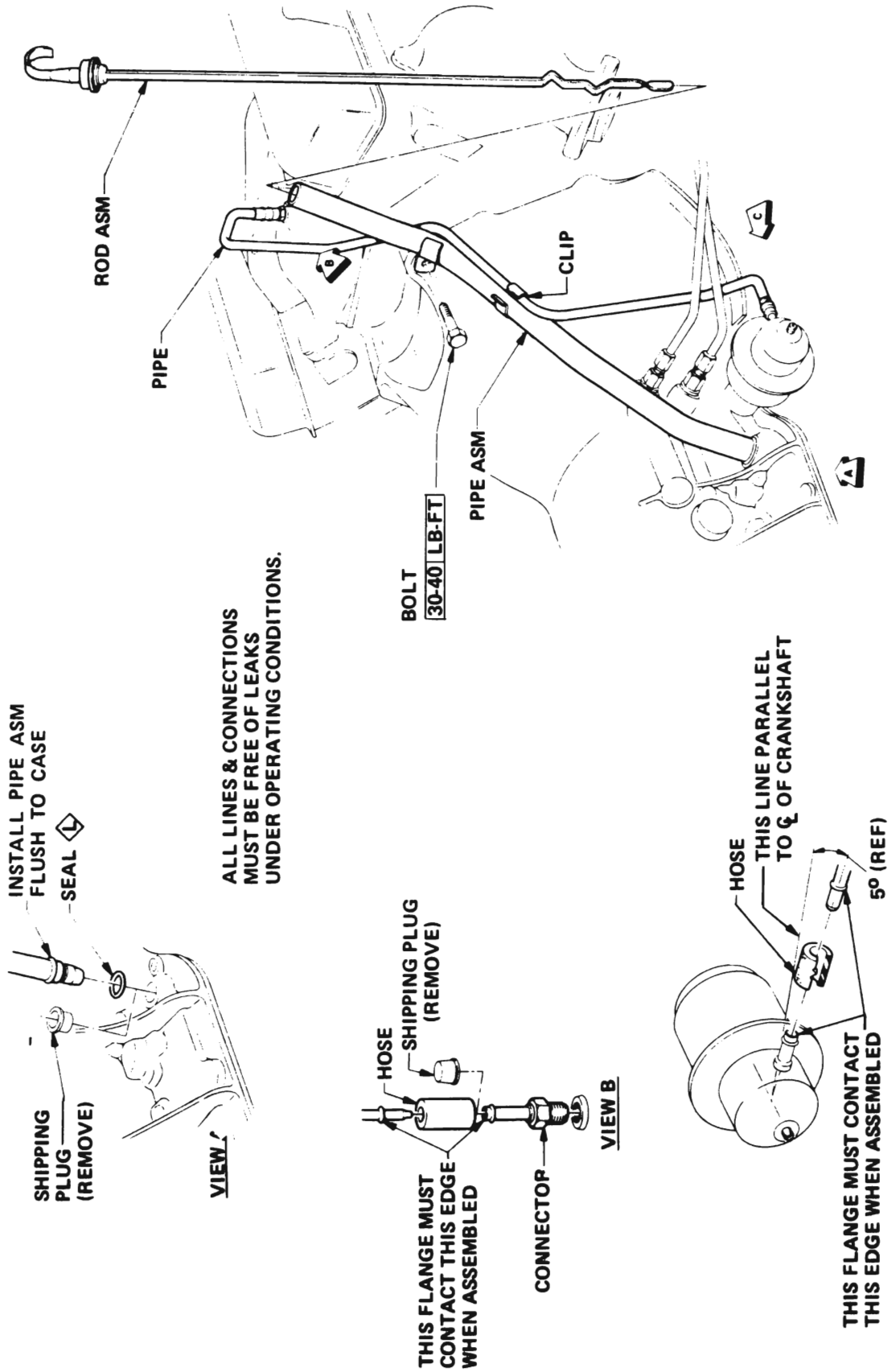
15. Mark flywheel and converter pump for reassembly in same position, and remove three converter pump to flywheel bolts.

16. Remove transmission case to engine block bolts.

17. Move transmission rearward to provide clearance between converter pump and crankshaft. Install Converter Holding Tool J-21366 to retain converter. Lower transmission and move to bench.

Installation

1. Assemble transmission to suitable transmission jack and raise transmission into position. Rotate converter to permit coupling of flywheel and converter with original relationship. Remove J-21366.
2. Install transmission case to engine block bolts. Torque to 30-40 lb. ft. Do not overtighten. Converter assembly must rotate freely by hand after converter pilot has been pushed forward into the engine crankshaft pilot hole.
3. Install flywheel to converter pump bolts. Torque to 25-35 lb. ft.
4. Install transmission cross member support. Install mounting pad to cross member.
5. Remove transmission jack and engine support.
6. Install transmission flywheel cover pan with tapping screws.
7. Install transmission oil filler pipe using a new "O" ring. See Figure 7D-26.
8. Reconnect speedometer cable.
9. Connect electrical wire harness to transmission electrical connector.



⬇ APPLY OIL BEFORE ASSEMBLY

7D-65

Figure 7D-26 - Vacuum Modulator Line and Dipstick

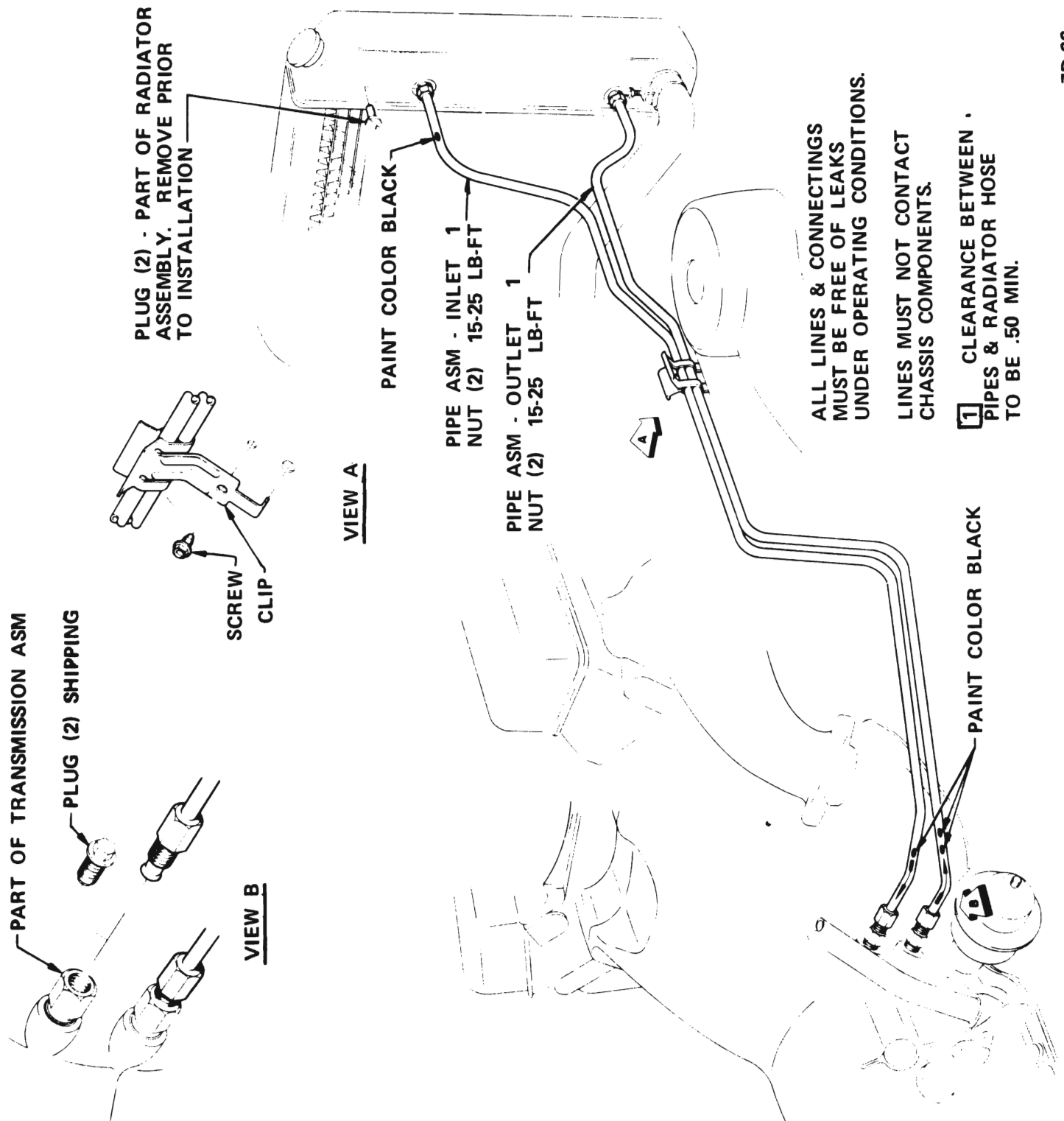


Figure 7D-27 - Oil Cooler Lines

10. Install propeller shaft.
11. Reinstall front exhaust crossover pipe, if removed.
12. Install oil cooler lines to transmission. See Figure 7D-27 Torque to 11 lb. ft.
13. Install vacuum line to vacuum modulator.
14. Fill transmission with fluid as described in Fluid Recommendations in the back of this section.

MAJOR REPAIR

REMOVAL OF PRESSURE SWITCH ASSEMBLY, VALVE BODY ASSEMBLY, GOVERNOR PIPES, AND DETENT SPRING ASSEMBLY

The following operations can be performed with transmission in vehicle.

1. Disconnect the lead wire assembly from the pressure switch assembly. See Figure 7D-28 (Model BB Only).

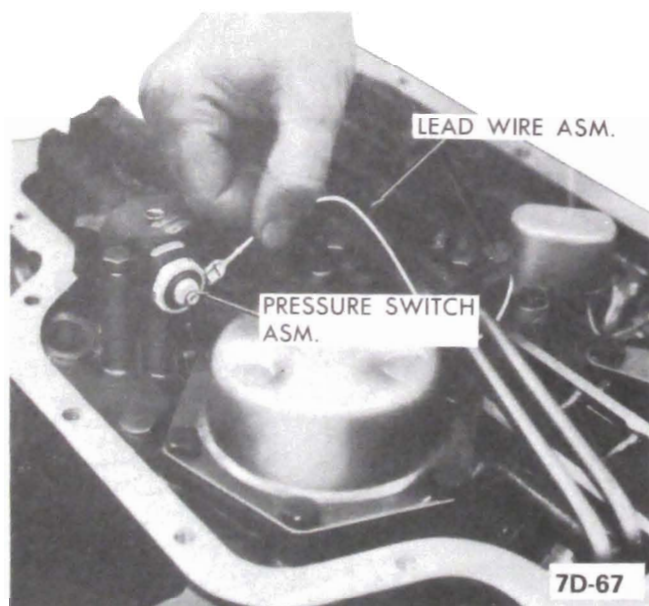


Figure 7D-28

2. If necessary, remove the pressure switch assembly. (Model BB Only).
3. Remove valve body attaching bolts and detent roller and spring assembly. Do not remove solenoid attaching bolts. If transmission is in vehicle, front servo group may drop out as control valve assembly is removed. See Figure 7D-29.

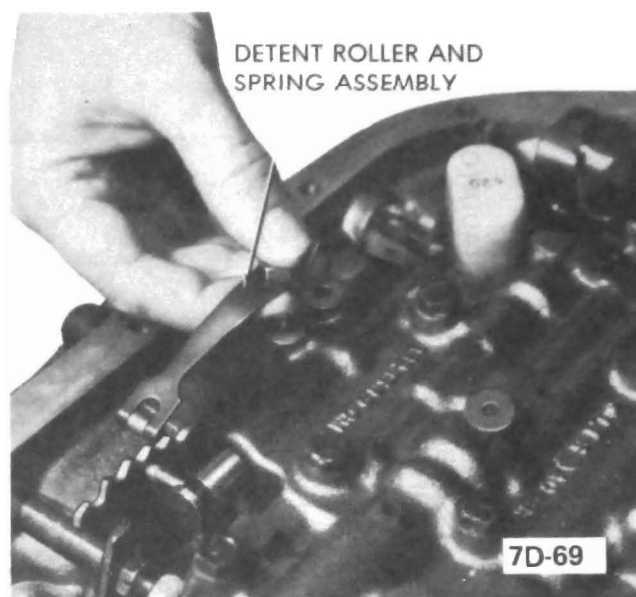


Figure 7D-29

4. Remove valve body assembly valve body to spacer plate gasket and governor pipes. Do not allow manual valve to fall out of valve body assembly. See Figure 7D-30.

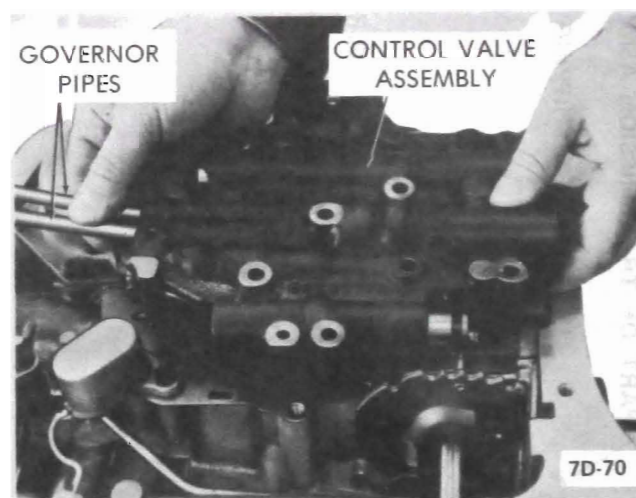


Figure 7D-30

5. Remove governor screen assembly from governor feed pipe in case or from end of governor feed pipe. See Figure 7D-31. Clean screen in clean solvent and air dry.
6. Remove governor pipes from valve body assembly.
7. Disconnect detent solenoid wire from case connector. See Figure 7D-32.

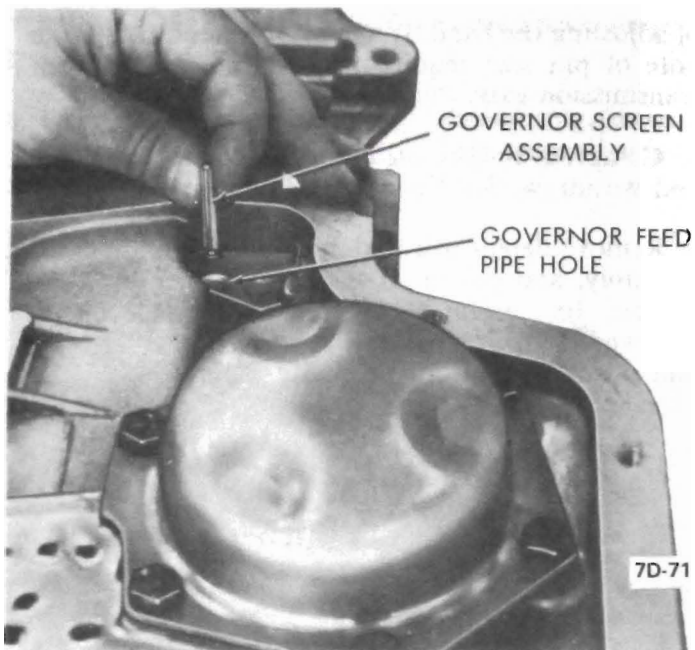


Figure 7D-31



Figure 7D-33

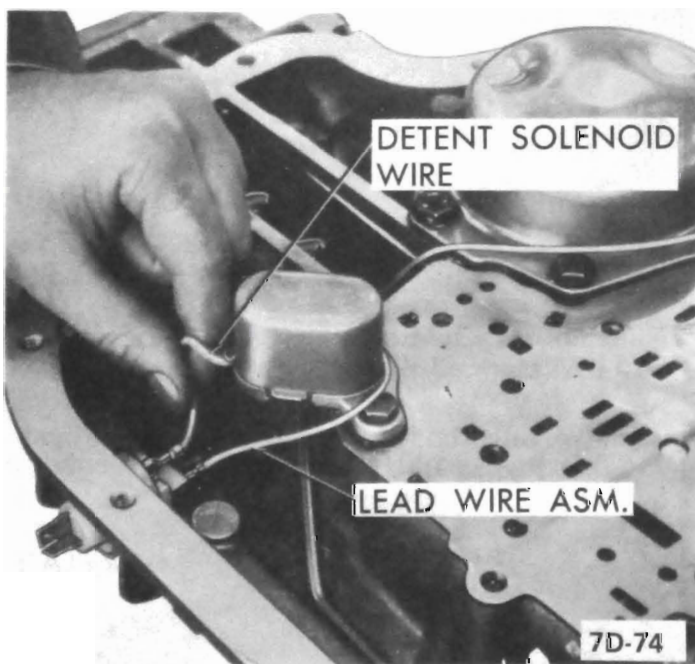


Figure 7D-32

REMOVAL OF SERVO, CASE CONNECTOR, VALVE BODY SPACER, GASKET FRONT SERVO, MANUAL DETENT, AND PARK LINKAGE

The following operations can be performed with the transmission in the vehicle.

1. Remove rear servo cover attaching bolts, servo cover, and gasket. (Discard gasket). See Figure 7D-33.

2. Remove rear servo assembly and spring from case. See Figure 7D-35.



Figure 7D-35

3. Check band apply Pin.

a. Attach band apply pin Selection Gage J-21370-6 with J-21370-5, to transmission case with attaching bolts. Torque 6-10 lb.ft.

b. Apply 25 lb.ft. torque and *select proper pin to be used during assembly of transmission*. See Figure 7D-36.

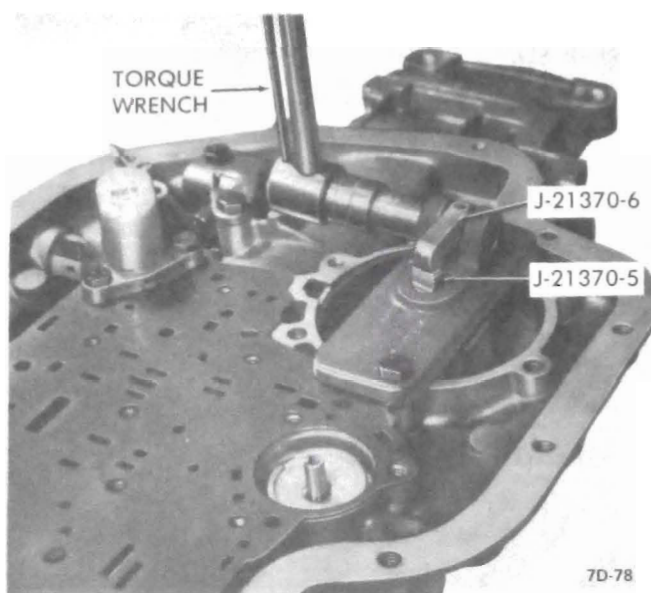


Figure 7D-36

There are three selective pins identified as follows:

Pin Id.	Pin Size
3 Rings	Long
2 Rings	Medium
1 Ring	Short

If both steps of J-21370-5 are below the gage surface, the long pin should be used. If the gage surface is between the steps, the medium length pin should be used. The short pin should be used if both steps of the gage pin are above the gage surface.

The identification ring is located on the band lug end of the pin. Selecting the proper pin is the equivalent

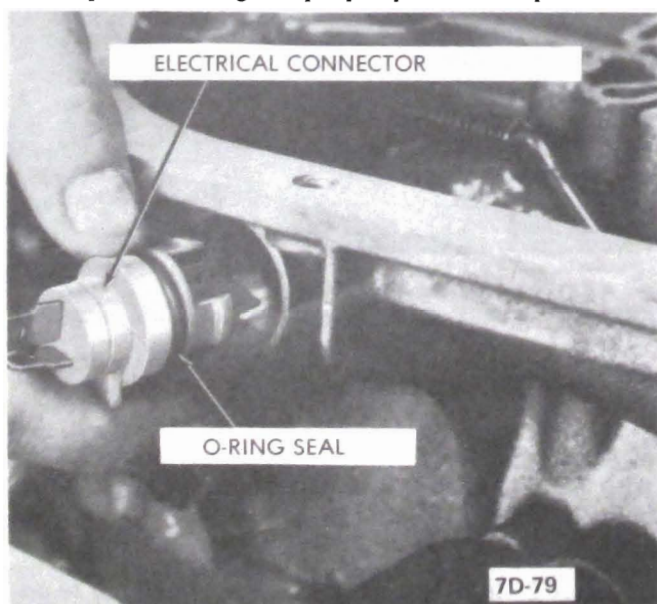


Figure 7D-37

of adjusting the band. If a new pin is required, make note of pin size required, and remove gage from transmission case.

4. Compress fingers on electrical connector sleeve and withdraw. See Figure 7D-37.

5. Remove detent solenoid attaching bolts, solenoid assembly, and gasket. If the transmission is in the vehicle, be careful when the detent solenoid is removed, as it prevents the spacer plate and gasket and check balls from dropping down. See Figure 7D-38.

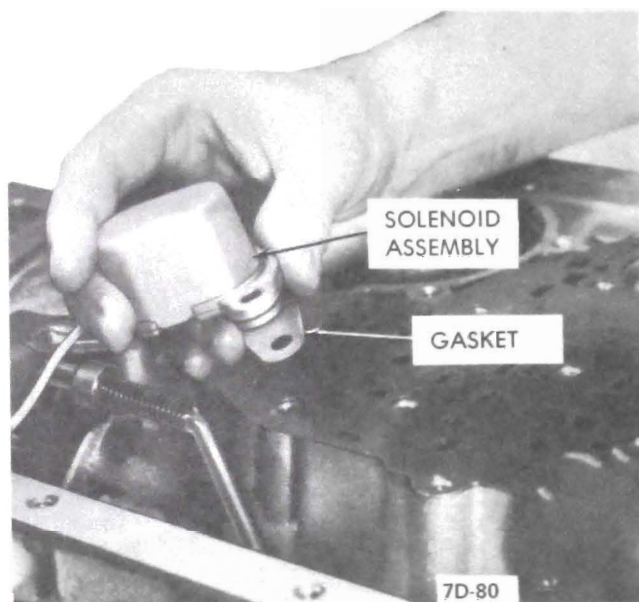


Figure 7D-38

6. Remove valve body assembly spacer plate and gasket. See Figure 7D-39.

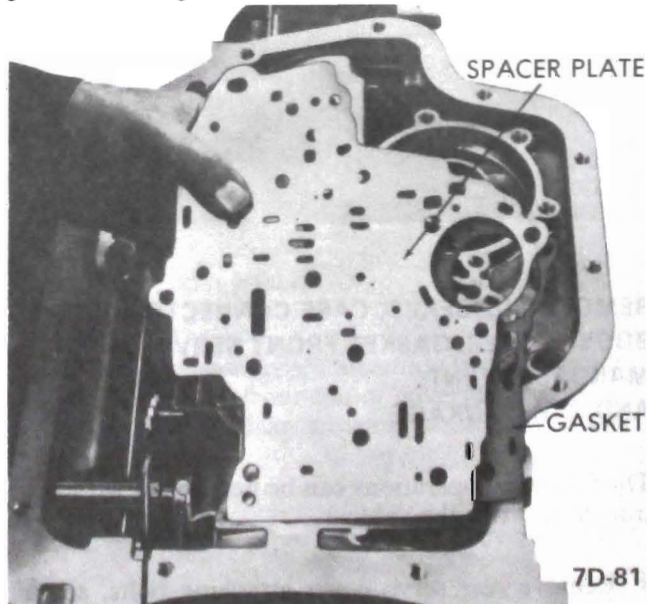


Figure 7D-39

7. Remove six (6) check balls from cored passages in transmission case.

8. Remove front servo piston, retainer ring, servo pin, spring retainer, and spring from transmission. See Figure 7D-40.

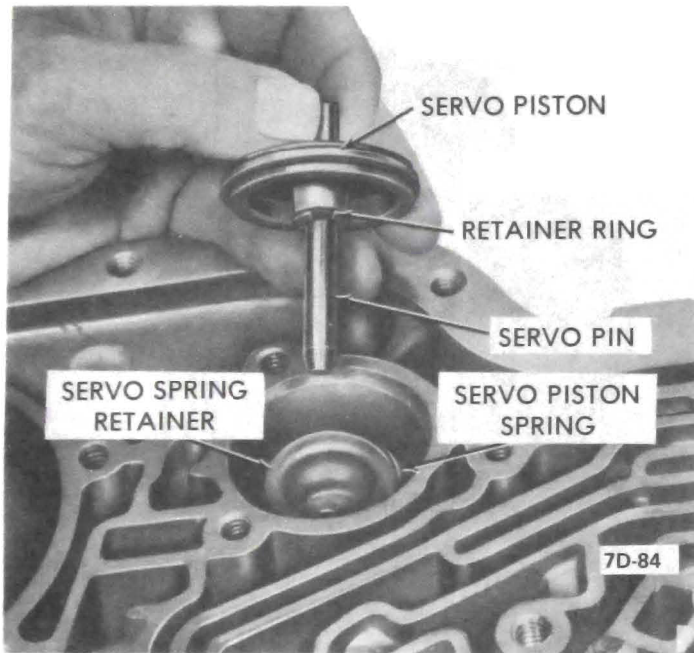


Figure 7D-40

9. If it becomes necessary to remove the internal manual linkage proceed as follows:

a. Unthread jam nut holding detent lever to manual shaft. Do not lose jam nut as it becomes free from shaft. See Figure 7D-41.

b. Remove manual shaft retaining pin from case. It

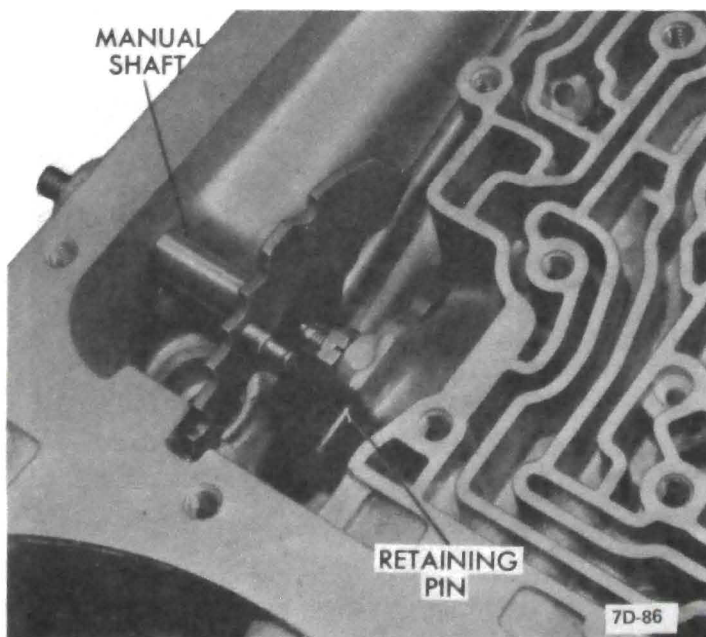


Figure 7D-41

may be necessary to bend pin to remove. See Figure 7D-41.

c. Remove detent lever from the manual shaft.

d. Remove manual shaft and jam nut from case. If necessary, remove manual shaft to case lip seal. See Figure 7D-42.

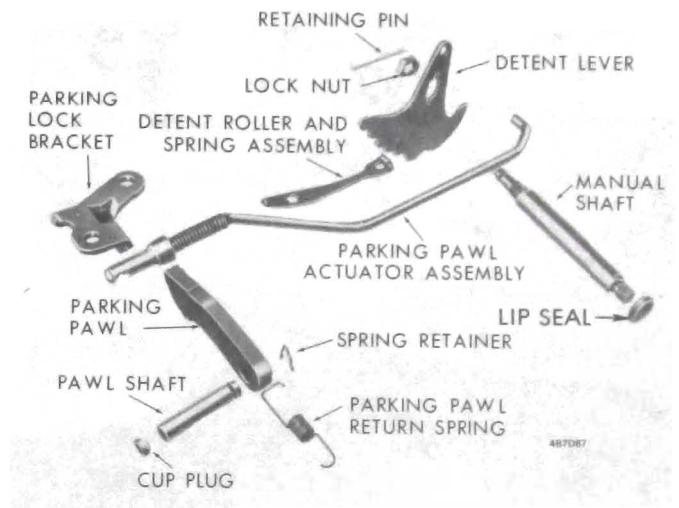


Figure 7D-42

e. Remove parking pawl actuator rod and detent lever assembly.

f. Remove attaching bolts and parking lock bracket.

g. Remove parking pawl return spring.

The following steps are to be completed only if one or more of the parts involved require replacement.

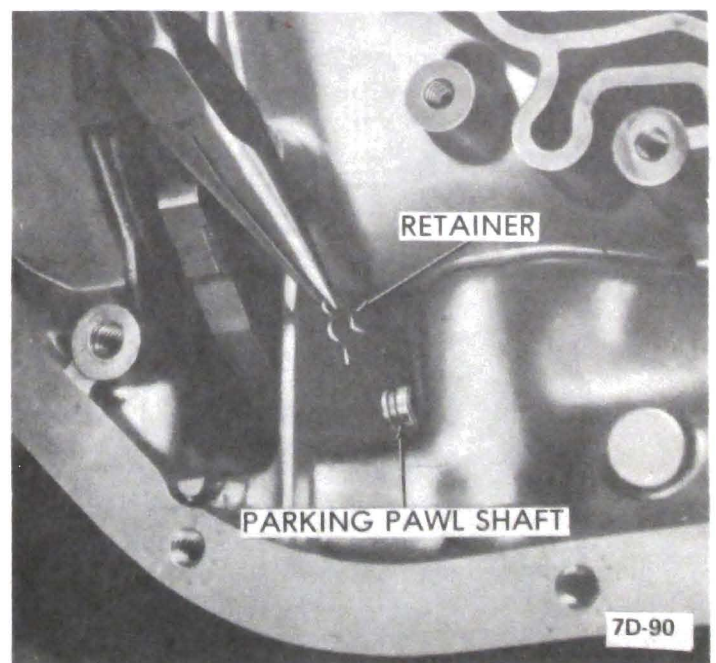


Figure 7D-43

h. Remove parking pawl shaft retainer. See Figure 7D-43.

i. Remove parking pawl shaft cup plug by inserting a screwdriver between the parking pawl shaft and the case rib, and prying outward. See Figure 7D-44.

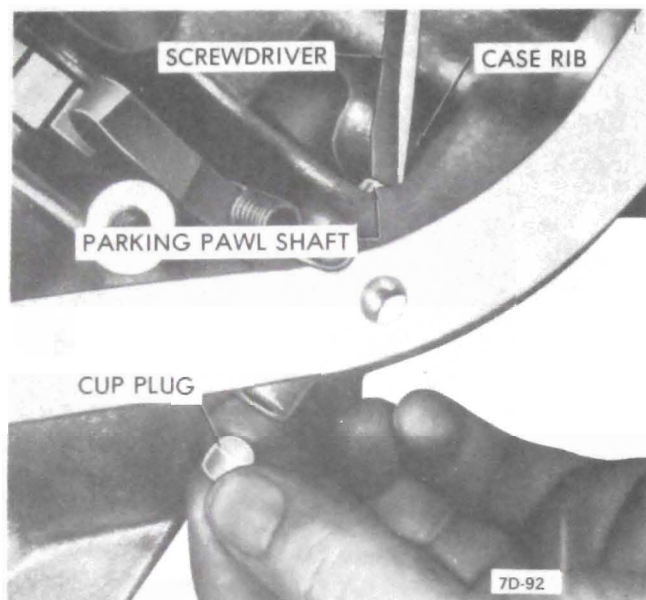


Figure 7D-44

j. Remove parking pawl shaft, and parking pawl.

REMOVAL OF REAR OIL SEAL AND EXTENSION HOUSING

The following operation can be performed with the transmission in the vehicle.

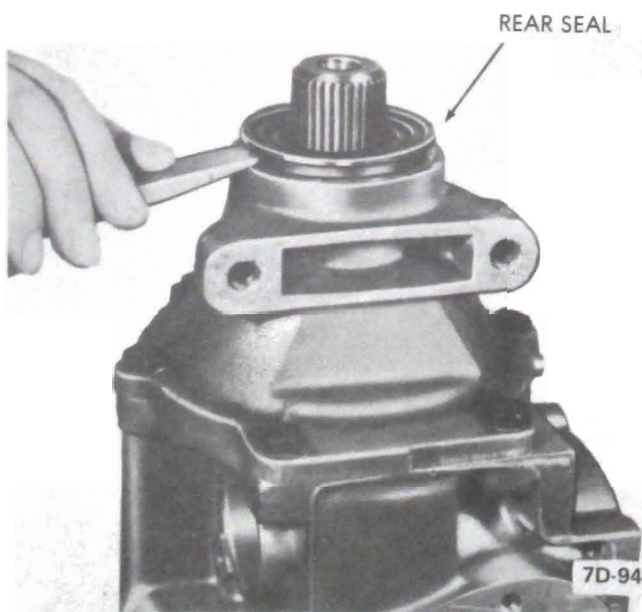


Figure 7D-45

1. If necessary to replace, pry the rear oil seal from the extension housing. See Figure 7D-45.

2. Remove extension housing to case attaching bolts.

3. Remove extension housing and extension housing to case gasket. See Figure 7D-46.

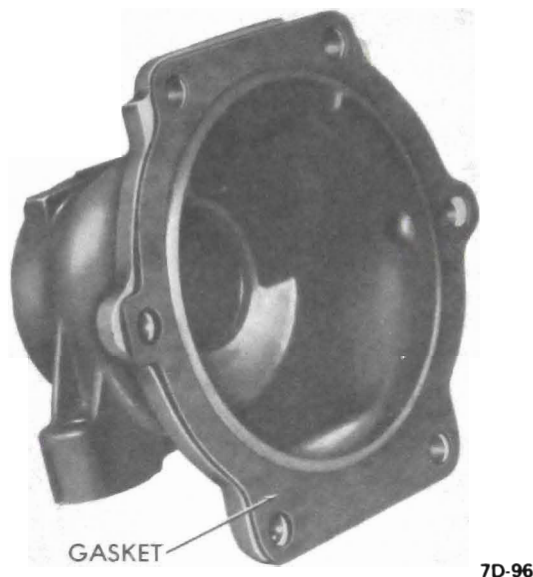


Figure 7D-46

REMOVAL OF OIL PUMP, FORWARD CLUTCH, INTERMEDIATE CLUTCH AND GEAR UNIT ASSEMBLY

1. If seal replacement is necessary, pry seal from pump. See Figure 7D-47.

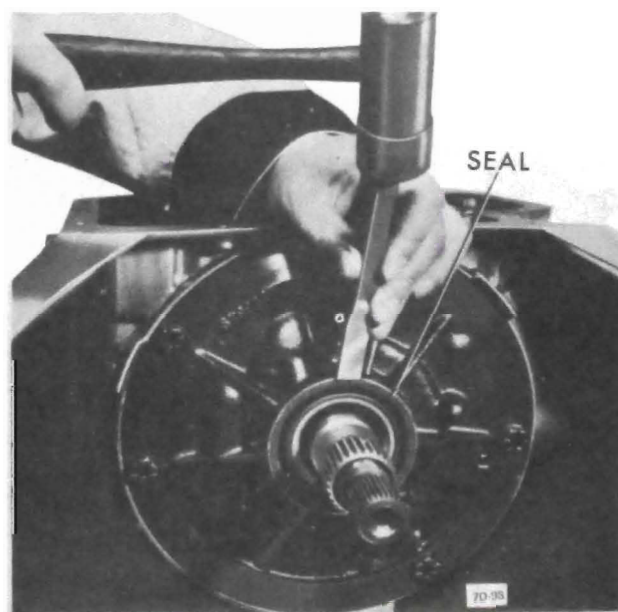


Figure 7D-47

2. Remove pump attaching bolts.

3. Install threaded slide Hammers, J-7004, into bolt holes in the pump body, tighten jam nuts and remove pump assembly from case. See Figure 7D-48.

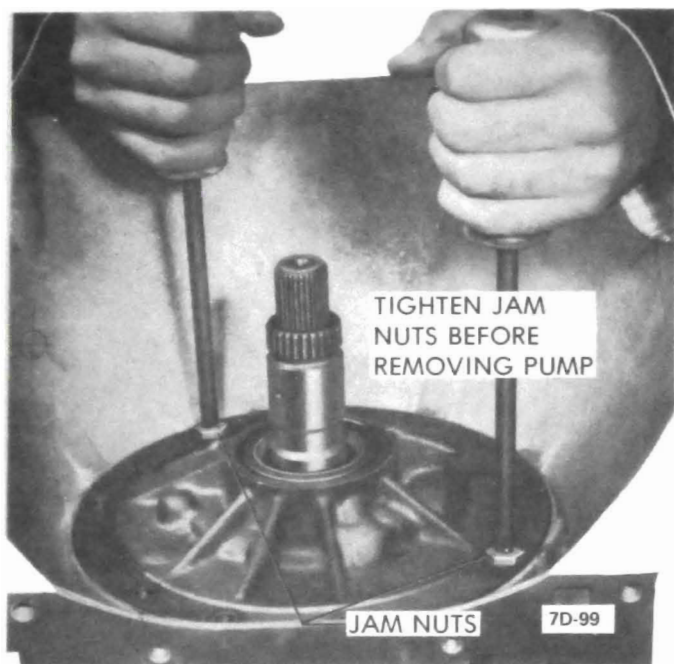


Figure 7D-48

4. Remove and discard pump to case oil seal ring and gasket.

5. Remove forward clutch and turbine shaft assembly from transmission. See Figure 7D-49.

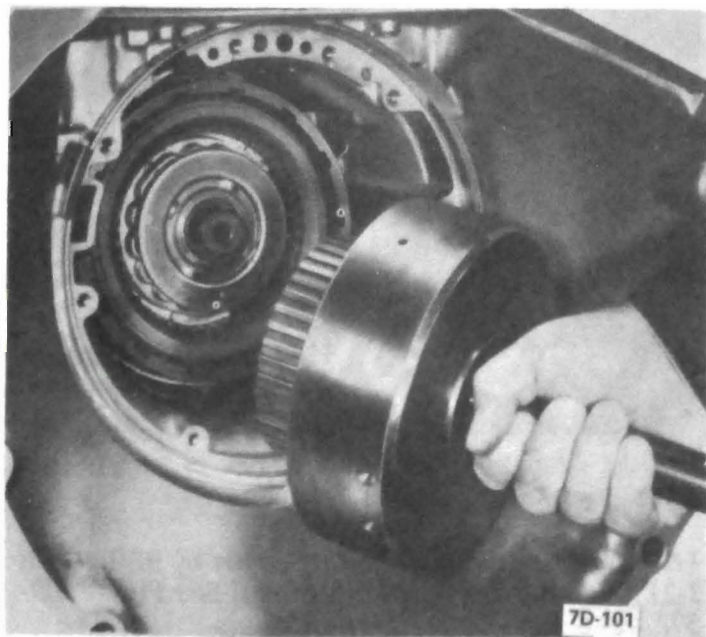


Figure 7D-49

6. Remove forward clutch hub to direct clutch housing thrust washer, if it did not come out with forward clutch housing assembly.

7. Remove direct clutch assembly. See Figure 7D-50.

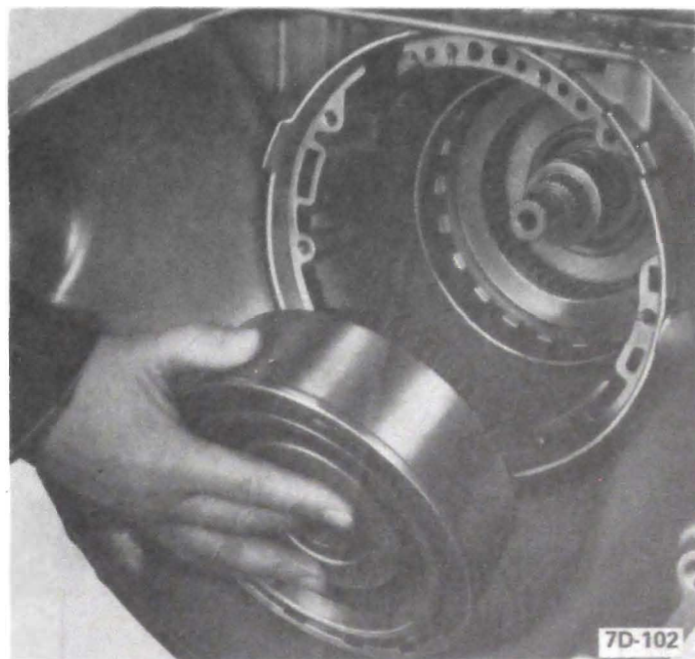


Figure 7D-50

8. Remove front band assembly.

9. Remove sun gear shaft. See Figure 7D-52.

10. Remove center support to case bolt using a 3/8" 12 point thin wall deep socket. See Figure 7D-53.

12. Remove intermediate clutch backing plate to case snap ring. See Figure 7D-54.

13. Remove intermediate clutch backing plate, 3 composition and 3 steel clutch plates. See Figure 7D-55.

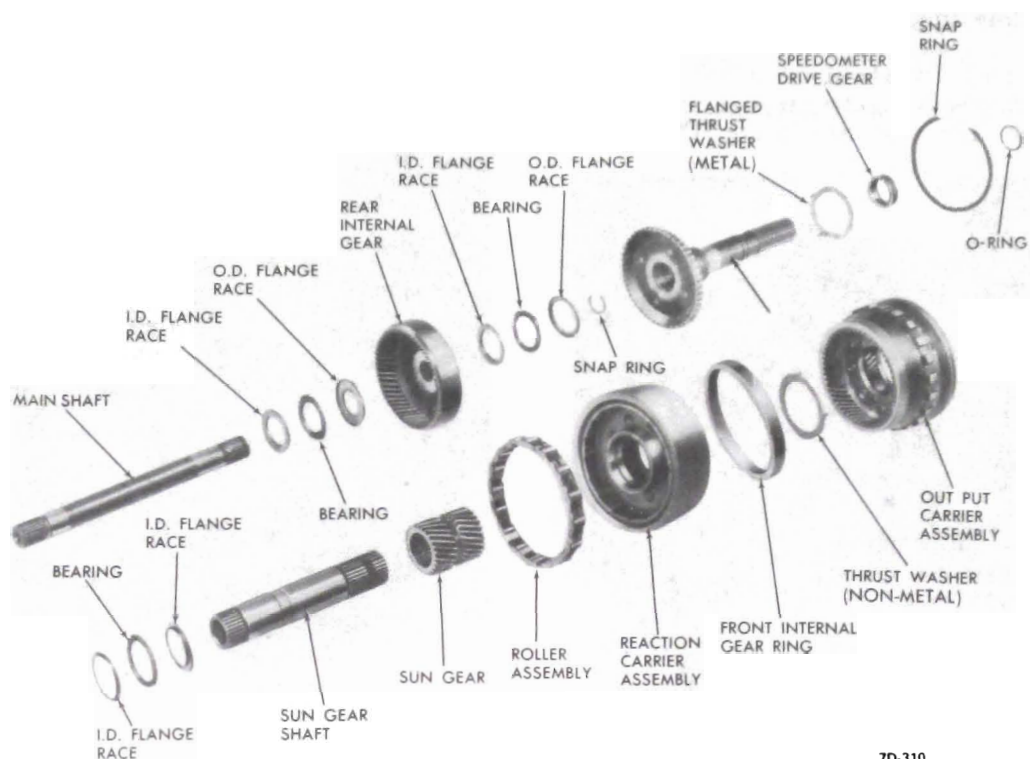
14. Inspect condition of composition and steel plates. *Do not diagnose a composition drive plate by color.*

A. Dry composition plates with compressed air and inspect the composition surface for:

1. Pitting and flaking
2. Wear
3. Glazing
4. Cracking
5. Charring
6. Chips or metal particles imbedded in lining

If a composition drive plate exhibits any of the above conditions, replacement is required.

B. Wipe steel plates dry and check for heat discolora-



7D-310

Figure 7D-51 Gear Unit Assembly

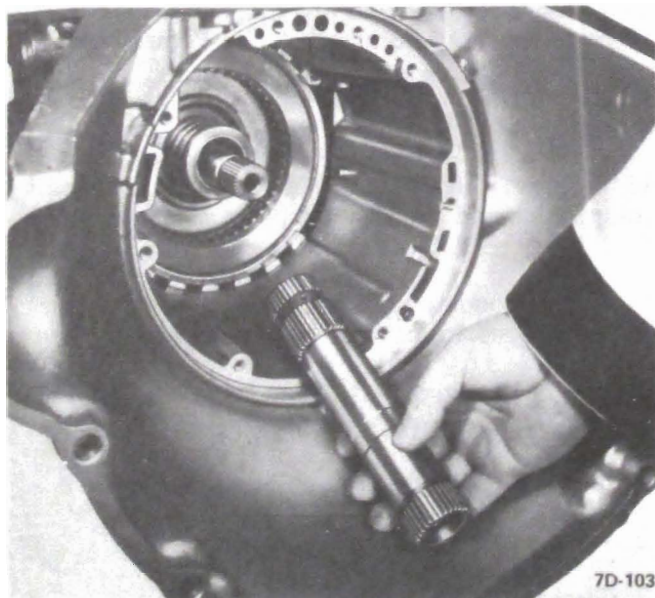


Figure 7D-52

tion. If the surface is smooth and an even color smear is indicated, the plates should be reused. If severe heat spot discoloration or surface scuffing is indicated, the plates must be replaced.

15. Remove center support to case retaining snap ring. See Figure 7D-56.

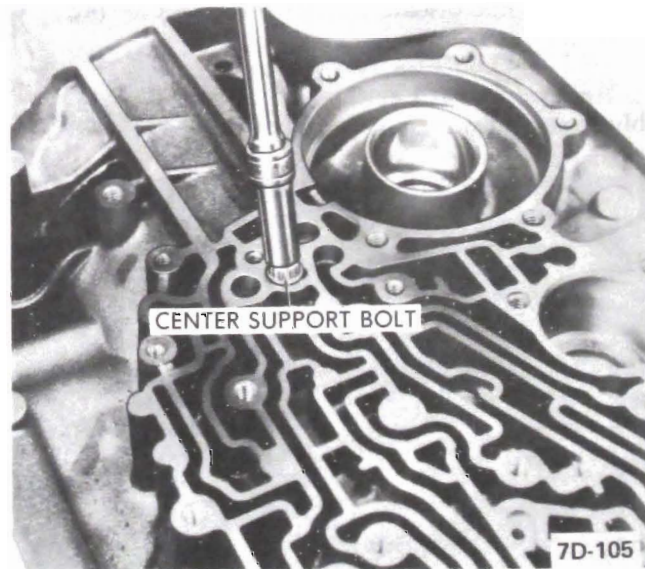


Figure 7D-53

16. Remove entire gear unit assembly by lifting with J-21795 and J-7004 Slide Hammer. See Figure 7D-57.

17. Remove output shaft to case thrust washer from rear of the output shaft.

18. Remove output shaft to yoke "O" ring if required.

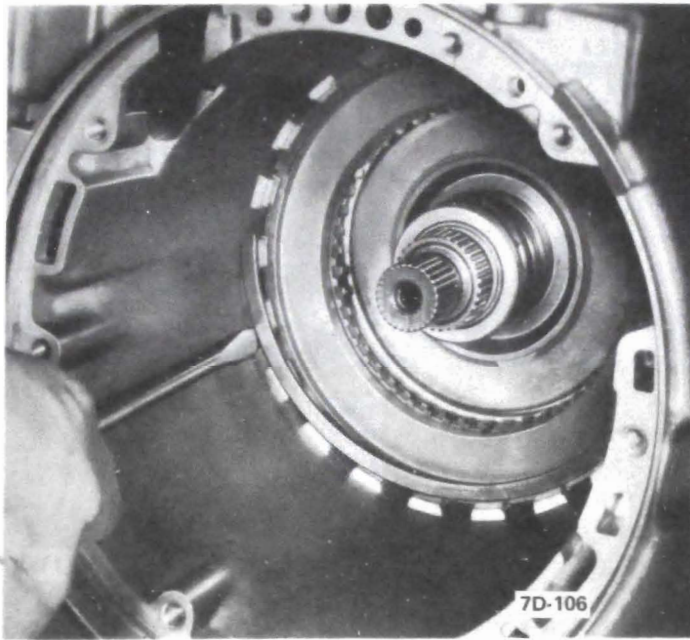


Figure 7D-54

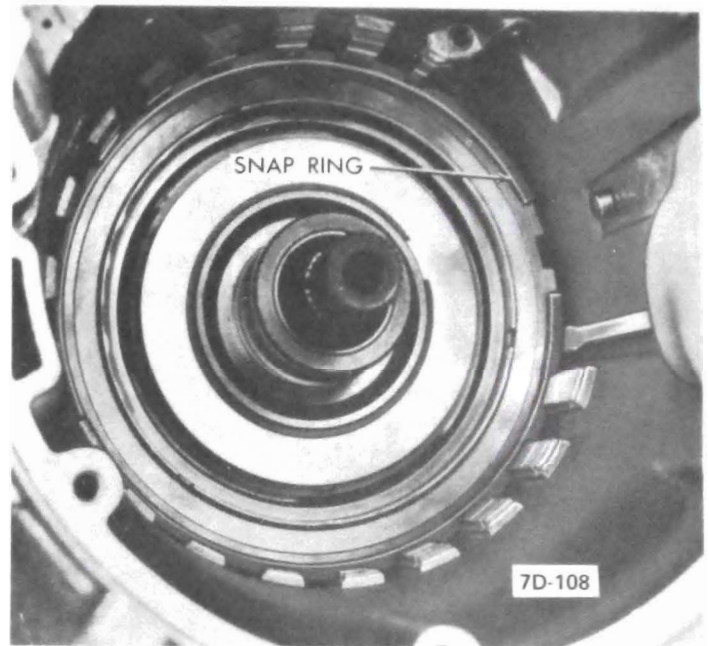


Figure 7D-56

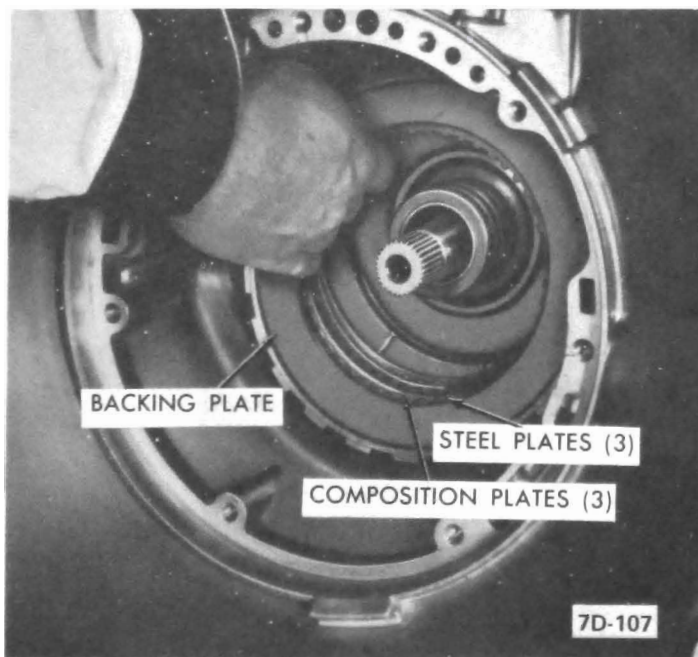


Figure 7D-55

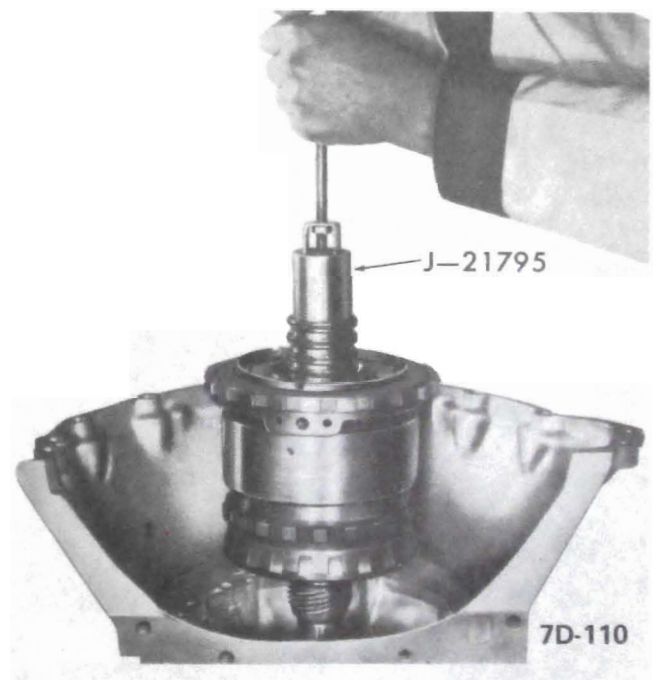


Figure 7D-57

19. Place gear unit assembly with output shaft facing down in hole in work bench. See Figure 7D-58.

20. Remove rear unit selective washer from the transmission case. See Figure 7D-59.

21. Remove support to case spacer.

22. Remove rear band assembly. See Figure 7D- 60.

GEAR UNIT ASSEMBLY

Disassembly

1. Remove center support assembly. See Figure 7D-61.

2. Remove center support to reaction carrier thrust washer.

3. Remove center support to sun gear races and

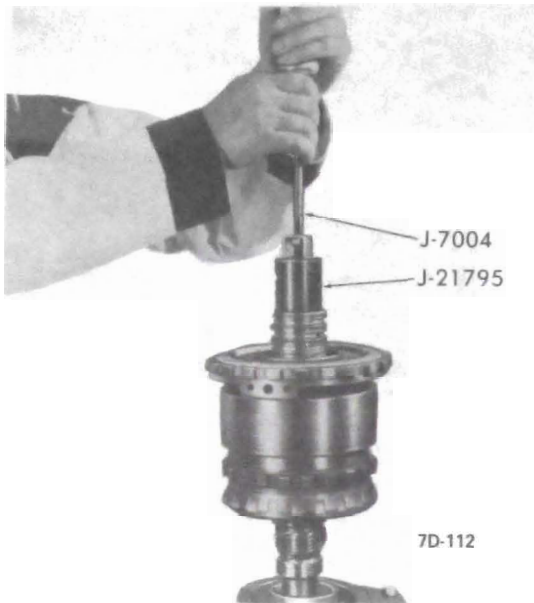


Figure 7D-58

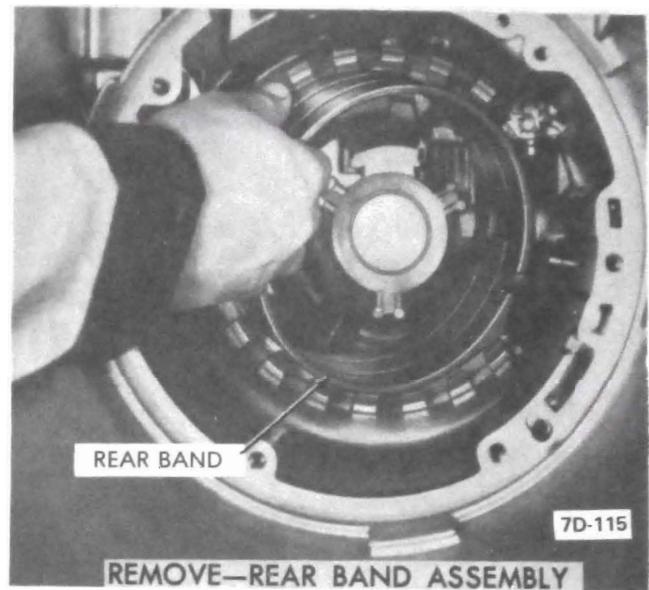


Figure 7D-60

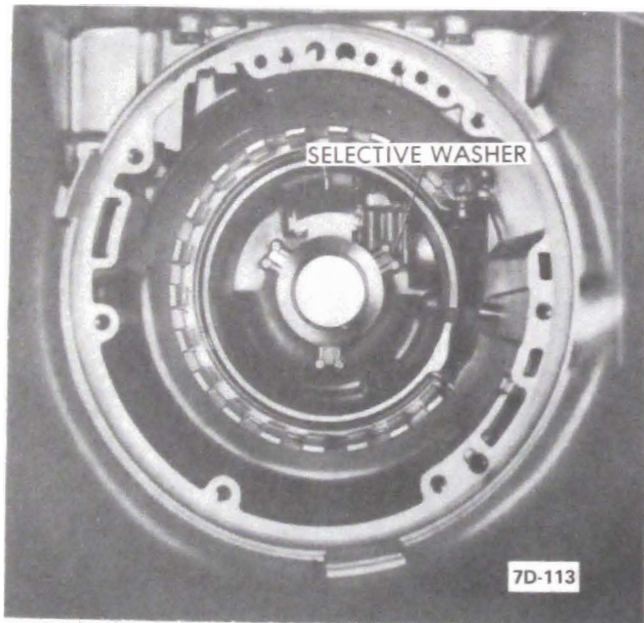


Figure 7D-59

thrust bearing. One of races may have been removed with the center support. See Figure 7D-62.

4. Remove reaction carrier and roller clutch assembly. See Figure 7D-63.

5. Remove front internal gear ring from output carrier assembly. See Figure 7D-63.

6. Remove sun gear. See Figure 7D-64.

7. Remove reaction carrier to output carrier thrust washer.

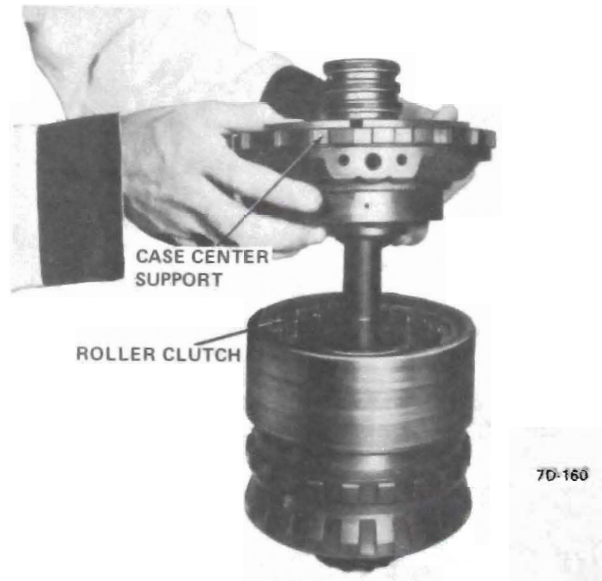


Figure 7D-61

8. Turn assembly over and place mainshaft through hole in work bench.

9. Remove output shaft to rear carrier snap ring. See Figure 7D-65.

10. Remove output shaft.

If replacement of the speedometer drive gear is necessary, remove in the following manner:

a. *Steel Speedometer Gear:* Install steel Speedometer Gear Removing Tool J-21427 and J-9578, on output shaft and remove speedometer drive gear. See Figure 7D-66.

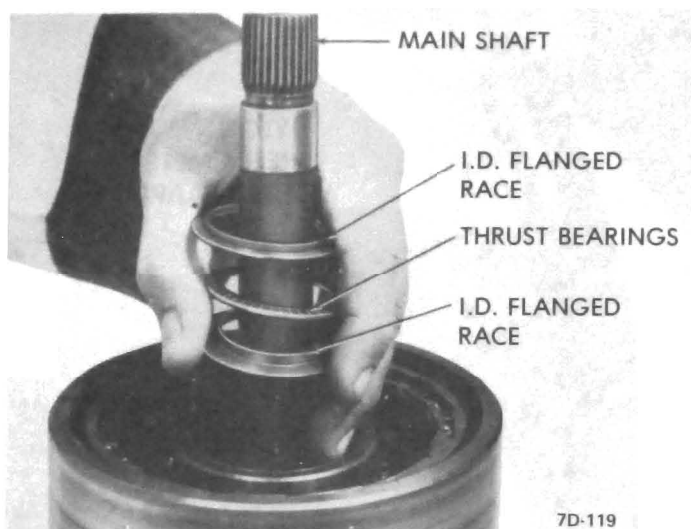


Figure 7D-62

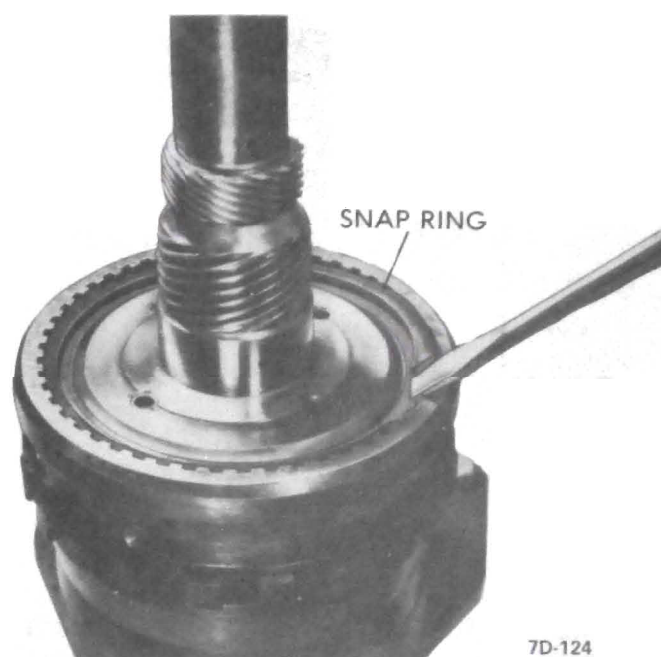


Figure 7D-65

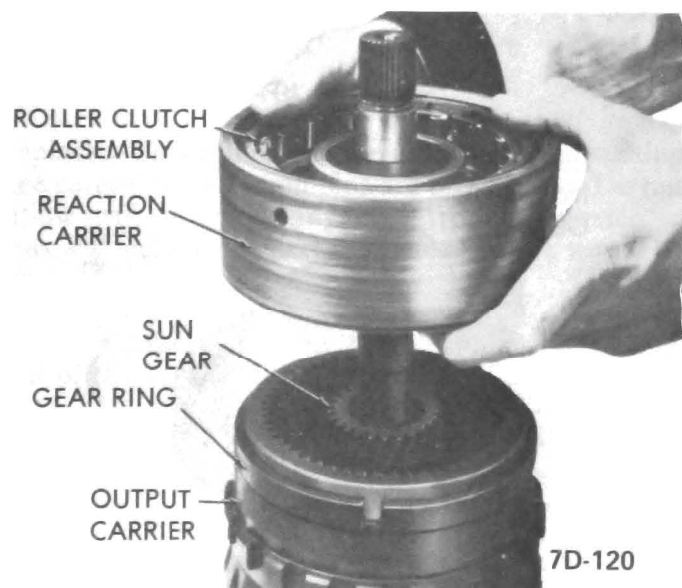


Figure 7D-63

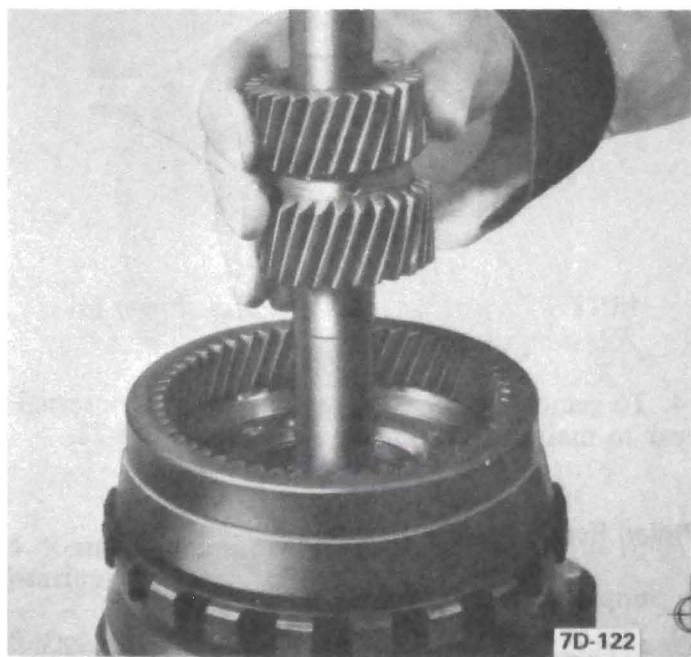


Figure 7D-64

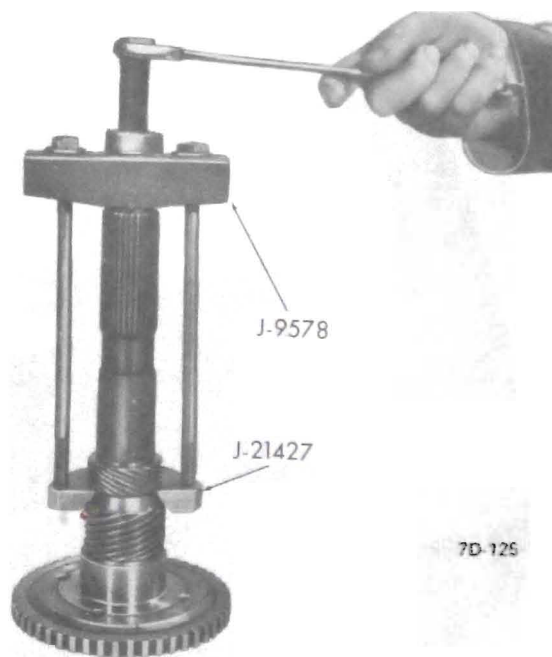


Figure 7D-66

b. Install new steel speedometer drive gear. Press to $5\frac{21}{32}$ " for "BS" and "BB" models, and $11\frac{15}{32}$ " for "BC", and "BT" models. See Figure 7D- 67.

c. *Nylon Speedometer Drive Gear:* Depress retaining clip and slide nylon gear off output shaft. See Figure 7D-69.

d. To install, place retaining clip (square end toward flange of shaft) into hole in output shaft. See Figure 7D-69.

e. Align slot in speedometer drive gear with retaining clip and install gear. See Figure 7D-70.

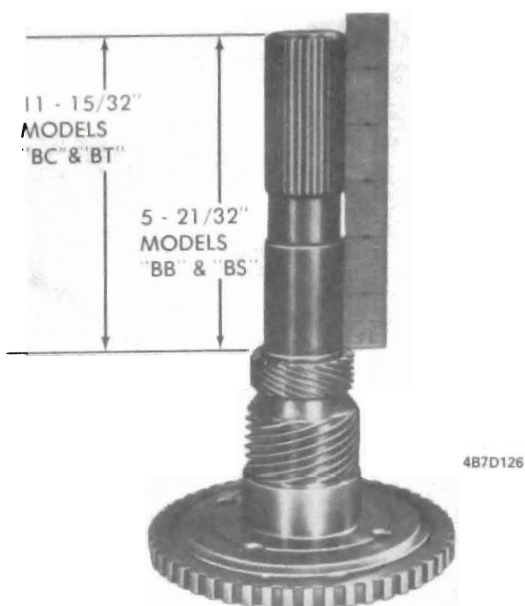


Figure 7D-67

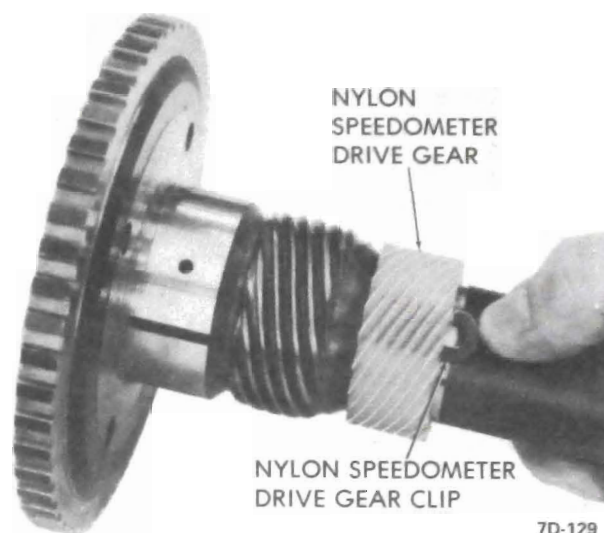


Figure 7D-70

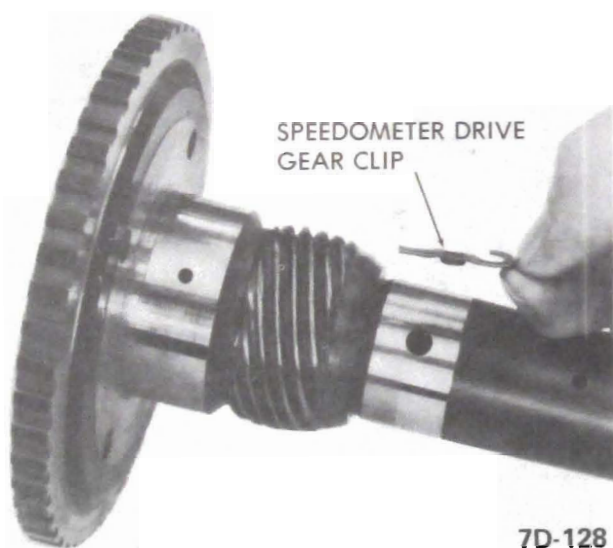


Figure 7D-69



Figure 7D-71

The nylon speedometer drive gear is installed at the factory only. All service replacement gears are steel. When a service gear is required, discard the retaining clip and proceed as described in step b.

11. Remove output shaft to rear internal gear thrust bearing and two (2) races.

12. Remove rear internal gear and mainshaft. See Figure 7D-71.

13. Remove rear internal gear to sun gear thrust bearing and two (2) races. Do not drop bearings.

NOTE: *Thrust Bearings location shown in Reassembly Section.*

14. To remove mainshaft, remove the rear internal gear to mainshaft snap ring. See Figure 7D-72.

Pinion Replacement Procedure

1. Support carrier assembly on its front face.

2. Using a 1/2 inch diameter drill, remove the stake marks from the end of the pinion pin, or pins, to be

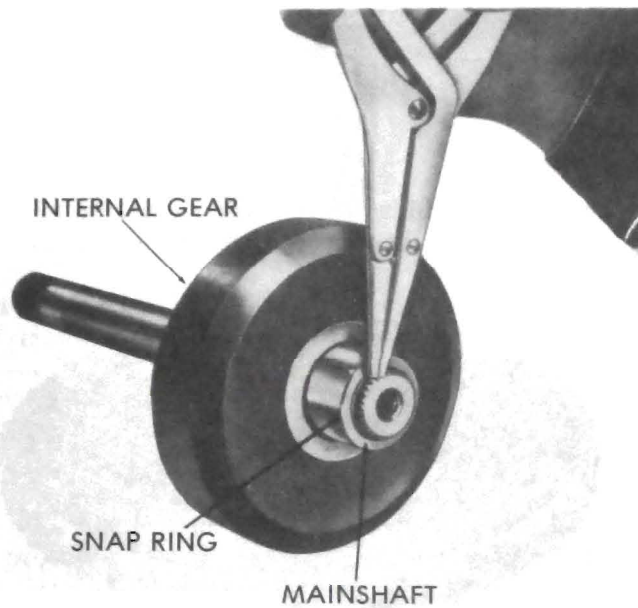


Figure 7D-72

replaced. This will reduce the probability of cracking the carrier when pinion pins are pressed out. Do not allow drill to remove any stock from the carrier, as this will weaken the part and future failure would be probable.

3. Using a tapered punch, drive or press the pinions out of the carrier. See Figure 7D-73.

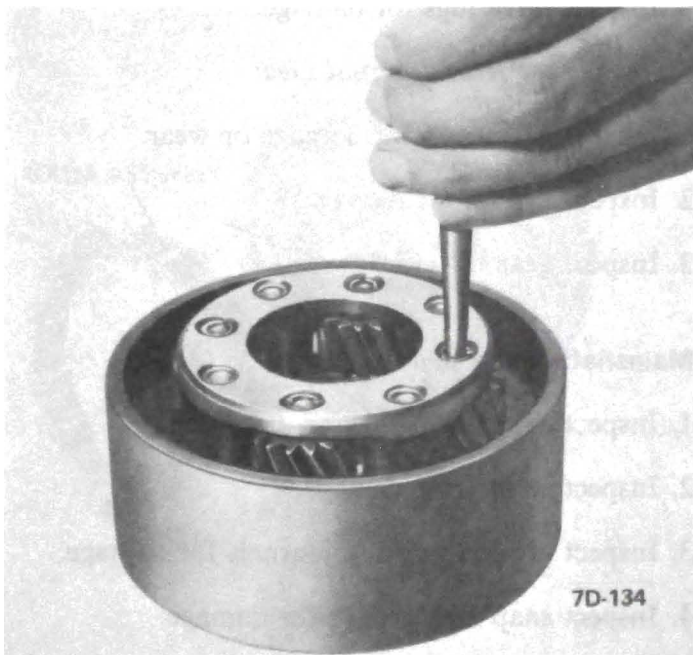


Figure 7D-73

4. Remove pinions, thrust washers and needle roller bearings.

5. Inspect pinion pocket thrust faces for burrs and remove if present.

6. Install eighteen (18) needle bearings into each pinion, using petroleum jelly to hold the bearings in place. Use a pinion pin as a guide. See Figure 7D- 74.



Figure 7D-74

7. Place a bronze and steel thrust washer on each side of pinion so steel washer is against pinion, hold them in place with petroleum jelly.

8. Place pinion assembly in position in the carrier and install a pilot shaft through the rear face of the assembly to hold the parts in place.

9. Drive a new pinion pin into place while rotating pinion from the front, being sure that the headed end is flush or below the face of the carrier. See Figure 7D-75.



Figure 7D-75

10. Place a large punch in a bench vise to be used as an anvil while staking the opposite end of the pinion pin in three places. Both ends of the pinion pins must lie below the face of the carrier or interference may occur. See Figure 7D-76.



Figure 7D-76

Inspection*Output Shaft*

1. Inspect bushing for wear or galling. If replacement is necessary proceed as follows:

a. Thread Tool J-21465-16 into bushing using Slide Hammer J-2619, remove. See Figure 7D-77.

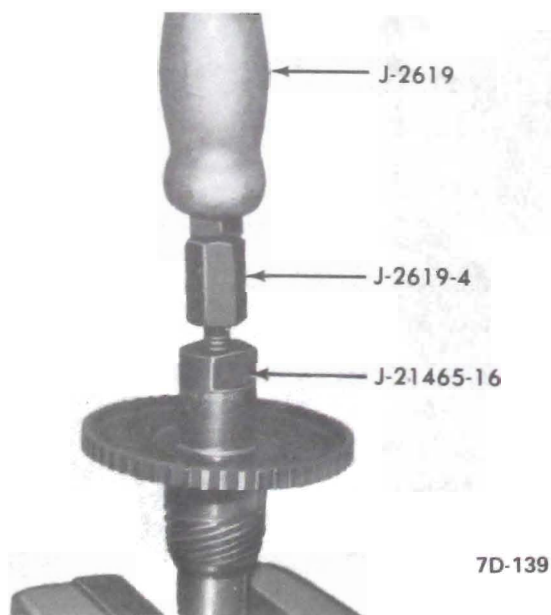


Figure 7D-77

b. Using Tool J-21465-1 install bushing. See Figure 7D-78.

2. Inspect bearing and thrust washer surfaces for damage.

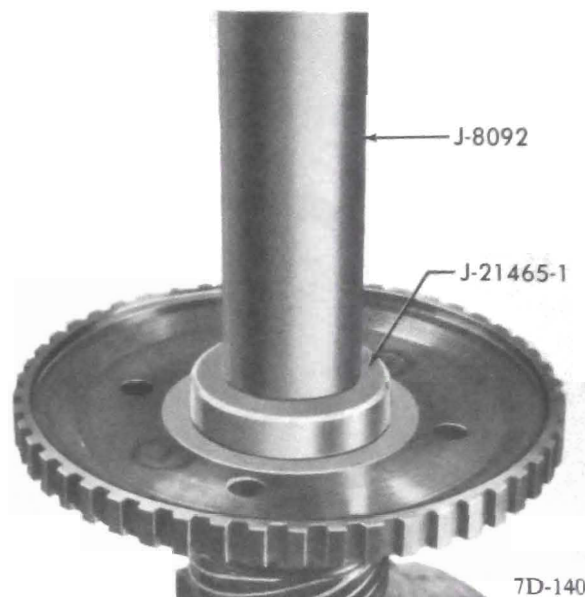


Figure 7D-78

3. Inspect governor drive gear for rough or damaged teeth.

4. Inspect splines for damage.

5. Inspect orificed cup plug in the lubrication passage.

6. Inspect drive lugs for damage.

Inspection of Rear Internal Gear

1. Inspect gear teeth for damage or wear.

2. Inspect splines for damage.

3. Inspect gear for cracks.

Mainshaft-Inspection

1. Inspect shaft for cracks or distortion.

2. Inspect splines for damage.

3. Inspect ground bushing journals for damage.

4. Inspect snap ring groove for damage.

5. Be sure oil lubrication holes are open.

Inspection of Sun Gear

1. Inspect gear teeth for damage or wear.

2. Inspect splines for damage.

3. Inspect the gear for cracks.

Inspection of Sun Gear Shaft

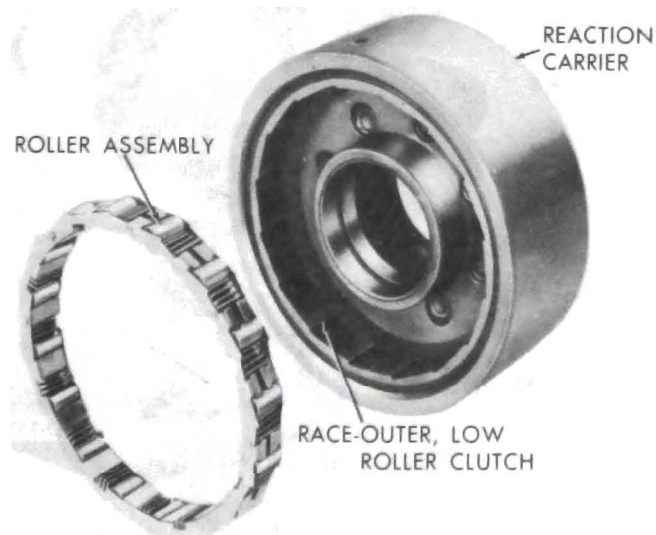
1. Inspect shaft for cracks or splits.
2. Inspect splines for damage.
3. Inspect bushings for scoring or galling. If replacement is necessary proceed as follows:
 - a. Thread J-21465-15 into Sun Gear Shaft. Thread Slide Hammer J-2619 into remover. Clamp slide hammer handle into vise. Grasp sun gear shaft and remove bushing.
 - b. Using Installer J-21465-5 and Drive Handle 8092, install new bushing.

This procedure applies to bushings in both ends of shaft.

4. Inspect ground bushing journals for damage.
5. Be sure the oil lubrication hole is open.

Inspection of reaction Carrier, Roller Clutch and Output Carrier Assembly

1. Inspect band surface on reaction carrier for signs of burning or scoring.
2. Inspect roller clutch outer race for scoring or wear. See Figure 7D-79.



7D-141

Figure 7D-79

3. Inspect thrust washer surfaces for signs of scoring or wear.
4. Inspect bushing for damage. If bushing is damaged the reaction carrier must be replaced.

5. Inspect reaction carrier pinions for damage, rough bearings or excessive tilt.

6. Check pinion end play. Pinion end play should be .009" - .024". See Figure 7D-80.

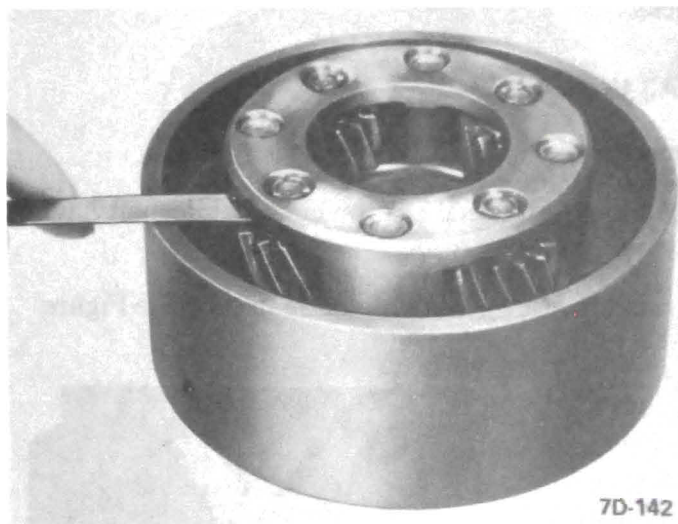


Figure 7D-80

7. Inspect roller clutch for damaged members.
8. Inspect roller cage and retaining springs for damage.
9. Inspect front internal gear for damaged teeth.
10. Inspect output carrier pinions for damage, rough bearings or excessive tilt.



7D-143

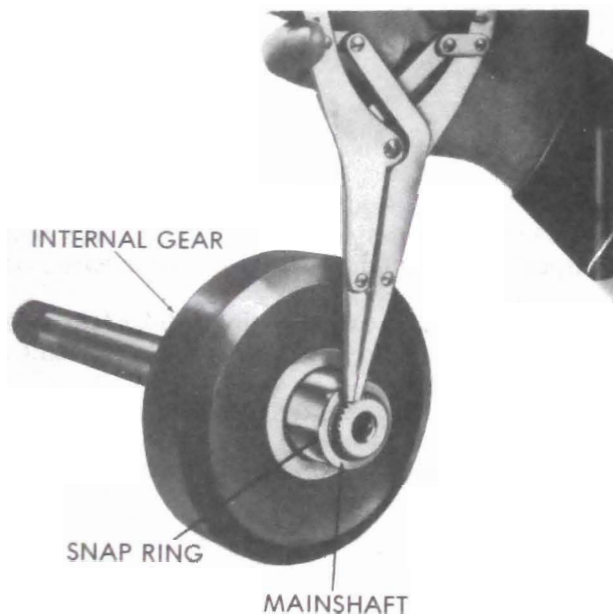
Figure 7D-81

11. Check pinion end play. Pinion end play should be .009" - .024". See Figure 7D-81.
12. Inspect parking pawl lugs for cracks or damage.
13. Inspect output locating splines for damage.
14. Inspect front internal gear ring for flaking or cracks.

GEAR UNIT ASSEMBLY

Reassembly

1. Install rear internal gear on end of mainshaft having snap ring groove.
2. Install internal gear retaining snap ring. See Figure 7D-82.

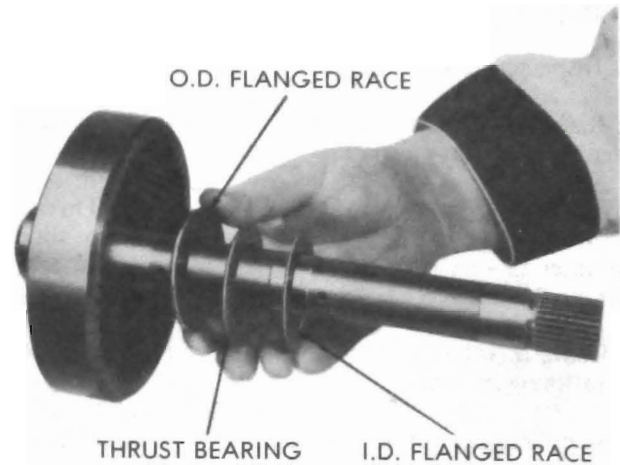


7D-133

Figure 7D-82

3. Install sun gear to internal gear thrust races and bearings against the inner face of the rear internal gear as follows: and retain with petroleum jelly. See Figure 7D-83.

- a. Place large race against the internal gear with flange facing forward or up.
 - b. Place thrust bearing against race.
 - c. Place small race against bearing with inner flange facing into the bearing or down.
4. Install output carrier over the mainshaft so that the pinions mesh with rear internal gear.



7D-146

Figure 7D-83

5. Place above portion of "build-up" through hole in bench so that mainshaft hangs downward. See Figure 7D-84.



7D-131

Figure 7D-84

6. Install rear internal gear to output shaft thrust races and bearing as follows; and retain with petroleum jelly. See Figure 7D-86.

- a. Place small diameter race against internal gear with center flange facing up.
- b. Place bearing on race.

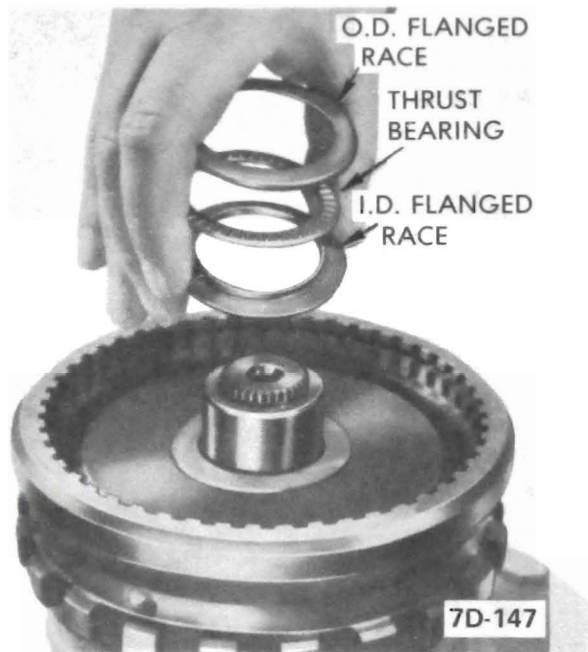


Figure 7D-86

c. Place second race on bearing with outer flange cupped over bearing.

7. Install output shaft into output carrier assembly. See Figure 7D-87.

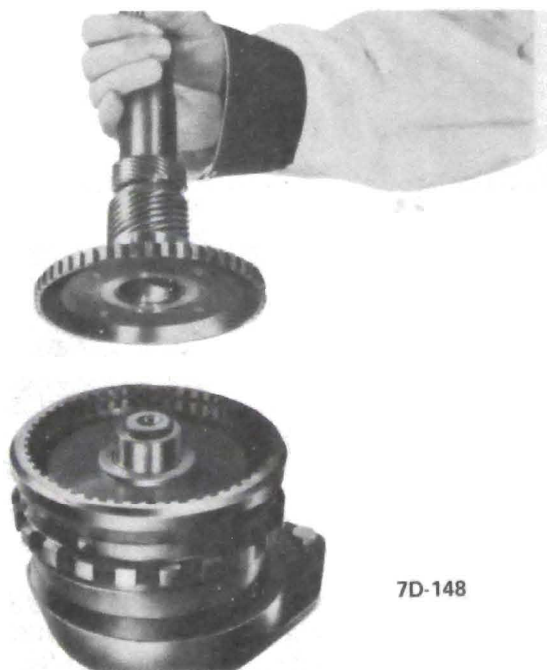


Figure 7D-87

8. Install output shaft to output carrier snap ring. See Figure 7D-88.

9. Lubricate with petroleum jelly and install output shaft to case metal thrust washer and turn unit over. See Figure 7D-89.

10. Install output shaft "O" ring seal.

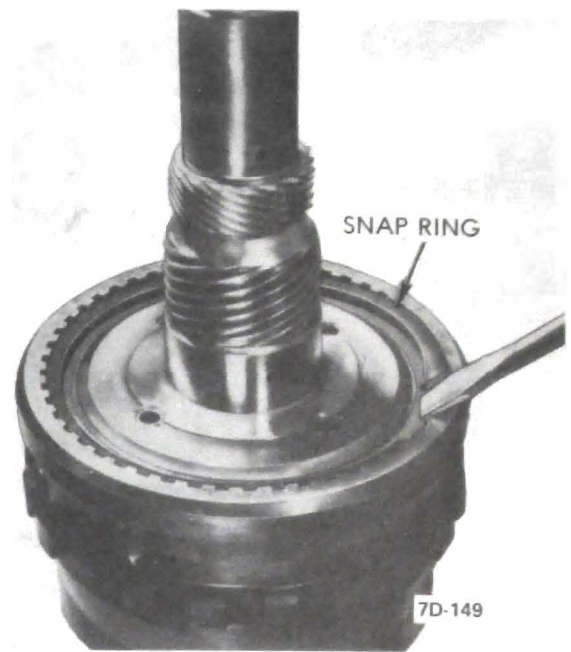


Figure 7D-88

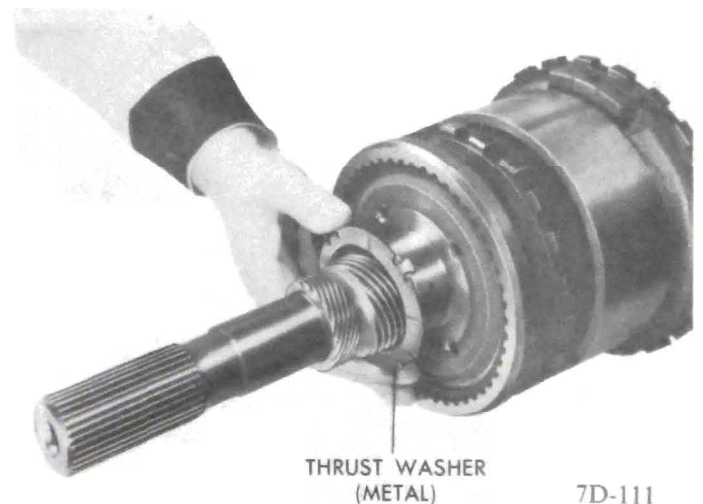


Figure 7D-89

11. Lubricate with petroleum jelly and install reaction carrier to output carrier thrust washer with tabs facing down in pockets. See Figure 7D-90.

12. Install sun gear splines with inner chamfer down. See Figure 7D-91.

13. Install gear ring over output carrier. See Figure 7D-92.

14. Install sun gear shaft with longest splined- end first.

15. Install reaction carrier. See Figure 7D-93.

When a new output carrier and/or reaction carrier is being installed, and if the front internal gear ring prevents assembly of the carriers, replace the front internal gear with the SERVICE ring.

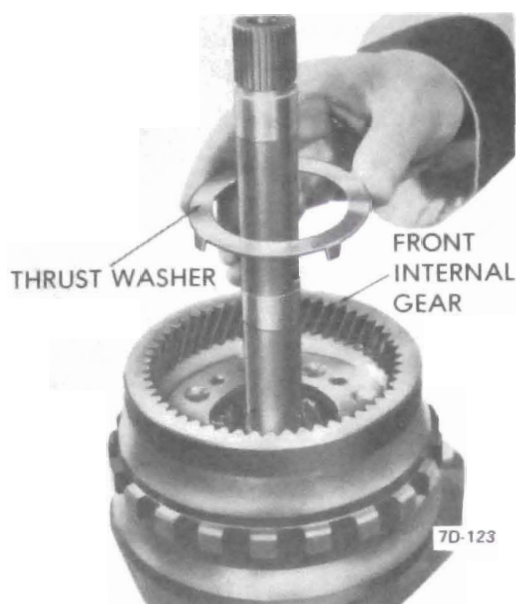


Figure 7D-90

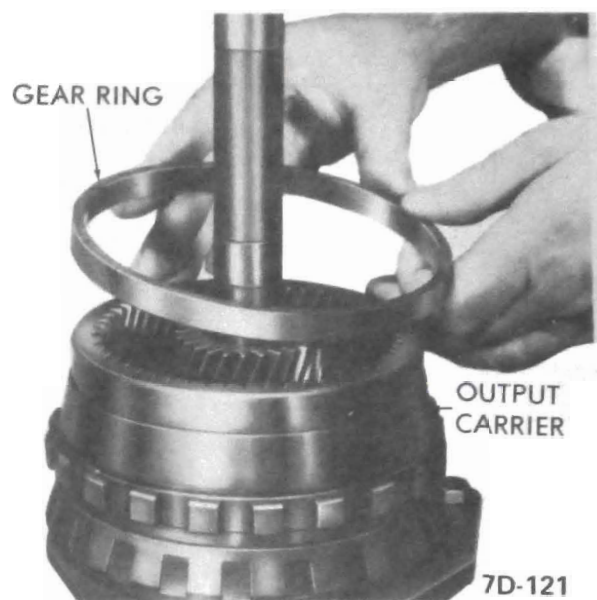


Figure 7D-92



Figure 7D-91



Figure 7D-93

16. Lubricate with petroleum jelly and install center support to sun gear thrust races and bearing as follows: See Figure 7D-94.

- a. Install large race, center flange up over the sun gear shaft.
- b. Install thrust bearing against race.
- c. Install second race, center flange up.

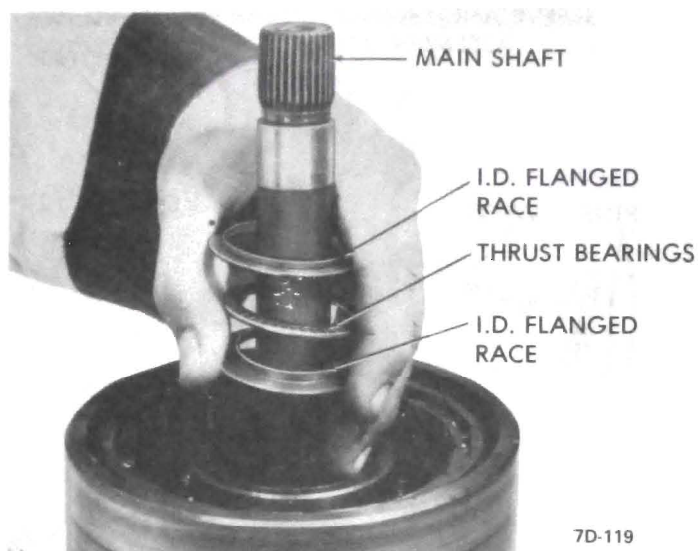
17. Lubricate with petroleum jelly and install center support to reaction carrier thrust washer into recess in center support. See Figure 7D-95.

18. Install rollers in roller clutch cage, by compressing energizing spring with forefinger and inserting roller from outer side. See Figure 7D-96.

Make certain that energizing springs are not distorted, and that curved end of leaf of springs are positioned against rollers.

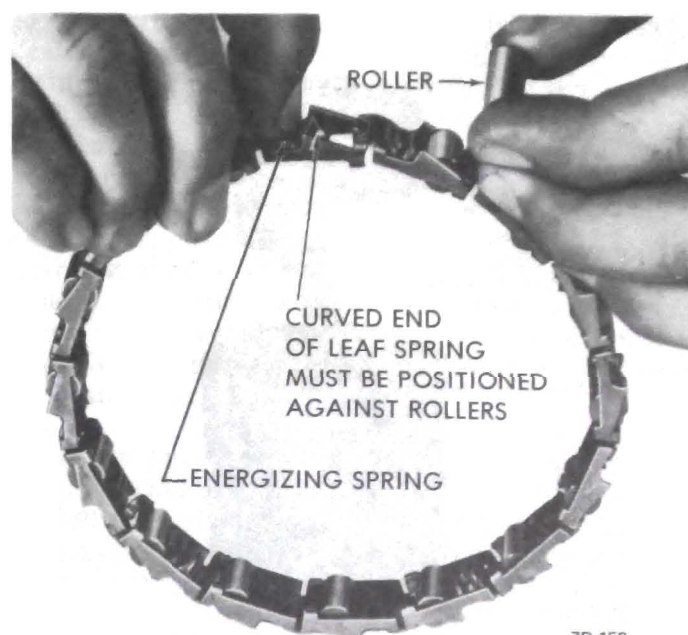
19. Install roller clutch assembly into reaction carrier. See Figure 7D-97.

20. Install center support into roller clutch in reaction carrier. See Figure 7D-98.



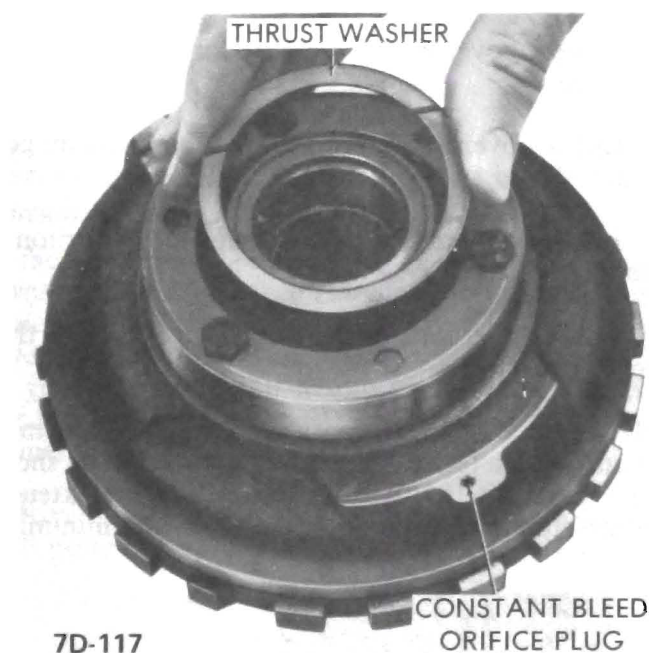
7D-119

Figure 7D-94



7D-158

Figure 7D-96



7D-117

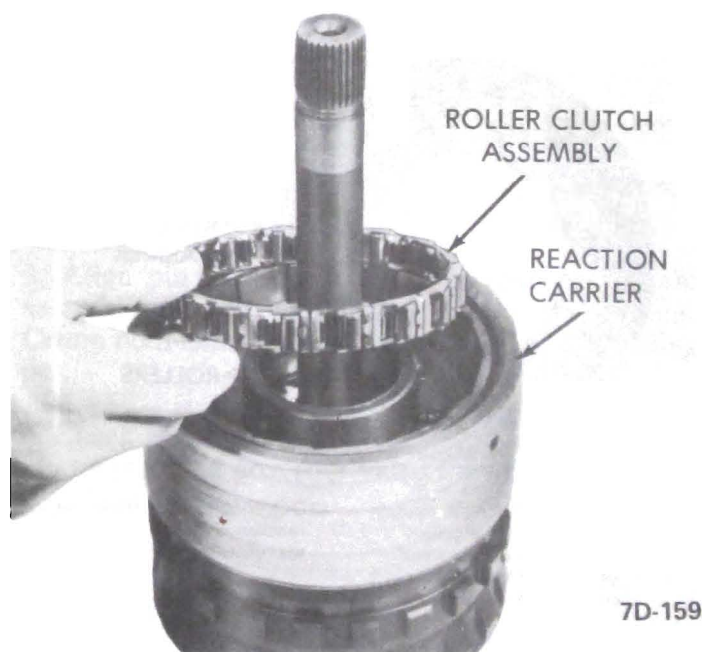
Figure 7D-95

With reaction carrier held, center support should turn counterclockwise only. See Figure 7D-99.

GOVERNOR ASSEMBLY

All components of the governor assembly, with the exception of the driven gear, are a select fit and each assembly is calibrated. The governor, including the driven gear, is serviced as a complete assembly. However, the driven gear can also be serviced separately.

It is necessary to disassemble the governor assembly in order to replace the driven gear. Disassembly may also be necessary due to foreign material causing improper operation. In such cases, proceed as follows:



7D-159

Figure 7D-97

Disassembly (See Figure 7D-100)

1. Cut off one end of each governor weight pin and remove pins, governor thrust cap, governor weights, and springs. Governor weights are interchangeable from side to side and need not be identified.
2. Remove governor valve from governor sleeve. Be careful not to damage valve.
3. Perform the following inspections and replace governor driven gear, if necessary.

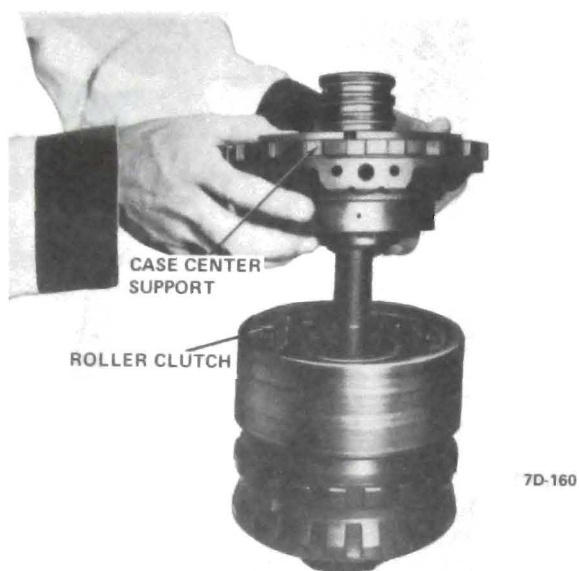


Figure 7D-98

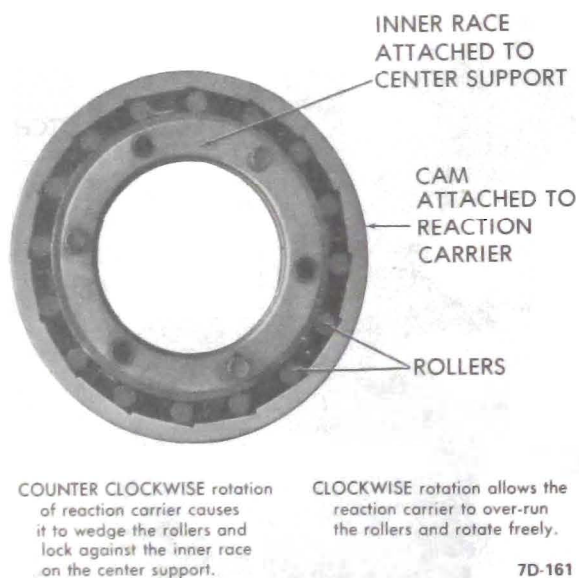


Figure 7D-99

Inspection

1. Wash all parts in cleaning solvent, air dry and blow out all passages.
2. Inspect governor sleeve for nicks, burrs, scoring or galling.
3. Check governor sleeve for free operation in bore of transmission case.
4. Inspect governor valve for nicks, burrs, scoring or galling.

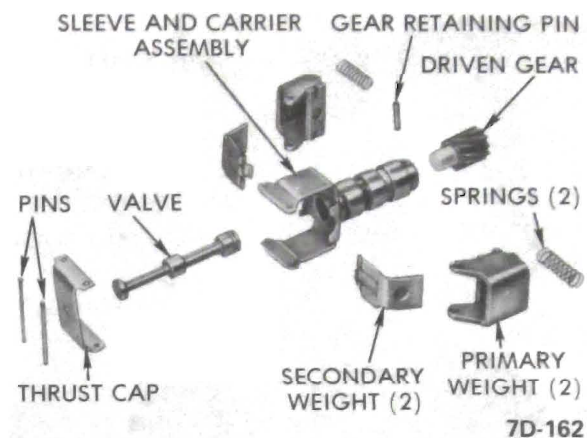


Figure 7D-100

5. Check governor valve for free operation in bore of governor sleeve.
6. Inspect governor driven gear for nicks, burrs, or damage.
7. Check governor driven gear for looseness on governor sleeve.
8. Inspect governor weight springs for distortion or damage.
9. Check governor weights for free operation in their retainers.
10. Check valve opening at entry (.020 inch minimum) with a feeler gage, holding governor as shown in Figure 7D-101, with governor weights extended completely outward. For exhaust (.020" minimum)

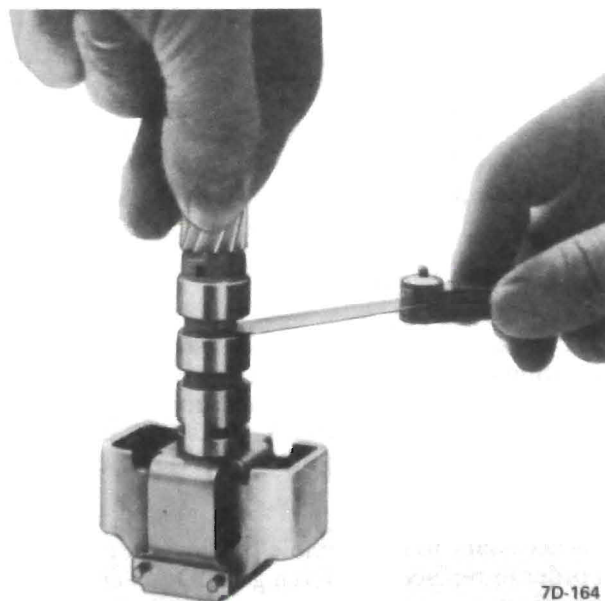
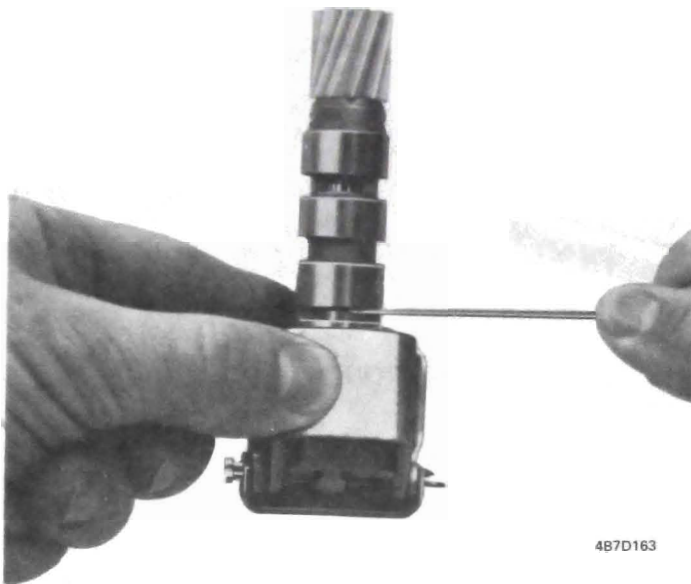


Figure 7D-101

governor weights must be completely inward. See Figure 7D-103. (400 THM only)



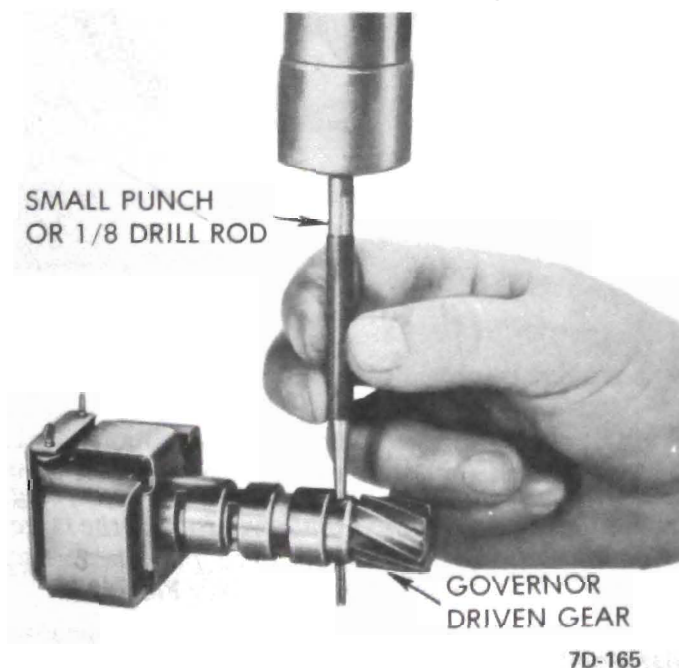
487D163

Figure 7D-103

Governor Driven Gear Replacement (All Transmissions)

To facilitate governor repair in the field, governor driven gear and replacement pins are available for service use. The service package contains a nylon driven gear, two governor weight retaining pins and one governor gear retainer split pin. Replacement of gear must be performed with care in the following manner:

1. Drive out governor gear retaining split pin using small punch or 1/8" drill rod. See Figure 7D-104.



7D-165

Figure 7D-104

2. Support governor on 7/64 inch plates installed in exhaust slots of governor sleeve, place in press, and with a long punch, press gear out of sleeve.
3. Carefully clean governor sleeve of chips that remain from original gear installation.
4. Support governor on 7/64 inch plates, installed in exhaust slots of sleeve, position new gear in sleeve and, with a suitable socket, press gear into sleeve until nearly seated. Carefully remove any chips that may have shaved off gear hub and press gear in until it bottoms on shoulder.
5. A new pin hole must be drilled through sleeve and gear. Locate hole position 90 degrees from existing hole, center punch, and then while supporting governor in press, drill new hole through sleeve and gear using a standard (1/8 inch) drill.
6. Install retaining pin.
7. Wash governor assembly thoroughly to remove any chips that may have collected.

Assembly (See Figure 7D-100)

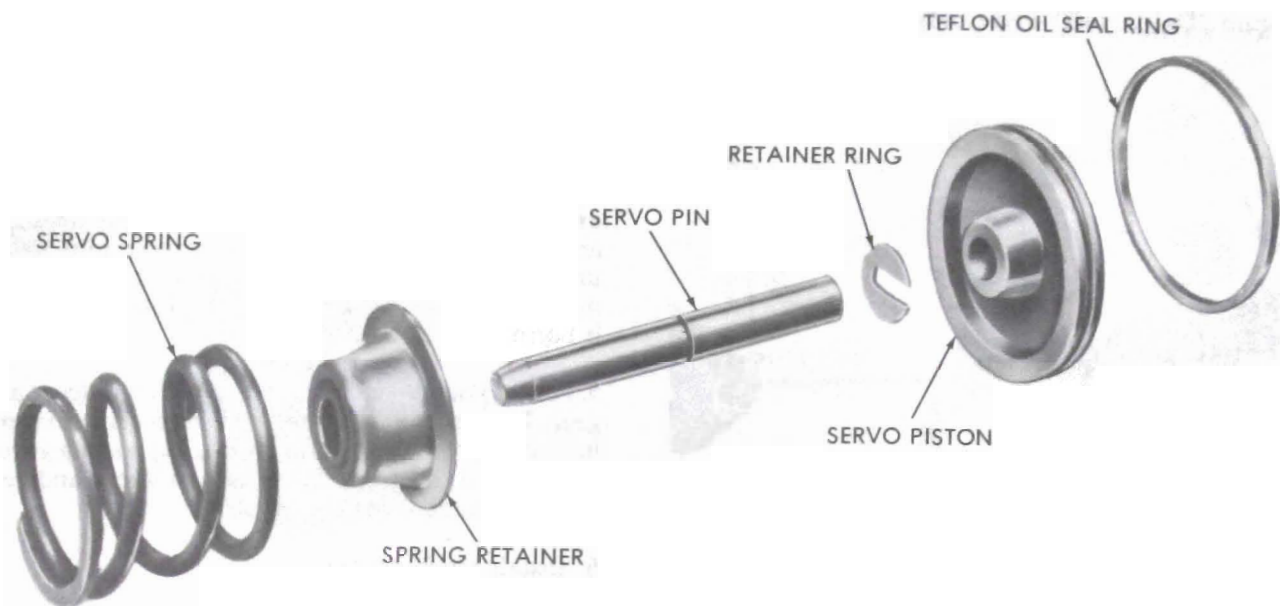
1. Install governor valve in bore of governor sleeve.
2. Install governor weights and springs, and thrust cap on governor sleeve.
3. Align pin holes in thrust cap, governor weight assemblies and governor sleeve, and install new pins. Crimp both ends of pin to prevent them from falling out.
4. Check governor weight assemblies for free operation on pins and governor valve for free operation in governor sleeve.

FRONT SERVO INSPECTION

See Figure 7D-105. Do not remove the teflon oil seal ring from the front servo piston, unless the oil seal ring requires replacement. For Service, the oil seal ring will be aluminum.

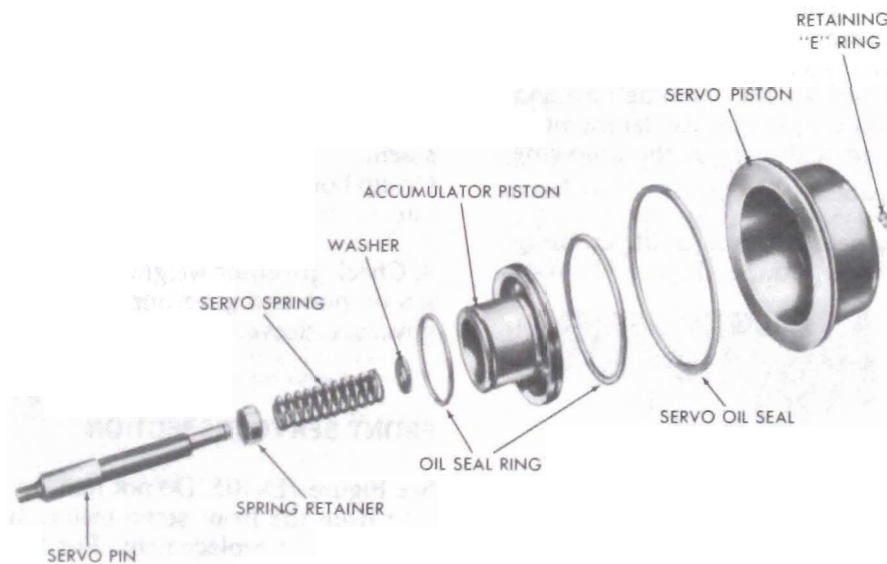
The spring retainer, servo pin, retainer ring, and servo piston are not interchangeable with the pre 1971 parts.

1. Inspect servo pin for scores and cracks. See Figure 7D-105.
2. Inspect piston and oil seal ring for damage.
3. Check fit of servo pin in piston.



7D-166

Figure 7D-105 Front Servo Assembly



7D-169

Figure 7D-106 Rear Servo Assembly

REAR SERVO ASSEMBLY

See Figure 7D-106. Do not remove the teflon oil seal rings from the rear accumulator piston, unless the oil seal rings require replacement.

If the teflon inner oil seal ring (small diameter) requires replacement for service, use the aluminum oil seal ring, Part No. 8623671.

The rear accumulator piston, large diameter ring groove depth, is machined shallower to take the large teflon oil seal ring. If this requires replacement, use only the teflon oil seal ring, Part No. 8627153.

Disassembly

1. Remove rear accumulator piston from rear servo piston.

2. Remove "E" ring retaining rear servo piston to band apply pin. See Figure 7D-106.

3. Remove rear servo piston and seal from band apply pin. See Figure 7D-106.

Inspection

1. Inspect freeness of accumulator ring in piston grooves.

2. Inspect fit of band apply pin in servo piston.

3. Inspect band apply pin for scores and cracks.

Reassembly

1. Install spring retainer, spring and washer on band apply pin. See Figure 7D-106.

If new pin is required, install here.

2. Install band apply pin retainer, spring and washer into bore of servo piston and secure with "E" ring. See Figure 7D-107.

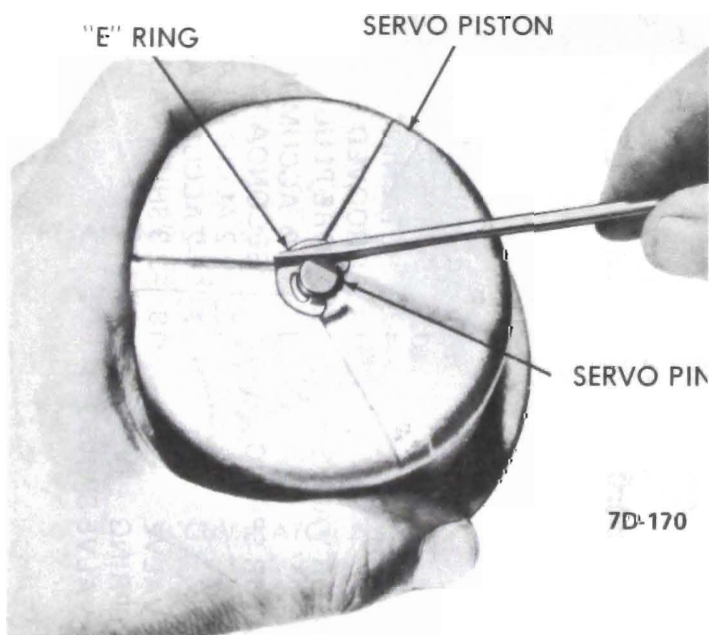


Figure 7D-107

3. Install oil seal ring on servo piston, if removed.

4. Install outer and inner oil rings on accumulator piston, if removed, and assemble into bore of servo piston.

VALVE BODY ASSEMBLY (See Figure 7D-108)

Disassembly

1. Position valve body assembly with cored face up and servo pocket nearest operator.

2. Remove manual valve from upper bore.

3. Install special Tool J-21885 on accumulator piston and remove retaining "E" ring. See Figure 7D-109.

4. Remove front accumulator piston and spring. See Figure 7D-110.

5. On the right side, top bore, remove 1-2 valve train as follows: (Models BC and BS)

Remove the retaining pin, 1-2 modulator bushing, 1-2 regulator valve, 1-2 regulator spring, 1-2 detent valve, and 1-2 shift valve. See Figure 7D-108.

b. Models "BT" and "BB", remove the retaining pin, 1-2 modulator bushing, 1-2 modulator valve spring, 1-2 modulator valve, and 1-2 shift valve. See Figure 7D-108.

6. From the next bore down, remove the retaining pin; 2-3 modulator bushing, and 2-3 modulator valve spring, 2-3 modulator valve, 3-2 intermediate spring and the 2-3 valve. See Figure 7D-108.

7. From the next bore down, remove the retaining roll pin, bore plug, spacer, spring and 3-2 valve. See Figure 7D-108.

8. At the other end of the assembly, top bore, remove the retaining pin and bore plug. See Figure 7D-108.

9. Remove the detent valve, detent regulator valve, spring and spacer. See Figure 7D-108.

10. From the next bore down, remove the 1-2 accumulator valve train as follows:

a. Models "BC", and "BT", remove the 1-2 accumulator grooved retaining pin, bore plug, 1-2 accumulator valve, and 1-2 accumulator primary spring. See Figure 7D-108.

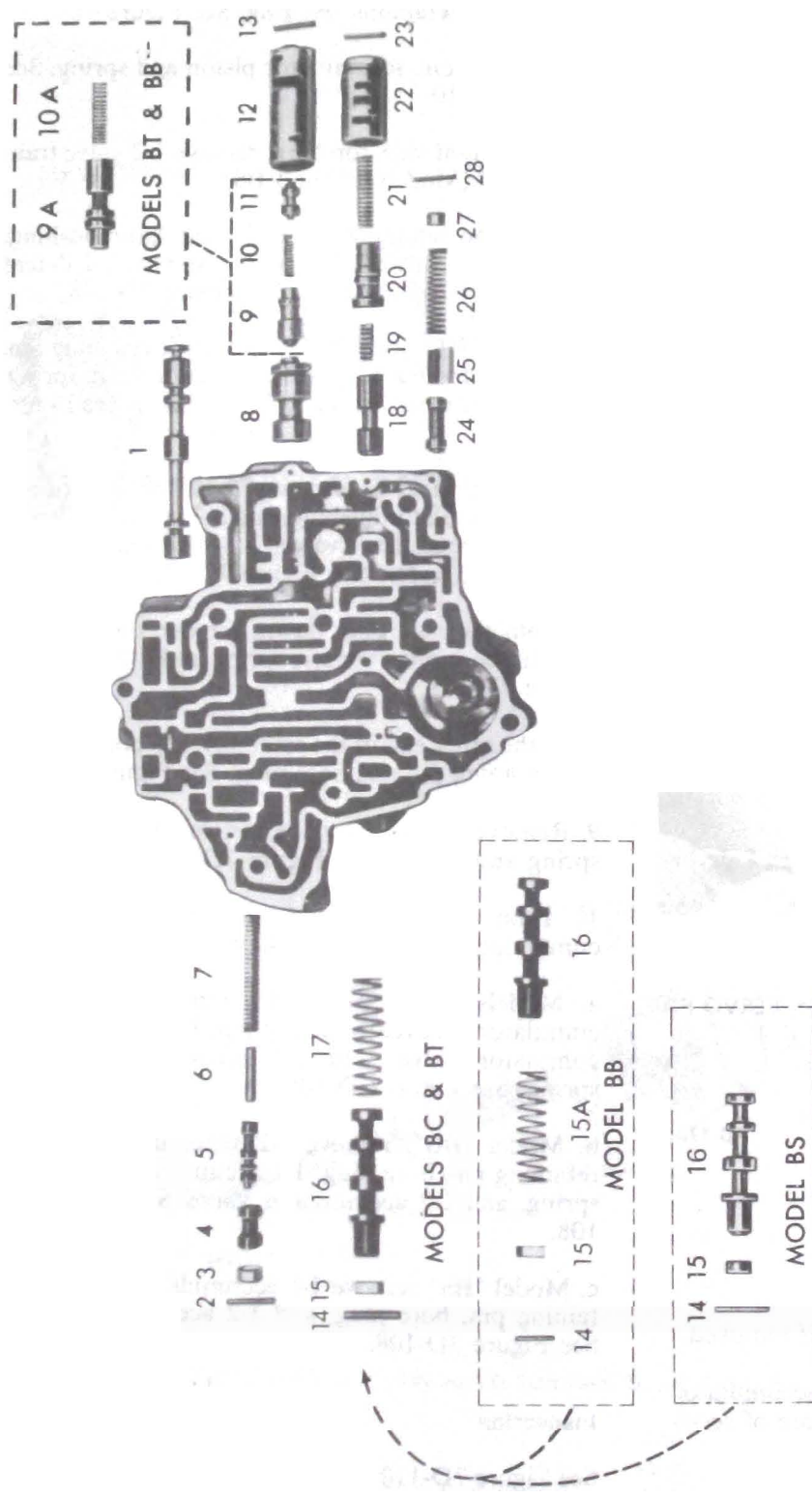
b. Model "BB", remove 1-2 accumulator grooved retaining pin, bore plug, 1-2 accumulator secondary spring, and 1-2 accumulator valve. See Figure 7D-108.

c. Model "BS" remove 1-2 accumulator grooved retaining pin, bore plug, and 1-2 accumulator valve. See Figure 7D-108.

Inspection

See Figure 7D-110. Do not remove the teflon oil seal ring from the front accumulator piston, unless the oil seal ring requires replacement. For service, the oil seal ring will be cast iron.

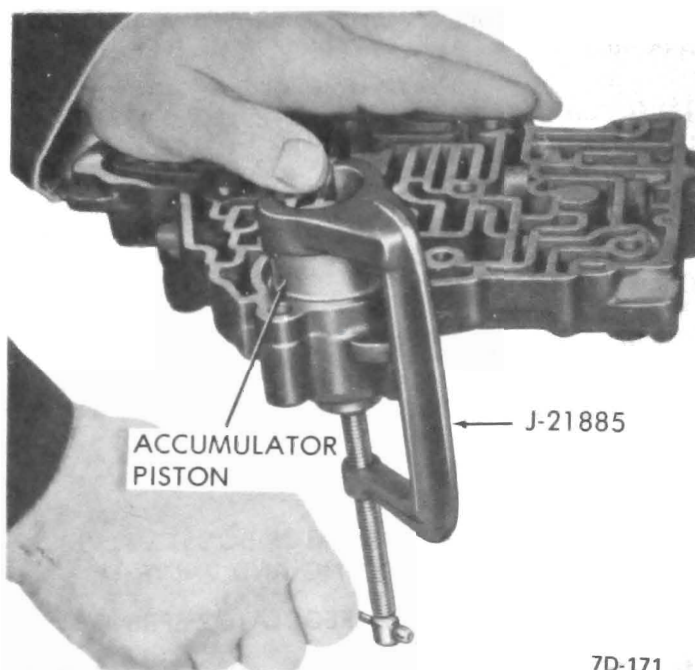
The front accumulator piston is not interchangeable with the pre 1971-72-73 piston.



- | | |
|---------------------------------------|-----------------------------|
| 1. MANUAL VALVE | 19. 3-2 INTERMEDIATE SPRING |
| 2. RETAINING PIN | 20. 2-3 MODULATOR VALVE |
| 3. BORE PLUG | 21. 2-3 VALVE SPRING |
| 4. DETENT VALVE | 22. 2-3 MODULATOR BUSHING |
| 5. DETENT REGULATOR VALVE | 23. RETAINING PIN |
| 6. SPACER PIN | 24. 3-2 VALVE |
| 7. DETENT REGULATOR SPRING | 25. SPACER PIN |
| 8. 1-2 SHIFT VALVE | 26. 3-2 VALVE SPRING |
| 9. 1-2 DETENT VALVE | 27. BORE PLUG |
| 9A. 1-2 MODULATOR VALVE | 28. RETAINING PIN |
| 10. 1-2 REGULATOR SPRING | |
| 10A. 1-2 MODULATOR VALVE SPRING | |
| 11. 1-2 REGULATOR VALVE | |
| 12. 1-2 MODULATOR BUSHING | |
| 13. RETAINING PIN | |
| 14. GROOVED RETAINING PIN | |
| 15. BORE PLUG | |
| 15A. 1-2 ACCUMULATOR SECONDARY SPRING | |
| 16. 1-2 ACCUMULATOR VALVE | |
| 17. 1-2 ACCUMULATOR PRIMARY SPRING | |
| 18. 2-3 SHIFT VALVE | |

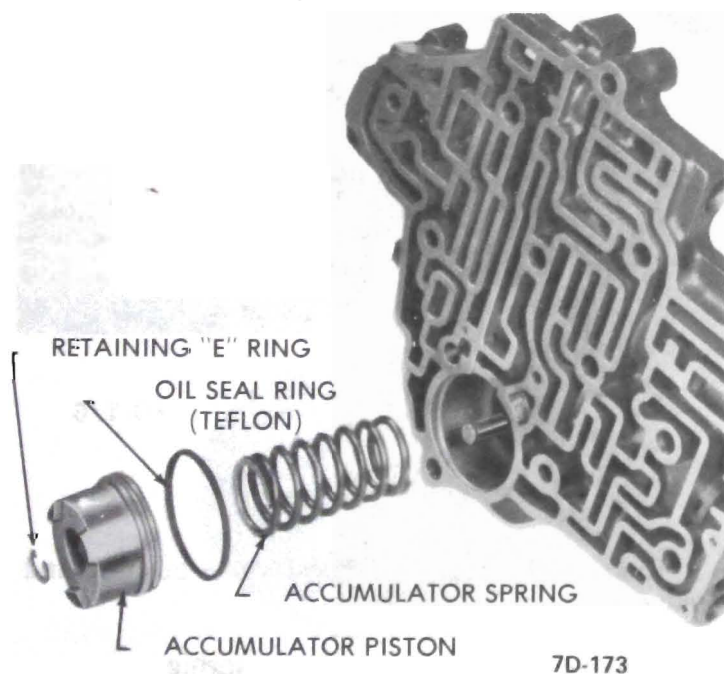
487D312

Figure 7D-108 Valve Body Assembly



7D-171

Figure 7D-109



7D-173

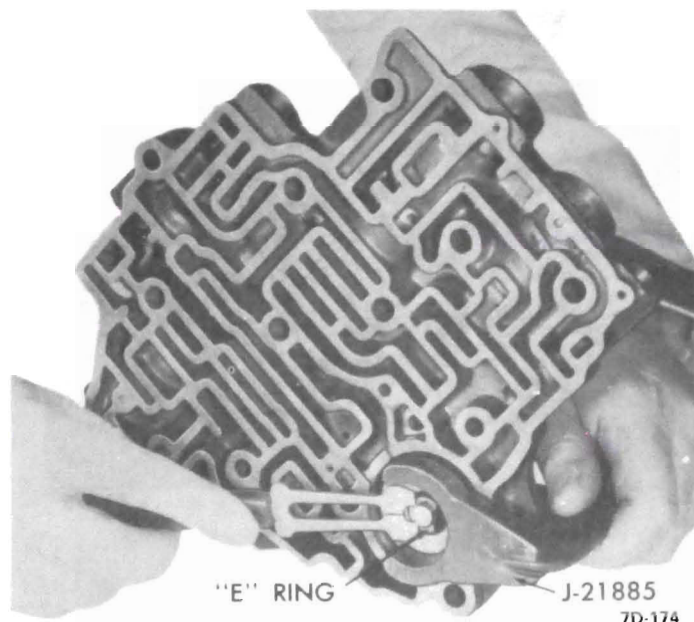
Figure 7D-110

1. Inspect all valves for scoring, cracks and free movement in their respective bores.
2. Inspect the body for cracks, scored bores, interconnected oil passages and flatness of mounting face.
3. Check all springs for distortion or collapsed coils.
4. Inspect piston and oil seal ring for damage.

Reassembly

1. Install front accumulator spring and piston into valve body.

2. Install special Tool J-21885 and compress spring and piston. Secure with retaining "E" ring. See Figure 7D-111.



7D-174

Figure 7D-111

Align piston and ring when entering bore.

3. Install the 1-2 accumulator valve train into lower left bore as follows:

a. Models "BC", and "BT", install the 1-2 accumulator primary spring, accumulator valve, stem end out, and the bore plug. Install the grooved retaining pin from the cast surface side of the valve body with grooved end entering the pin hole last. Tap the retaining pin with a hammer until the pin is flush with the cast surface side of the valve body.

b. Models "BB" and "BS", install the 1-2 accumulator valve, stem end out, and the 1-2 accumulator secondary spring. Install the bore plug and install the grooved retaining pin from cast surface side of the valve body with grooved end entering the pin hole last. Tap the retaining pin with a hammer until the pin is flush with the cast surface side of the valve body.

4. In the next bore up, install the detent spring and spacer. Compress spring and secure with small screwdriver. See Figure 7D-112.

5. Install the detent regulator valve. Wide land first. See Figure 7D-112.

6. Install the detent valve, narrow land first. See Figure 7D-112.

7. Remove the screwdriver as the bore plug (hole

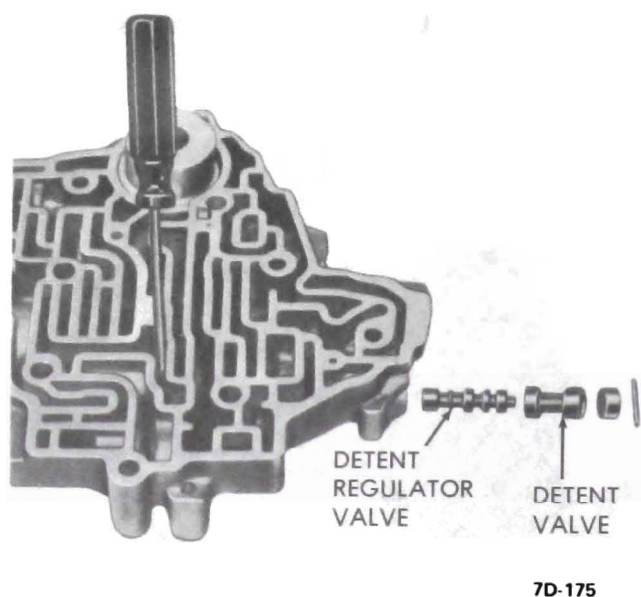


Figure 7D-112

out) and retaining pin are installed. See Figure 7D-112.

8. In the lower right hand bore, install the 3-2 valve. See Figure 7D-108.

9. Install the spacer, spring bore plug (hole out) and retaining pin. See Figure 7D-108.

10. In the next bore up, install the 2-3 valve, open end out, and 3-2 intermediate spring. See Figure 7D-108.

11. Install the 2-3 modulator valve into bushing. See Figure 7D-108.

12. Install the 2-3 modulator valve and bushing, into valve body bore. See Figure 7D-108.

13. Install the 2-3 valve spring, compress spring and install retaining pin.

14. In the next bore up, install 1-2 shift valve train as follows:

a. Models "BC" and "BS", install the 1-2 shift valve, stem end out. Install 1-2 regulator valve, larger stem first, spring and 1-2 detent valve, hole end first, into 1-2 modulator bushing, aligning spring in bore of 1-2 detent valve and install in upper right bore of valve body. Compress bushing, against spring and secure with retaining pin from cored side of valve body.

b. Models "BB" and "BT", install the 1-2 shift valve, stem end out. Install the 1-2 modulator spring and 1-2 modulator valve into the 1-2 modulator bushing, aligning the spring in the bore of the modulator valve. Install these parts into the valve body bore.

Compress bushing against spring and secure with retaining pin from cored side of the valve body.

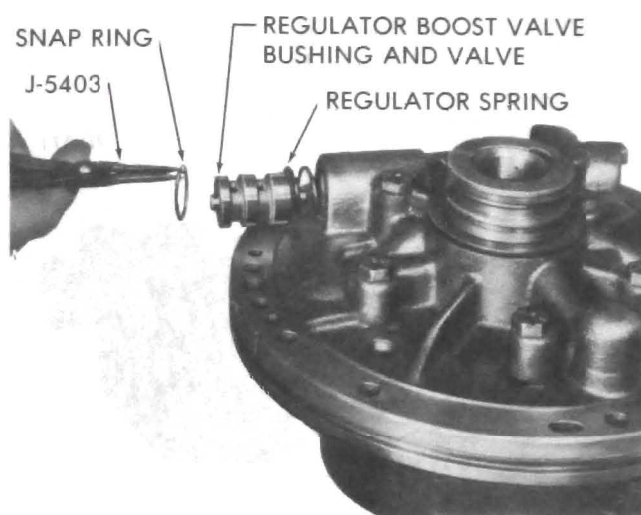
15. Install the manual valve with detent pin groove to the right. See Figure 7D-108.

OIL PUMP ASSEMBLY

Disassembly

1. Place pump assembly through hole in bench.

2. Compress the regulator boost valve bushing against the pressure regulator spring and remove the snap ring using J-5403 pliers. See Figure 7D-113.



7D-176

Figure 7D-113

3. Remove the regulator boost valve bushing and valve.

4. Remove the pressure regulator spring.

5. Remove the regulator valve, spring retainer and spacer(s), if present. See Figure 7D-114.

6. Remove the pump cover to body attaching bolts.

7. Remove pump cover from body. See Figure 7D-115.

8. Remove the retaining pin and bore plug from the pressure regulator bore.

9. Remove two oil rings from the pump cover. See Figure 7D-116.

10. Remove the pump to forward clutch housing selective washer.

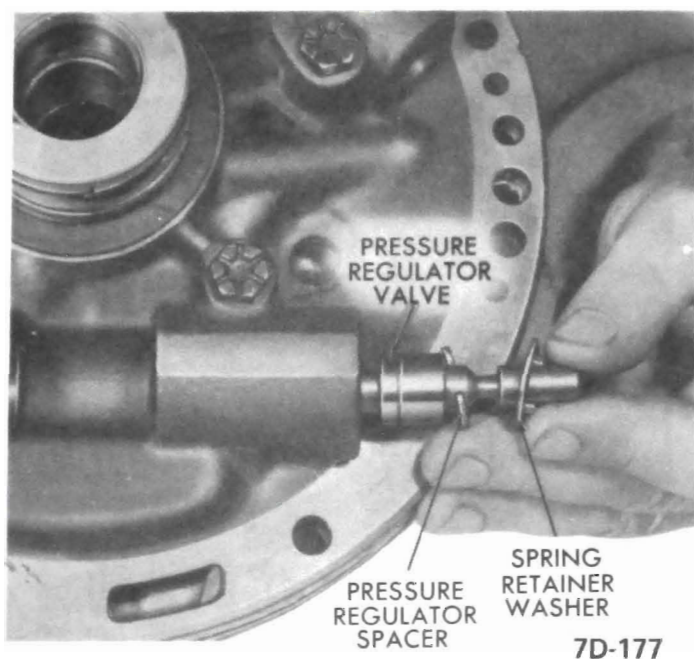


Figure 7D-114

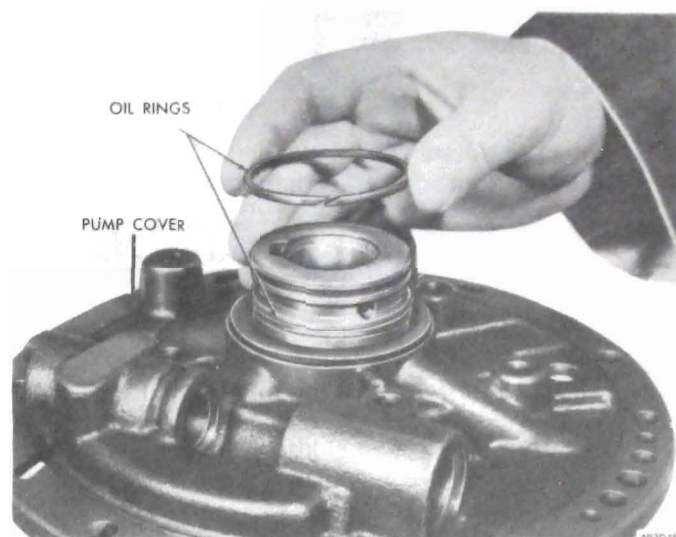


Figure 7D-116

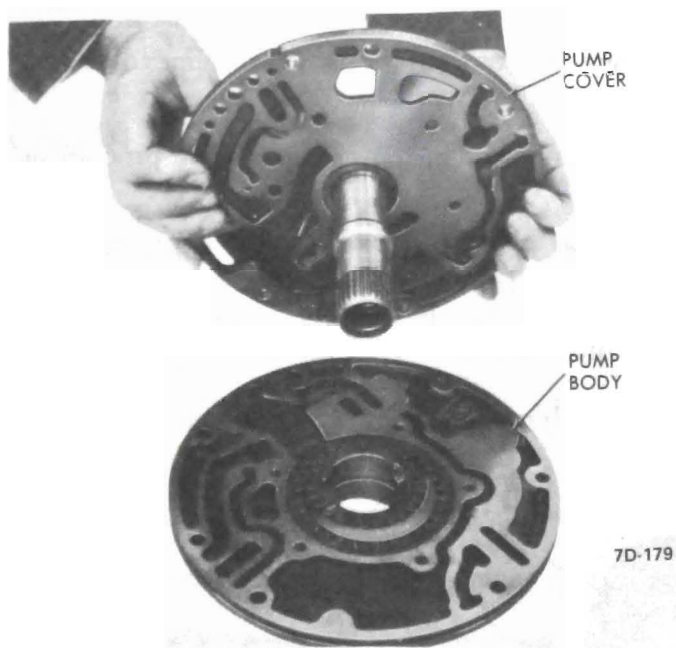


Figure 7D-115

11. Mark drive and driven gears for reassembly in same position and remove. See Figure 7D-117.

Inspection

The 1971-72-73-74 solid type pressure regulator valve does not contain oil holes and an orifice cup plug like the previous pressure regulator valve. The solid style valve must only be used in the pump cover with the squared off pressure regulator boss (pressure boost bushing end). See Figure 7D-118. The previous pressure regulator valve with the oil holes and orifice cup plug will be used to service either type pump cover.

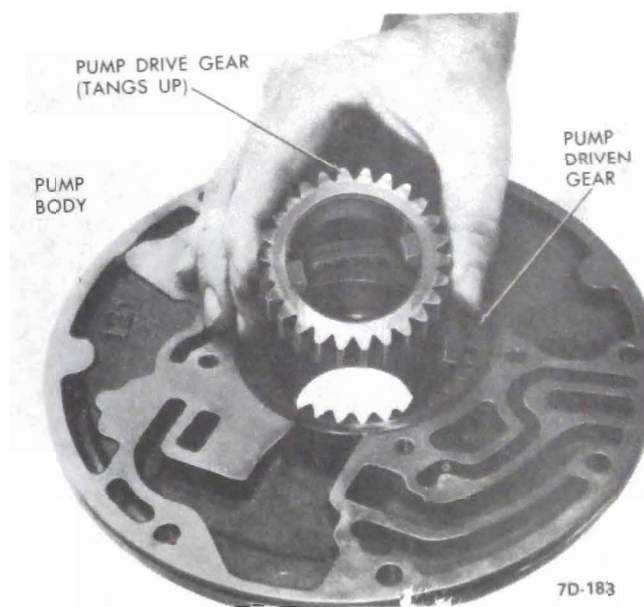


Figure 7D-117

1. Inspect the gear pocket and crescent for scoring, galling or other damage.
2. Place pump gears in pump and check the following clearance.
 - a. Pump body face to gear face clearance. Clearance should be .0008" - .0035". See Figure 7D-120.
3. Check face of pump body for scores or nicks.
4. Check oil passages.
5. Check for damaged cover bolt attaching threads.
6. Check for overall flatness of pump body face.

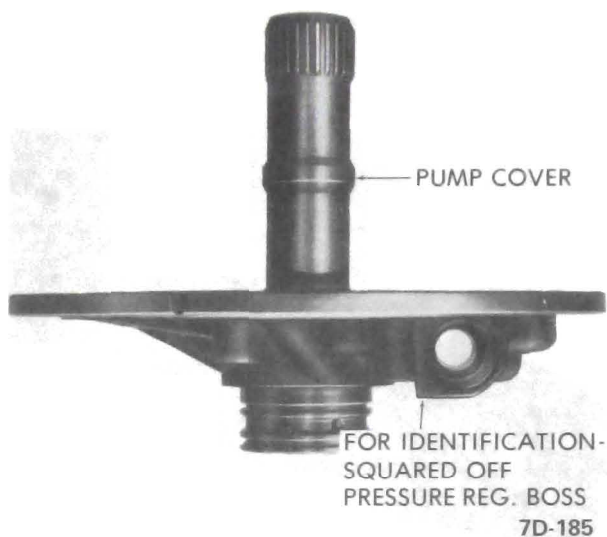


Figure 7D-118



Figure 7D-120

7. Check bushing for scores or nicks. If damaged replace as follows:

a. Support oil pump on wood blocks. Using Tool J-21465-17 and Drive Handle J-8092 press bushing out of oil pump body. See Figure 7D-121.

b. Using Tool J-21465-17 drive bushing into pump body from gear pocket face until it is flush to .010 below machined surface.

8. Inspect the pump attaching bolt seals for damage, replace if necessary.

9. Inspect pump cover face for overall flatness.

10. Check for scores or chips in pressure regulator bore.

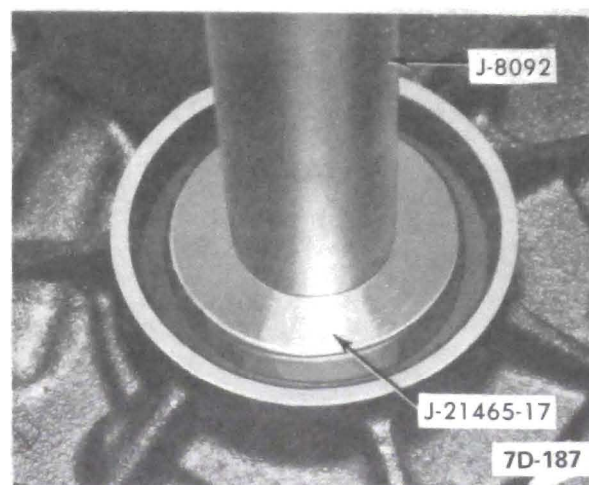


Figure 7D-121

11. Check that all passages are open and not inter-connected.

12. Check for scoring or damage at pump gear face.

13. Inspect stator shaft for damaged splines or scored bushings.

If replacement of bushing is necessary proceed as follows:

a. Thread J-21465-15 into stator shaft bushing. Thread Slide Hammer J-2619 into remover. Clamp slide hammer handle into vise. Grasp stator shaft and remove bushing. See Figure 7D-122.

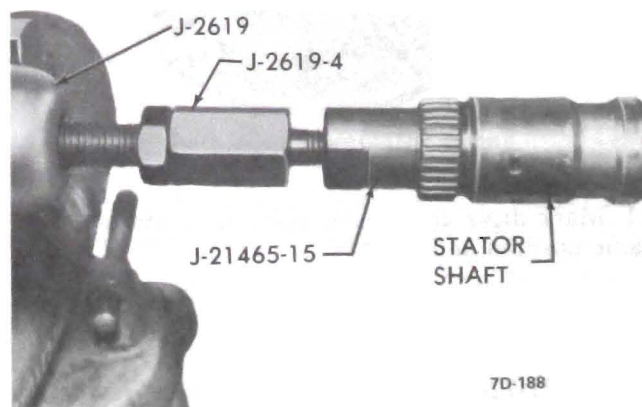


Figure 7D-122

b. Using Installer J-21465-3 install bushing in front of shaft. See Figure 7D-123.

c. See Figure 7D-123 for installation of bushing in rear of shaft.

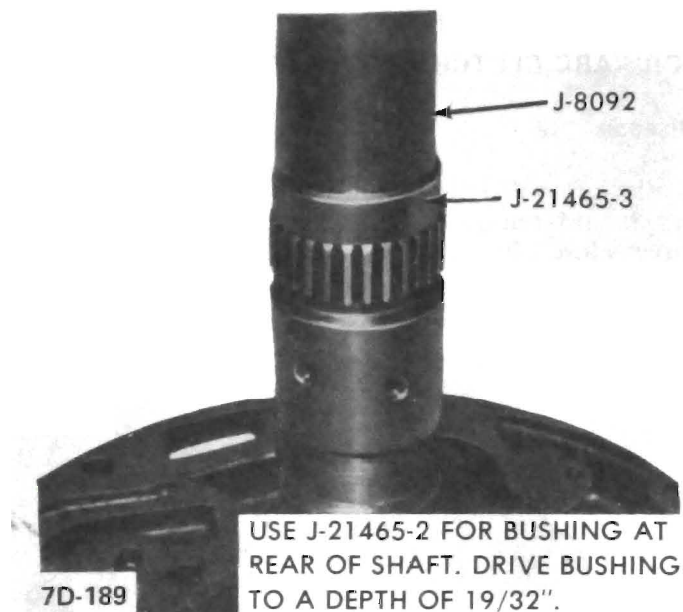


Figure 7D-123

14. Inspect oil ring grooves and rings for damage or wear.

15. Inspect selective washer thrust face for wear or damage.

16. Inspect pressure regulator and boost valve for free operation.

Reassembly

1. Install drive and driven pump gears into the pump body with alignment marks up. See Figure 7D-117.

Install the drive gear with drive tangs up.

2. Install pressure regulator spring retainer, spacer(s)

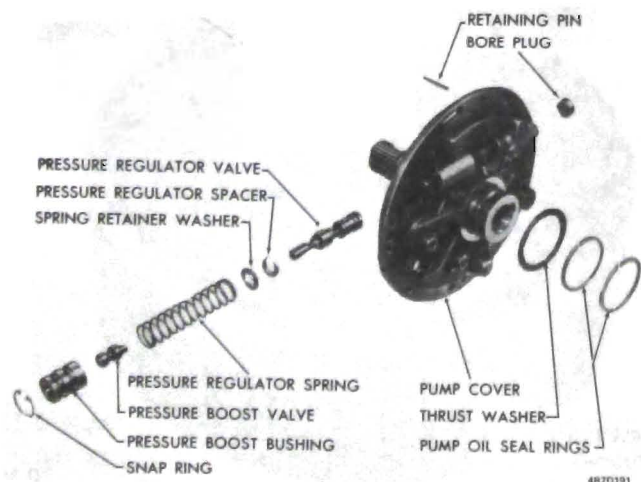


Figure 7D-124

if used, and spring into the pressure regulator bore. See Figure 7D-124.

3. Install the pressure regulator valve from opposite end of bore, stem end first.

4. Install the boost valve into the bushing, stem end out, and install both parts into the pump cover by compressing the bushing against the spring.

5. Install the retaining snap ring.

6. Install the pressure regulator valve bore plug and retaining pin into opposite end of bore. See Figure 7D-125.

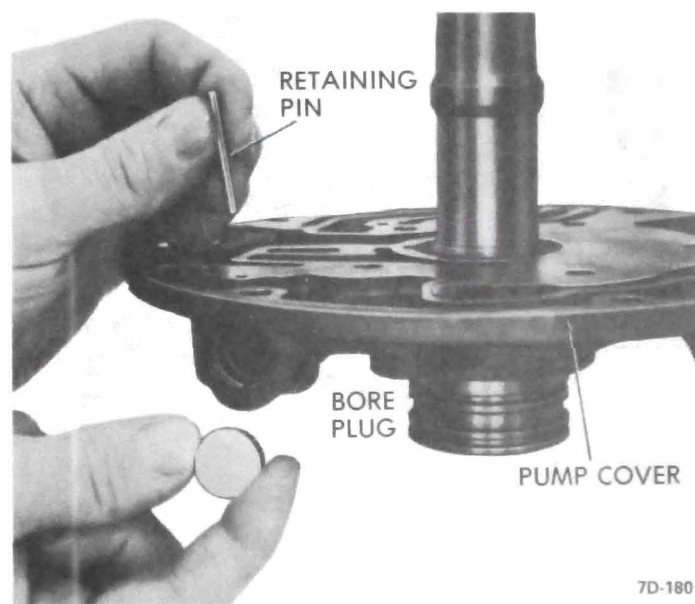


Figure 7D-125

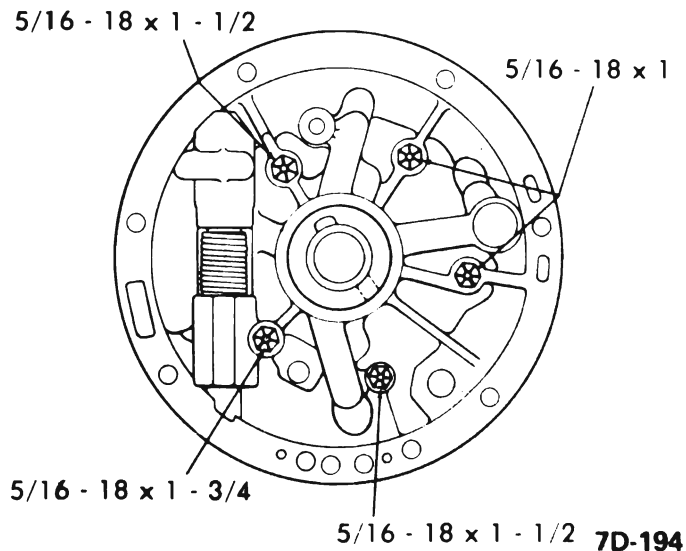


Figure 7D-126

7. Install the previously selected front unit selective thrust washer over the pump cover delivery sleeve. See Figure 7D-124.

8. Install two oil seal rings. See Figure 7D-124.

9. Assemble pump cover to pump body.

10. Install bolts as shown in Figure 7D-126. Leave bolts one turn loose at this time.

11. Place Pump Aligning Strap, J-21368, over pump body and cover, and tighten tool. See Figure 7D-127.

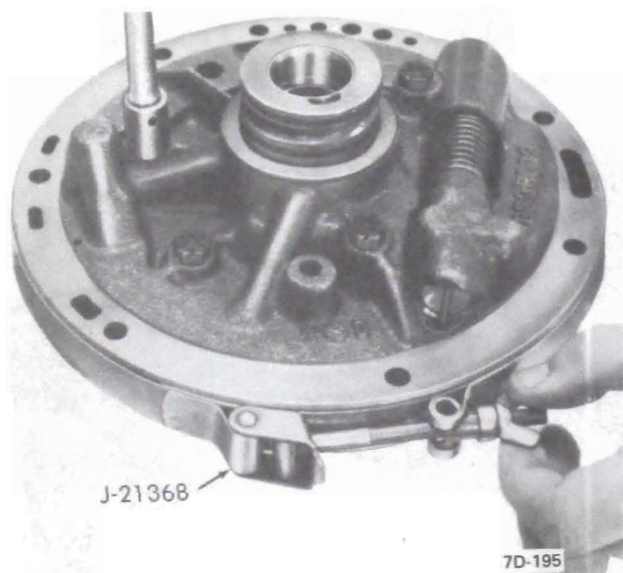


Figure 7D-127

12. Tighten pump cover bolts. Torque to 15-20 lb.ft.



Figure 7D-128

13. Install pump to case "O" ring seal.

FORWARD CLUTCH ASSEMBLY

Disassembly

1. Place forward clutch and turbine shaft in hole in bench and remove the forward clutch housing to direct clutch hub snap ring. See Figure 7D-128.

2. Remove the direct clutch hub. See Figure 7D-129.

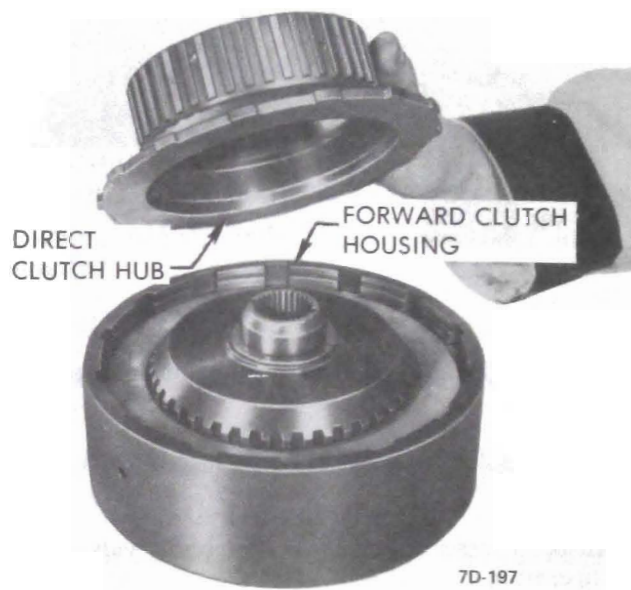


Figure 7D-129

3. Remove the forward clutch hub and thrust washers. See Figure 7D-130.

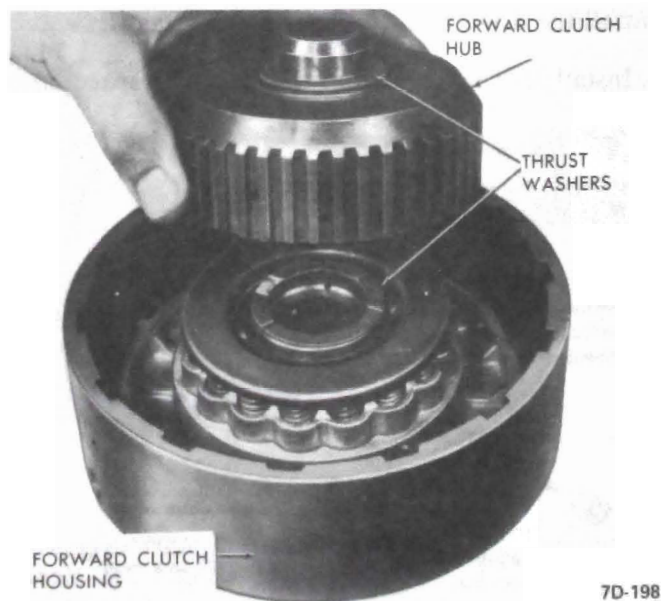


Figure 7D-130

4. Remove five (5) radial groove composition and five (5) steel clutch plates. See Figure 7D-131.

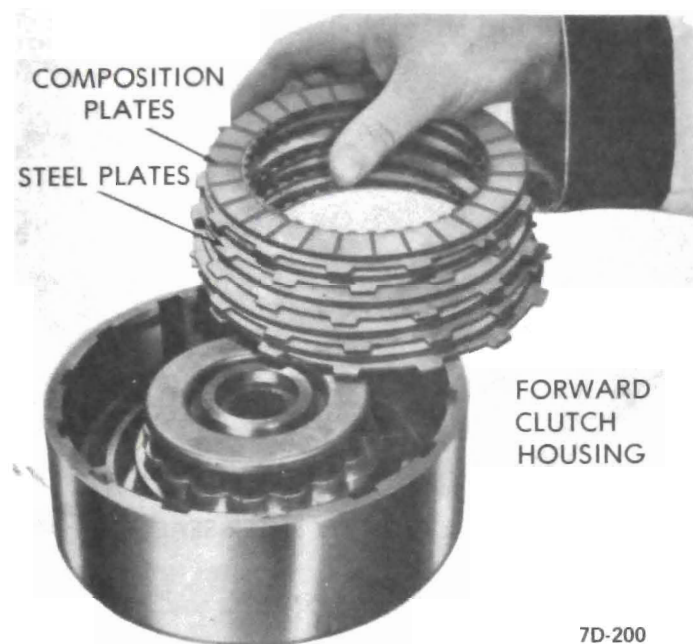


Figure 7D-131

5. If necessary remove turbine shaft. See Figure 7D-132.

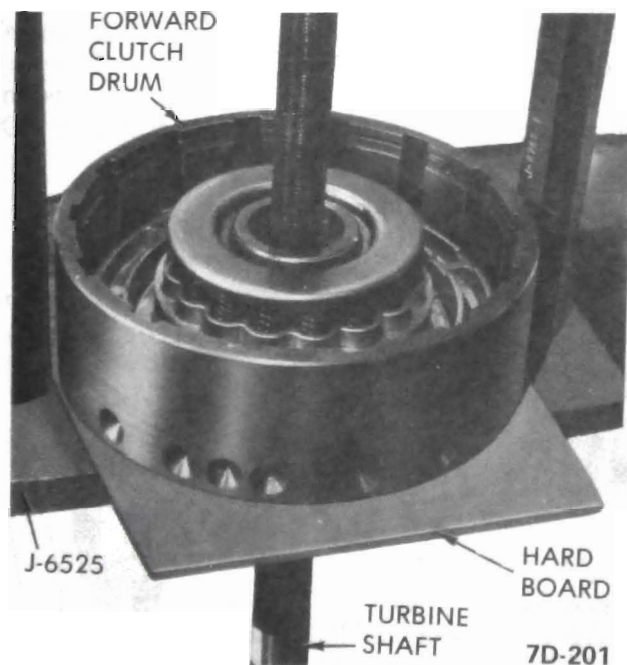


Figure 7D-132

6. Using J-2590 clutch spring compressor, compress the spring retainer and remove the snap ring. See Figure 7D-133.

If turbine shaft is not removed, compress spring retainer as shown in Figure 7D-134.

7. Remove tools, snap ring, spring retainer and sixteen clutch release springs. See Figure 7D-135.

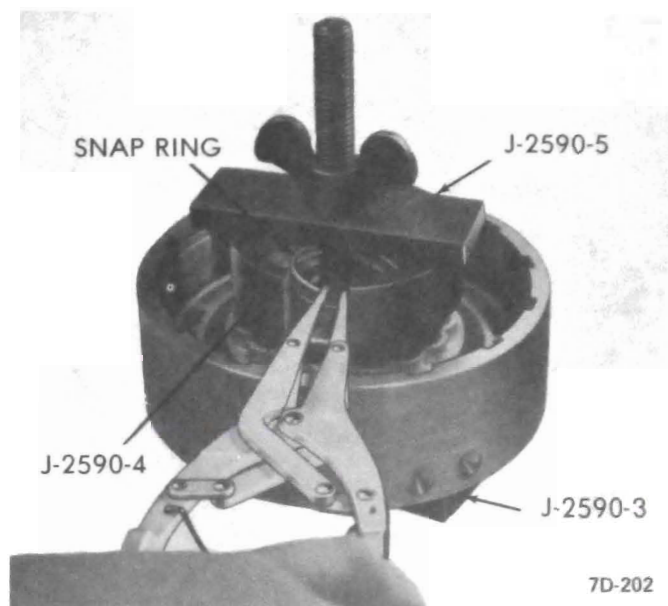


Figure 7D-133

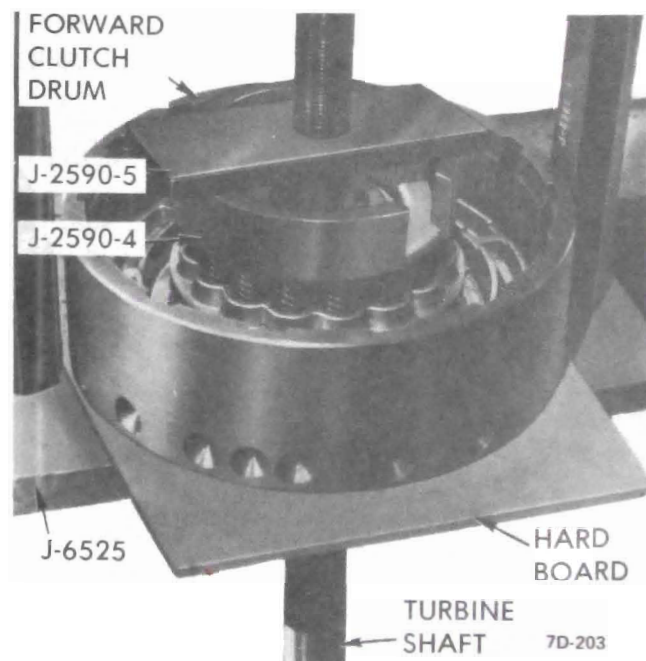


Figure 7D-134

Keep these springs separate from the direct clutch release springs.

8. Remove clutch piston.

9. Remove inner and outer clutch piston seals. See Figure 7D-137.

10. Remove center piston seal from the forward clutch housing. See Figure 7D-138.

Inspection

1. Inspect condition of composition-faced and steel

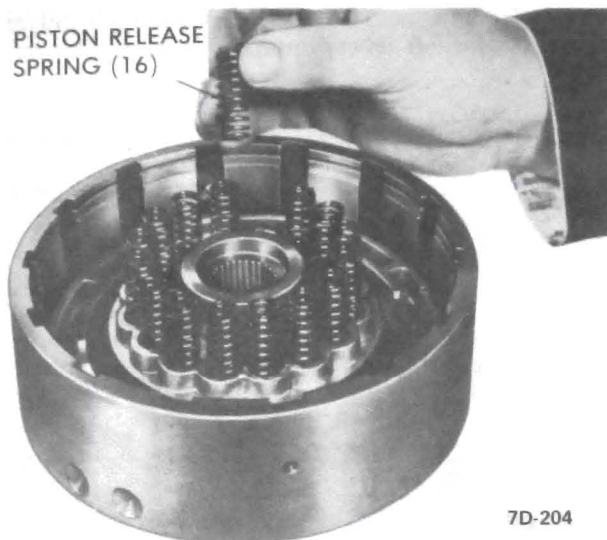


Figure 7D-135

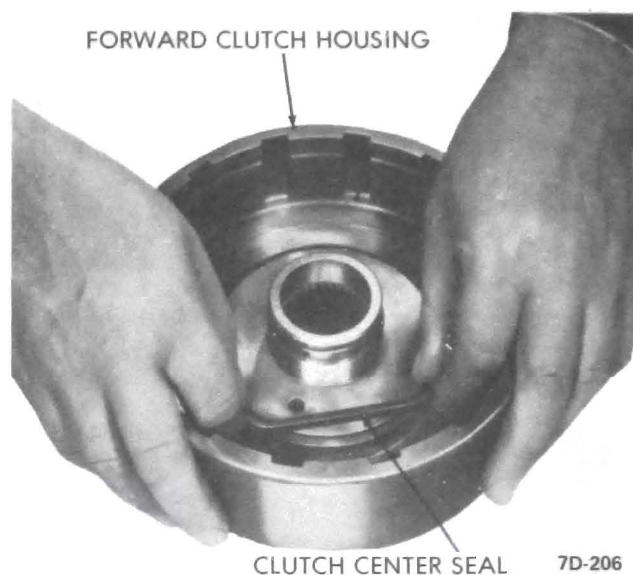


Figure 7D-138

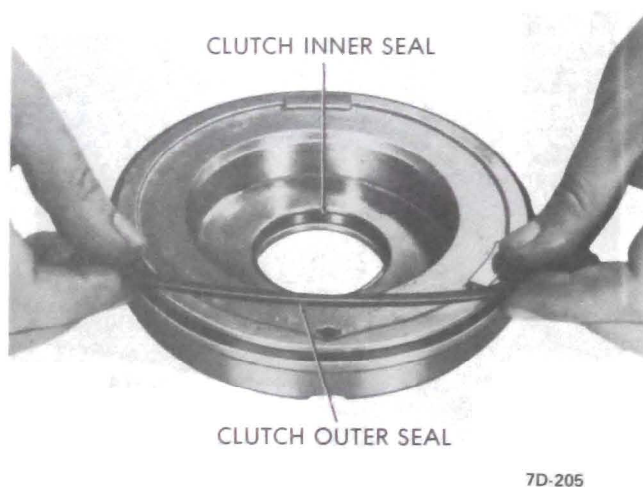


Figure 7D-137

plates. *Do not diagnose a composition plate by color.*

A. Dry composition-faced with compressed air and inspect the composition surfaces for:

1. Pitting and flaking
2. Wear
3. Glazing
4. Cracking
5. Charring

6. Chips or metal particles imbedded in lining

If a composition-faced plate exhibits any of the above conditions, replacement is required.

B. Wipe steel plates dry and check for heat discoloration. If the surface is smooth and an even color smear is indicated, the plates should be reused. If severe heat spot discoloration or surface scuffing is indicated, the plates must be replaced. See Figure 7D-139.

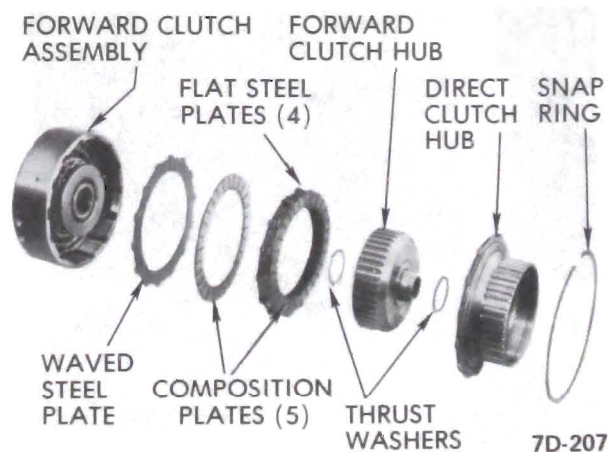


Figure 7D-139

2. Inspect the 16 return springs. Evidence of extreme heat or burning in the area of the clutch may have caused the springs to take a heat set and would justify replacement of the springs.

3. Inspect clutch hubs for worn splines, proper lubrication holes and worn thrust faces.

4. Inspect the piston for cracks.
5. Inspect clutch housing for wear, scoring, open oil passages and free operation of the ball check.
6. Inspect turbine shaft.
 - a. Inspect for open lubrication passages at each end.
 - b. Inspect splines for damage.
 - c. Inspect ground bushing journals for damage.
 - d. Inspect shaft for cracks or distortion.

Turbine shaft and clutch housing are serviced separately.

Reassembly

1. Place new inner, and outer oil seals on clutch piston, lips face away from spring pockets. See Figure 7D-137.

The forward and direct clutch pistons have identical inside and outside diameters. It is possible to reverse the pistons during reassembly, therefore care should be exercised to make certain the proper piston be installed in the clutch assemblies as shown in Figure 7D-140. The forward clutch piston can be identified by the blind hole in the clutch apply face of the piston.

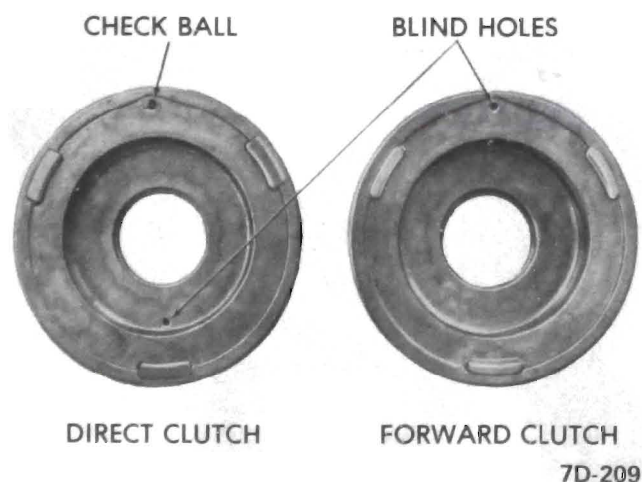


Figure 7D-140

2. Place a new center seal on the clutch housing, lip faces up. See Figure 7D-138.
3. Place Seal Protector Tool J-21362, over clutch hub and install outer clutch piston Seal Protector J-21409, into clutch drum and install piston. See Figure 7D- 141.
4. Install clutch release springs into pockets in piston. See Figure 7D-135.

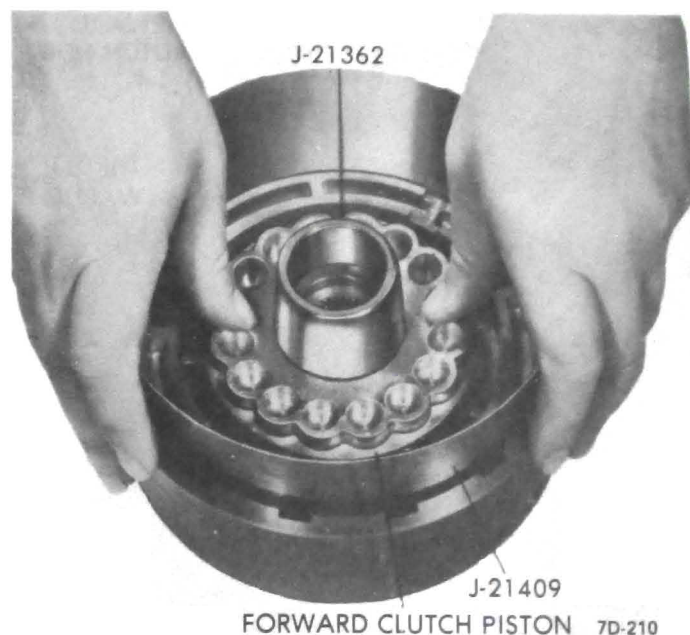


Figure 7D-141

5. Place spring retainer and snap ring on springs.
 6. Compress springs using Clutch Compressor Tool J- 2590, and install snap ring. See Figure 7D-133.
- If turbine shaft was not removed, install retainer as shown in Figure 7D-132.
7. If removed, install turbine shaft into forward clutch drum. See Figure 7D-142.

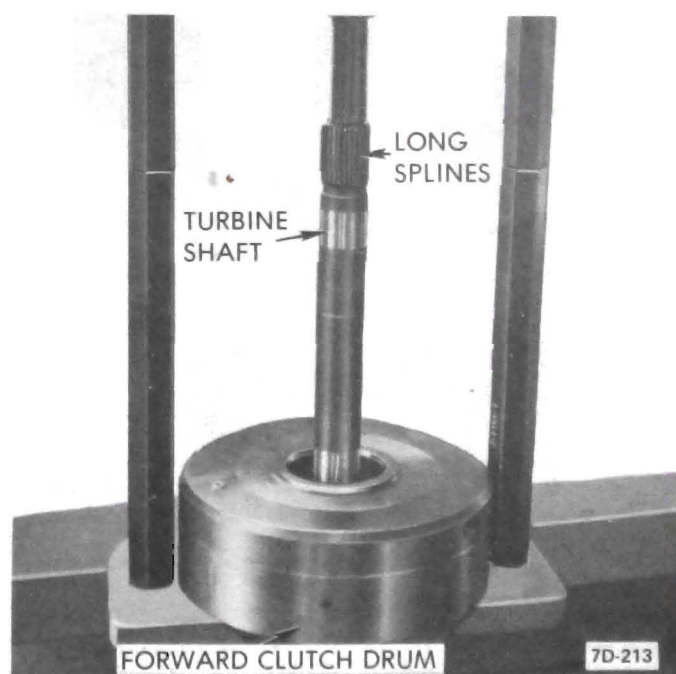


Figure 7D-142

8. Install the forward clutch hub thrust washers on forward clutch hub. Retain with petroleum jelly. See Figure 7D-143.

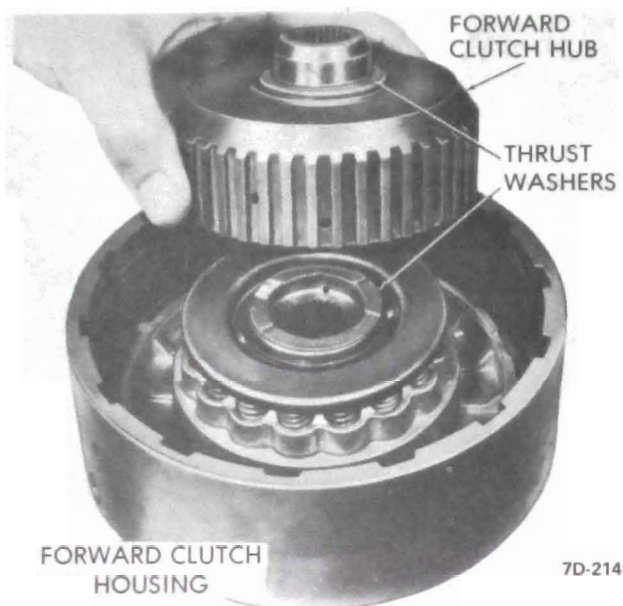


Figure 7D-143

9. Place forward clutch hub into forward clutch housing. See Figure 7D-143.

10. Oil and install five (5) radial groove composition, four (4) flat steel clutch plates and one (1) waved steel plate (plate with "U" notches), starting with waved steel and alternating composition and steel plates. See Figure 7D-144.

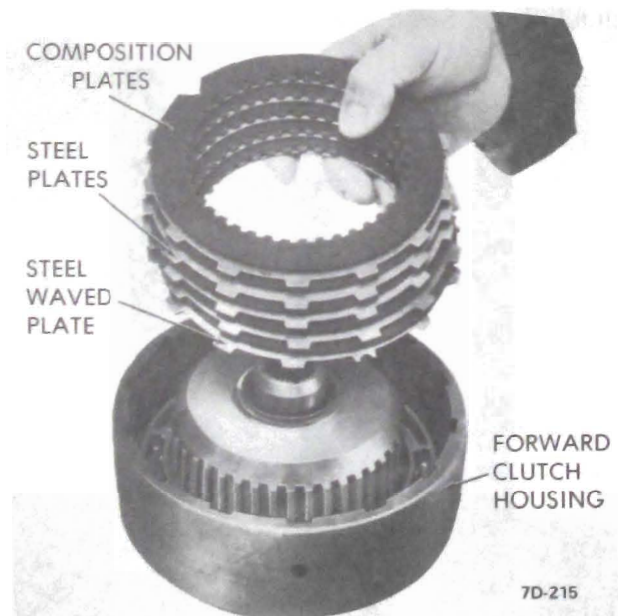


Figure 7D-144

Do not confuse the flat steel clutch plate (plate with "V" notch) with the waved steel clutch plate (plate with "U" notch.)

Radially-grooved composition clutch plates are in-

stalled at the factory only. All service composition plates have the smooth surface configuration.

11. Install the direct clutch hub and retaining snap ring. See Figure 7D-145.



Figure 7D-145

12. Place forward clutch housing on pump delivery sleeve and air check clutch operation. See Figure 7D-146.

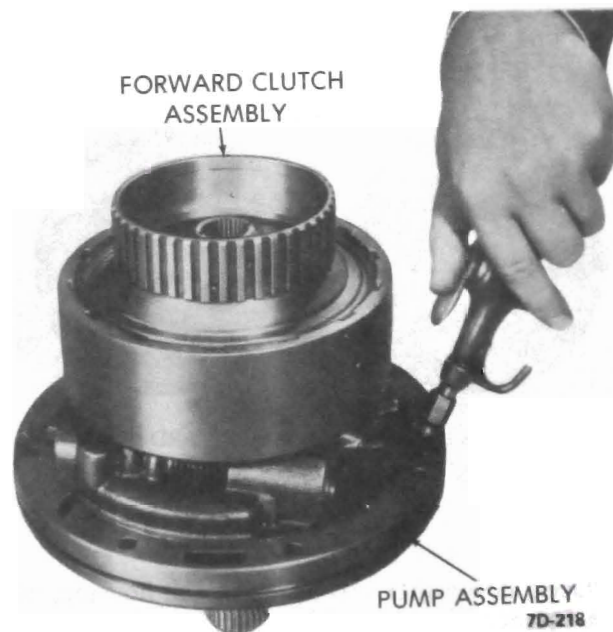


Figure 7D-146

DIRECT CLUTCH AND INTERMEDIATE ROLLER CLUTCH

Disassembly

1. Remove roller clutch retainer snap ring and retainer. See Figure 7D-147.



Figure 7D-147

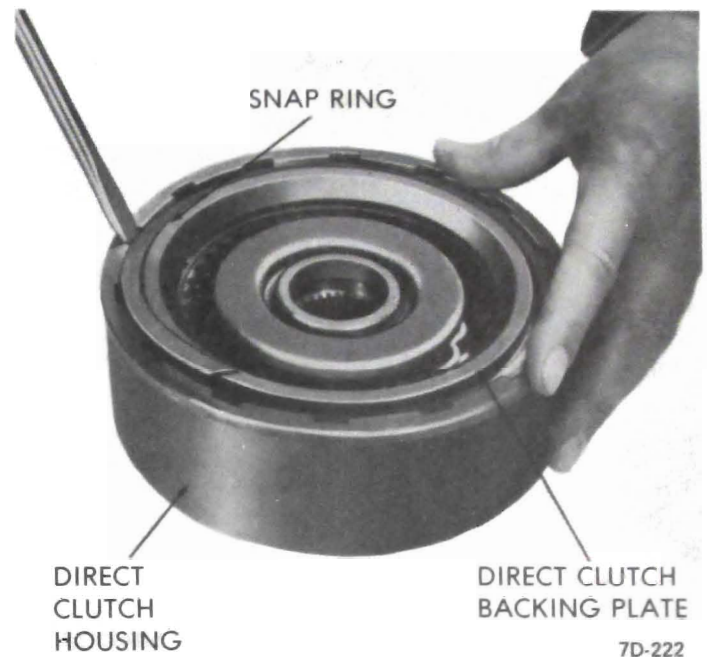


Figure 7D-149

2. Remove roller clutch outer race and roller assembly. See Figure 7D-148.

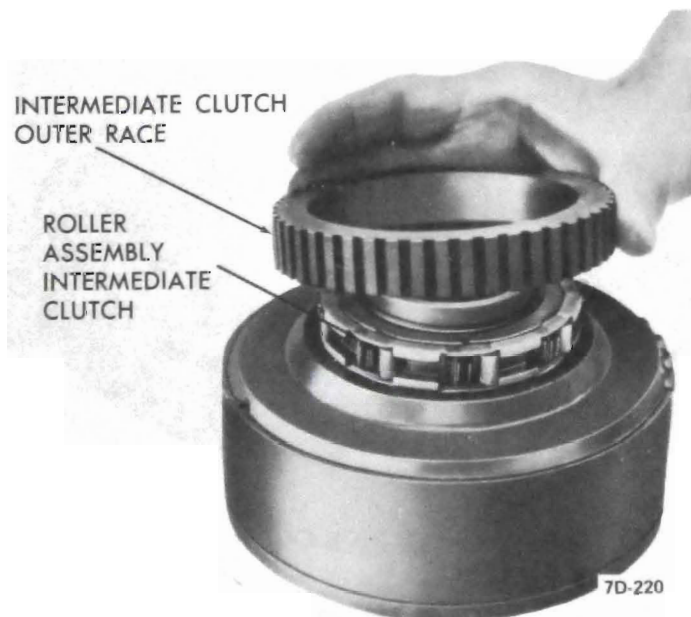


Figure 7D-148

c. Models "BC", and "BT", remove direct clutch backing plate, five (5) composition-faced, and five (5) steel clutch plates.

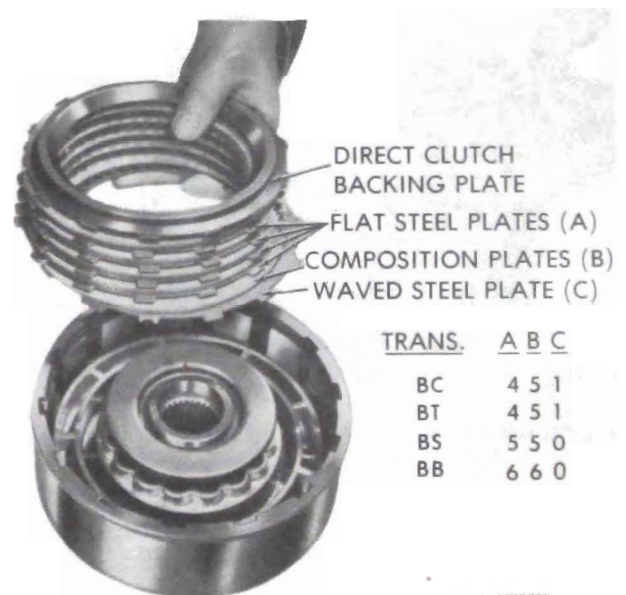


Figure 7D-150

3. Turn unit over and remove backing plate to clutch housing snap ring. See Figure 7D-149.

4.a. Model "BB", remove direct clutch backing plate, six (6) composition-faced and six (6) steel clutch plates. See Figure 7D-150.

b. Model "BS", remove direct clutch backing plate, five (5) composition-faced and five (5) steel clutch plates.

5. Using Tool J-2590, compress spring retainer and remove snap ring. See Figure 7D-151.

6. Remove retainer and fourteen (14) piston release springs. Keep these springs separate from forward clutch release springs. See Figure 7D-152.

7. Remove direct clutch piston. See Figure 7D- 154.

8. Remove outer seal from piston. See Figure 7D-155.

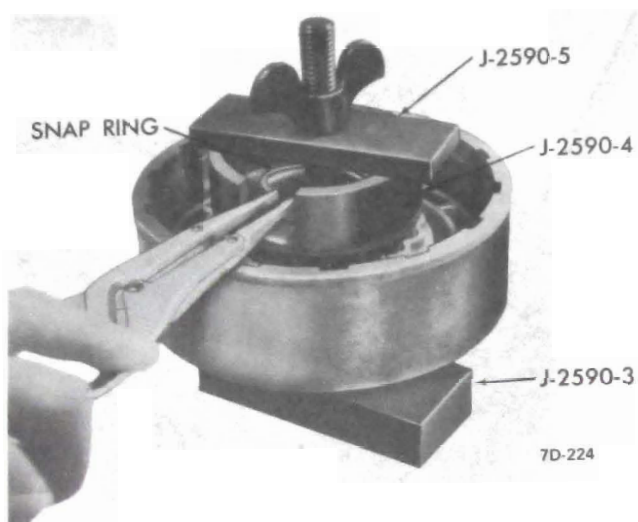


Figure 7D-151

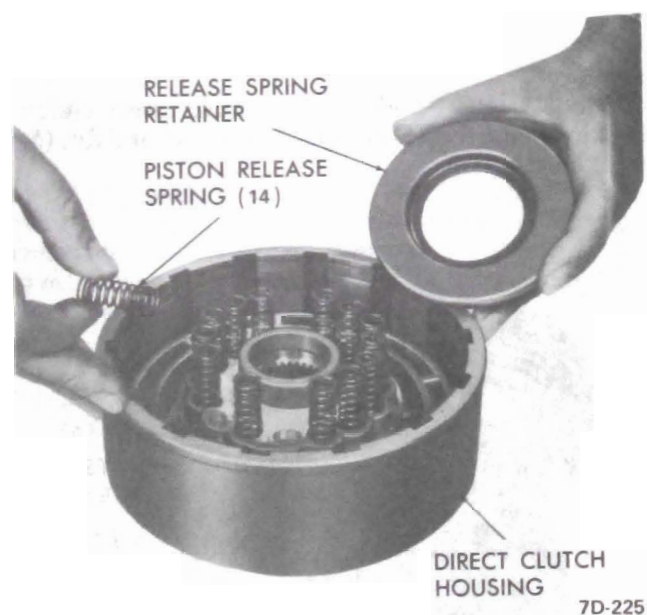


Figure 7D-152

9. Remove inner seal from piston. See Figure 7D-156.

10. Remove center piston seal from direct clutch housing. See Figure 7D-157.

Inspection

1. Inspect roller assembly. See Figure 7D-158.
2. Inspect the inner cam and outer race for scratches or wear.
3. Inspect clutch housing for cracks, wear, proper opening of oil passages or wear on clutch plate drive lugs.



Figure 7D-154



Figure 7D-155

4. Inspect condition of composition and steel plates. *Do not diagnose a composition-faced plate by color.*

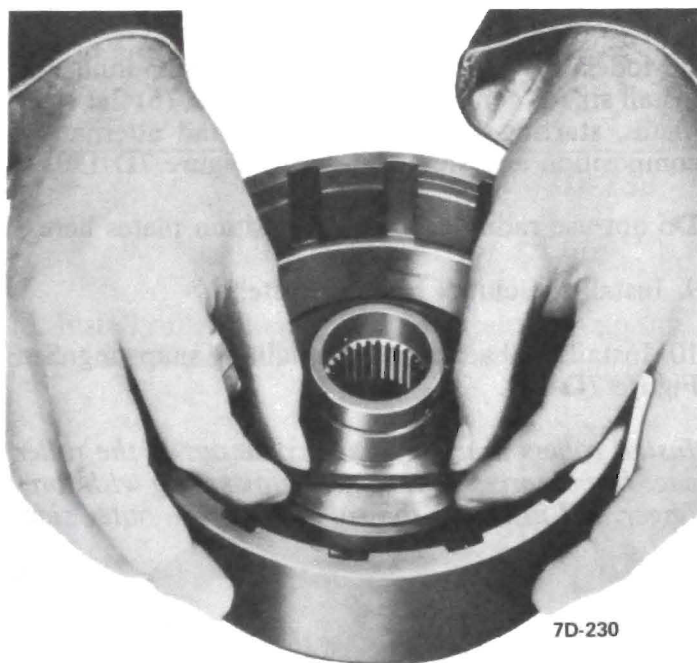
A. Dry composition plates with compressed air and inspect the composition surface for:

1. Pitting and flaking
2. Wear
3. Glazing
4. Cracking



7D-229

Figure 7D-156



7D-230

Figure 7D-157

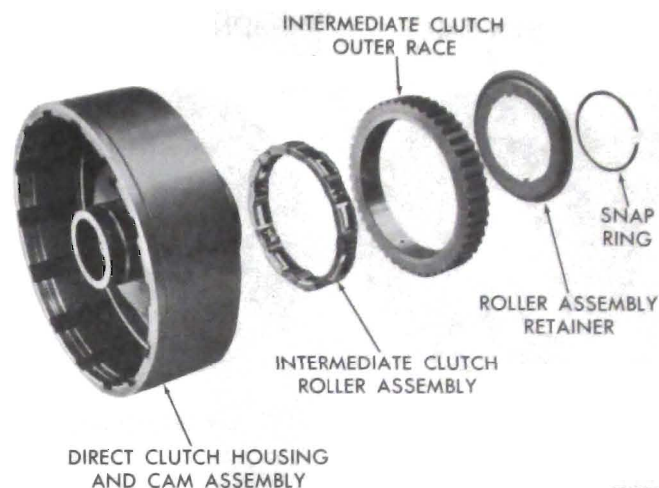
5. Charring

6. Chips or metal particles imbedded in lining

If a composition-faced plate exhibits any of the above conditions, replacement is required.

B. Wipe steel plates dry and check for heat discoloration. If the surface is smooth and an even color smear is indicated, the plates should be reused. If severe heat spot discoloration or surface scuffing is indicated, the plates must be replaced.

5. Inspect the fourteen (14) return springs. Evidence



7D-231

Figure 7D-158

of extreme heat or burning in the area of the clutch may have caused the springs to take a heat set and would justify replacement of the springs.

The fourteen (14) direct clutch release springs are not serviced. If one of more of these springs require replacement, discard all of them and install the sixteen (16) Service direct clutch release springs.

6. Inspect the backing plate for scratches or other damage.

7. Inspect the clutch piston for cracks and free operation of the ball check.

Reassembly

1. Install a new inner clutch piston seal on piston with lip facing away from spring pockets. Make certain correct piston is used. See Figure 7D-156.

2. Install a new outer clutch piston seal with lip away from spring pockets. See Figure 7D-155

Make certain the piston has a ball check (Model "BB" direct clutch piston has two (2) check balls). The piston with a blind hole is for the forward clutch assembly. See Figure 7D-159.

3. Install a new center seal on clutch housing with lip of seal facing up. See Figure 7D-157.

The direct clutch housing for the "BB" model use the six (6) plate direct clutch assembly. This housing can be identified by the elimination of the I.D. chamfer on the clutch plate end of the housing and/or a groove in the face at the base of the tower. See Figure 7D-160. Should replacement of the direct clutch housing become necessary, extreme care must be taken in obtaining the correct part for the model involved.

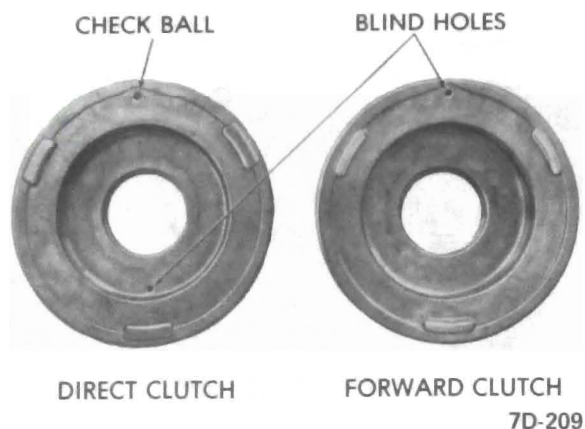


Figure 7D-159

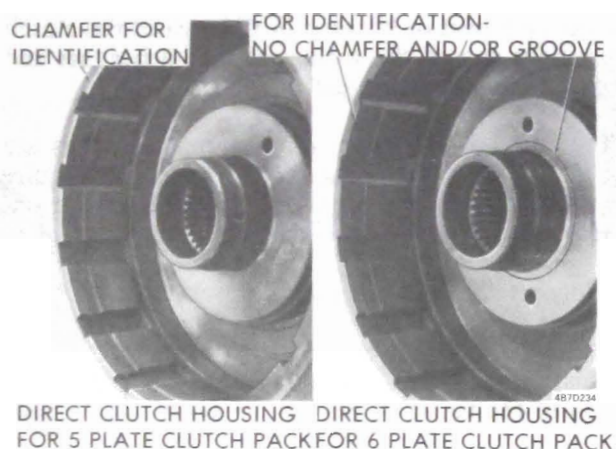


Figure 7D-160 Direct Clutch Housing Identification

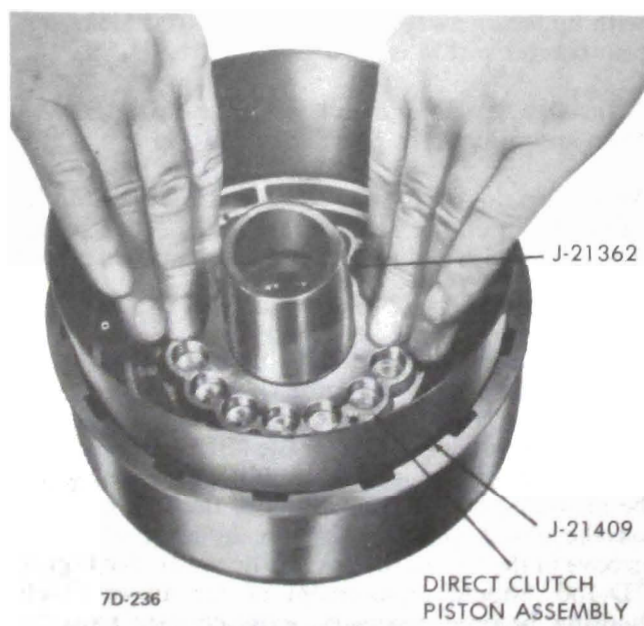


Figure 7D-161

4. Place Seal Protectors, Tools J-21362 - Inner, J-21409 - Outer, over hub and clutch housing and install clutch piston. See Figure 7D-161.

5. Install fourteen (14) clutch release springs into spring pockets in clutch piston, leaving two (2) pockets directly opposite one another with no springs.

6. Place spring retainer and snap ring on springs.

7. Using Tool J-2590, install snap ring. See Figure 7D-151.

8.a. Model "BS", lubricate with transmission fluid and install five (5) composition-faced, five (5) flat steel, starting with the waved steel and alternating composition and steel plates. See Figure 7D-150.

b. Models "BC", "BT" lubricate with transmission fluid and install five (5) composition-faced, four (4) flat steel, and one (1) waved steel plate (plate with "U" notch), starting with the waved steel and alternating composition and steel plates. See Figure 7D-150.

c. Model "BB", lubricate with transmission fluid and install six (6) composition-faced and six (6) flat steel plates, starting with the flat steel and alternating composition and steel plates. See Figure 7D-150.

Do not use radial groove composition plates here.

9. Install the clutch backing plate.

10. Install the backing plate retaining snap ring. See Figure 7D-149.

Install rollers that may have come out of the roller cage by compressing the energizing spring with forefinger and inserting the roller from the outer side.

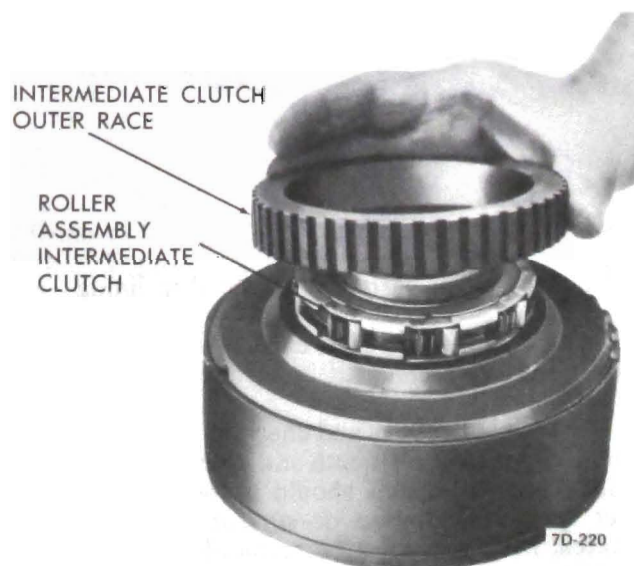
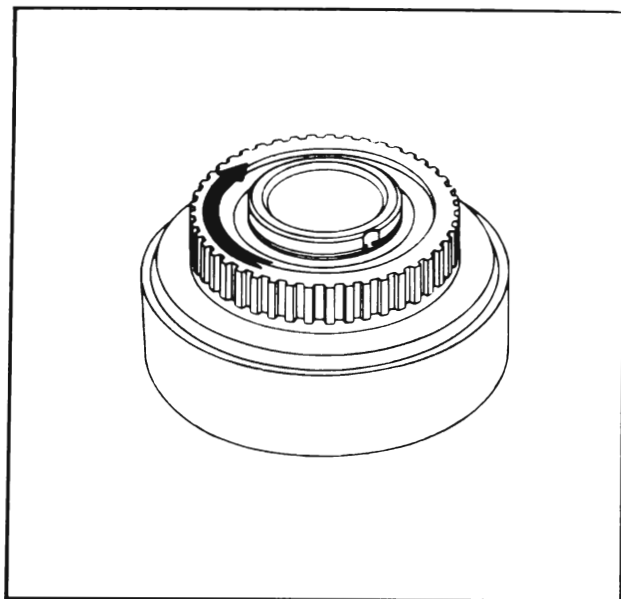


Figure 7D-162

11. Turn unit over and install the roller clutch assembly onto the intermediate clutch inner cam.

12. Install the intermediate clutch outer race with a clockwise turning motion. See Figure 7D-162.

Outer race should not turn counterclockwise after installation. See Figure 7D-163.



7D-238

Figure 7D-163

13. Install roller retainer over roller clutch, cup side down. See Figure 7D-164.



Figure 7D-164

14. Install roller retainer snap ring. See Figure 7D-165.

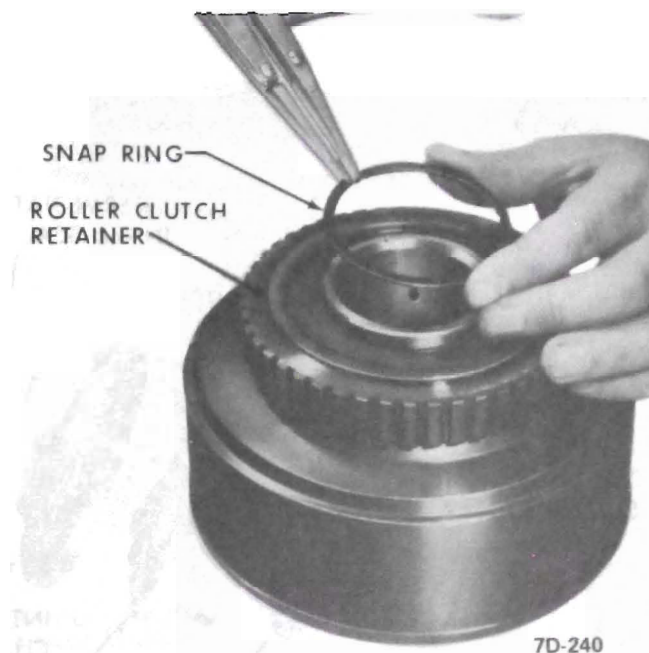


Figure 7D-165

17. Place direct clutch assembly over center support and air check operation of direct clutch. See Figure 7D-166.

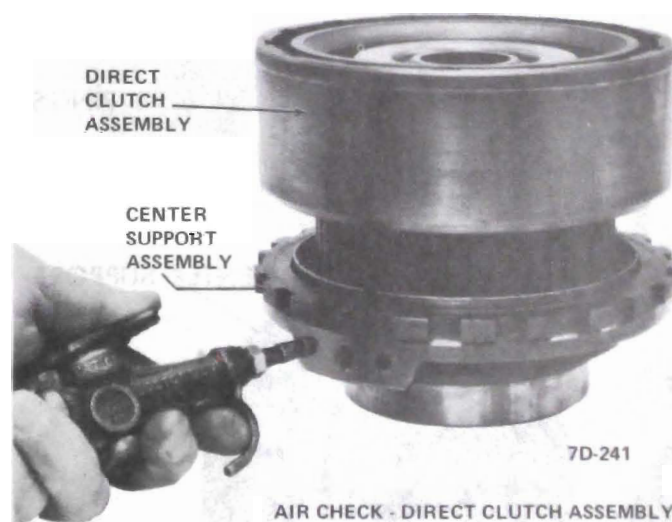


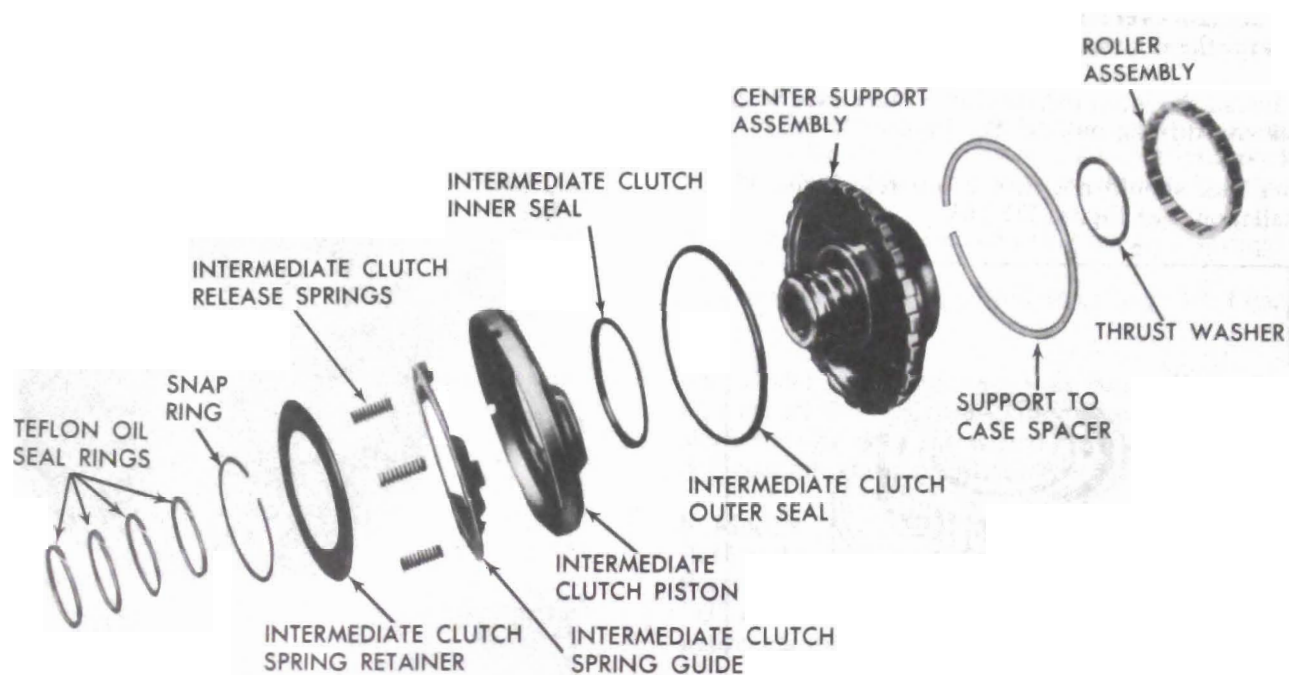
Figure 7D-166

If air is applied through the reverse passage (right oil feed hole), it will escape from the direct clutch passage (left oil feed hole). This is considered normal. Apply air through left oil feed hole to actuate piston and move direct clutch.

CENTER SUPPORT AND INTERMEDIATE CLUTCH (See Figure 7D-167)

Disassembly

1. Remove 4 teflon oil seal rings from the center support. See Figure 7D-168. All service center support oil seal rings are hook type cast iron.



7D-242

Figure 7D-167

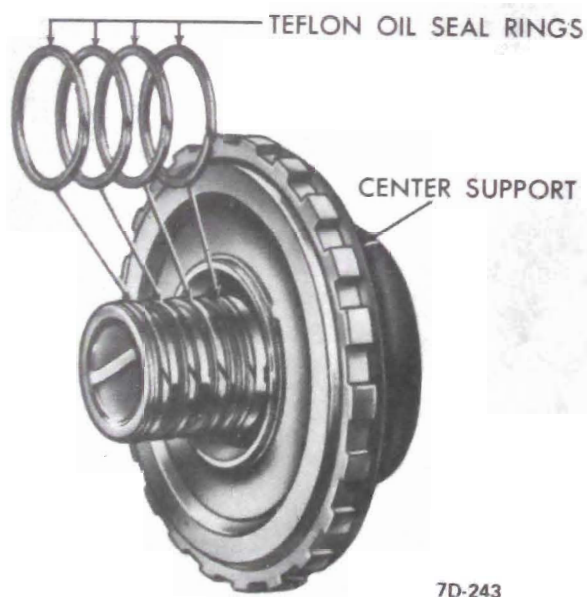
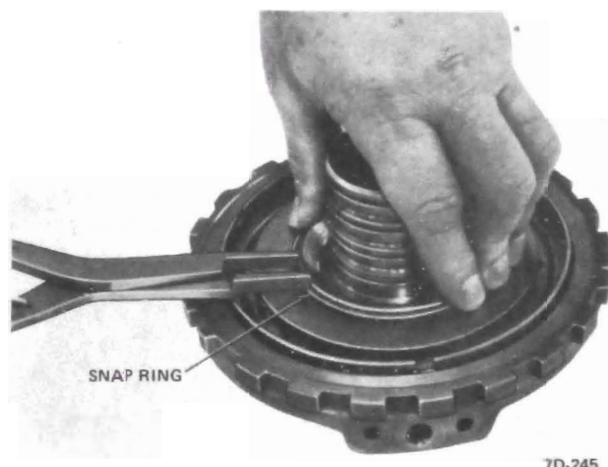


Figure 7D-168



7D-245

Figure 7D-169

2. Remove snap ring. See Figure 7D-169.
3. Remove spring retainer. See Figure 7D-171. Remove three (3) clutch release springs and spring guide. See Figure 7D-172.
4. Remove the intermediate clutch piston. See Figure 7D-173.

Do not remove the three (3) bolts retaining the roller clutch inner race to the center support.

5. Remove the inner piston seal. See Figure 7D-174.
6. Remove the outer piston seal. See Figure 7D-175.

Inspection

1. Inspect the roller clutch inner race for scratches or indentations. Be sure the lubrication hole is open.

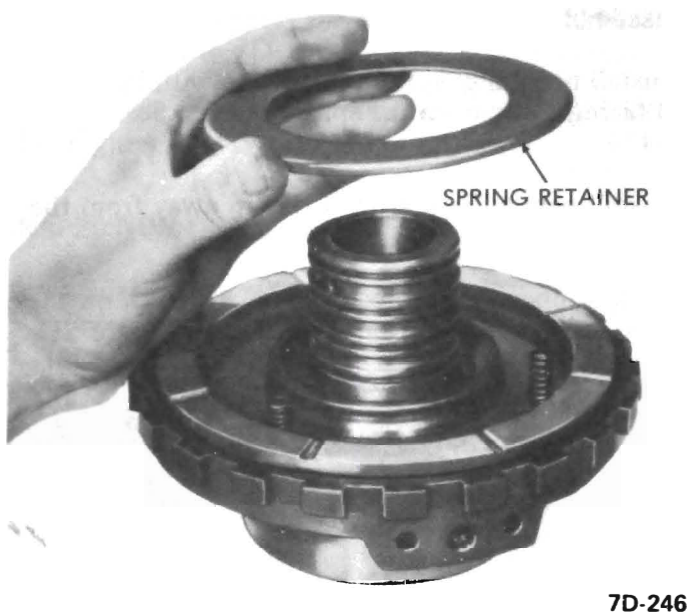


Figure 7D-171

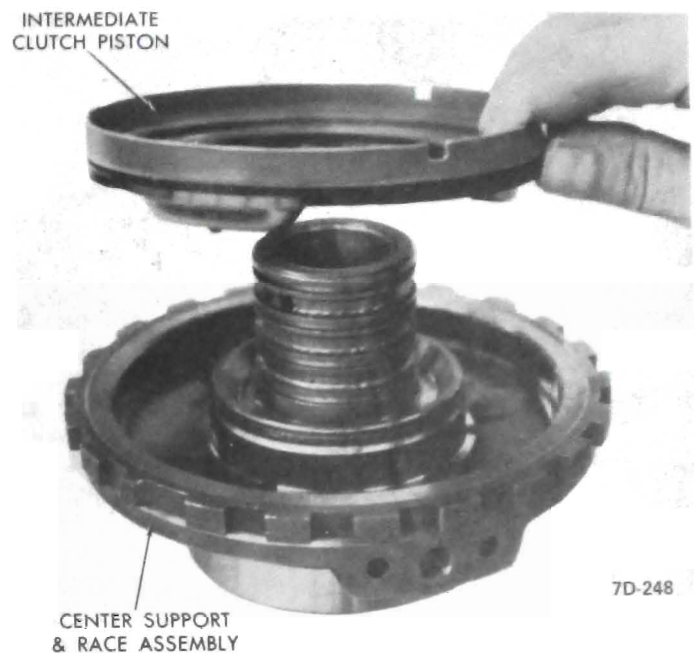


Figure 7D-173

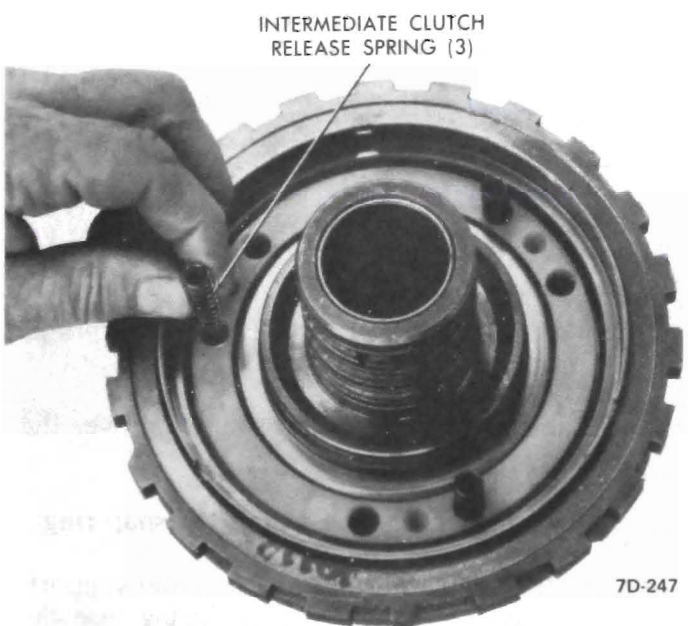


Figure 7D-172

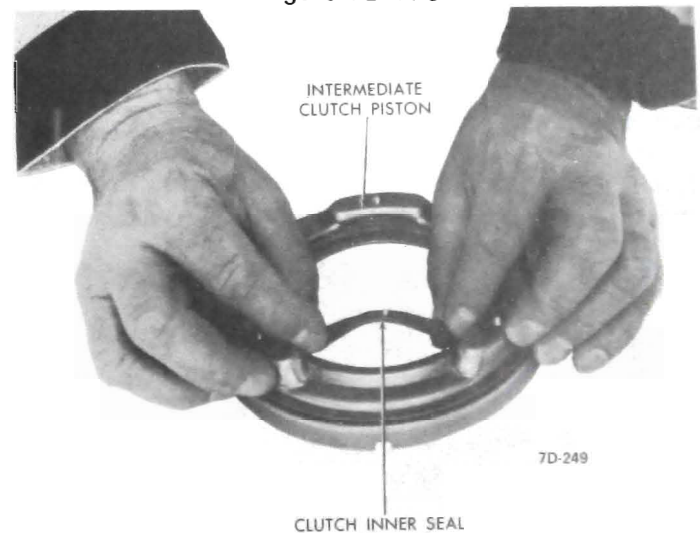


Figure 7D-174



Figure 7D-175

2. Inspect the bushing for scoring, wear or galling. If replacement is necessary proceed as follows:

a. Using Tool J-21465-6, remove bushing. See Figure 7D-176.

b. From front side of center support, align elongated slot in bushing with drilled hole in the oil delivery sleeve closest to the piston. Using Tool J- 21465-6 and Drive Handle J-8092, drive bushing squarely into the bore until the bushing is flush to .010" below top of oil delivery sleeve.

2. Check the oil ring grooves and rings for damage.

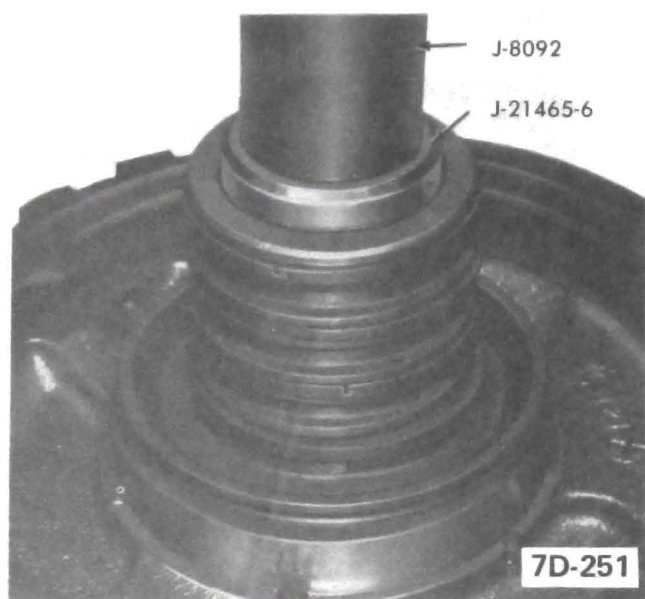


Figure 7D-176

All Service center support oil seal rings are hook type cast iron.

3. Air check the oil passages to be sure they are open and not interconnected. See Figure 7D-177.

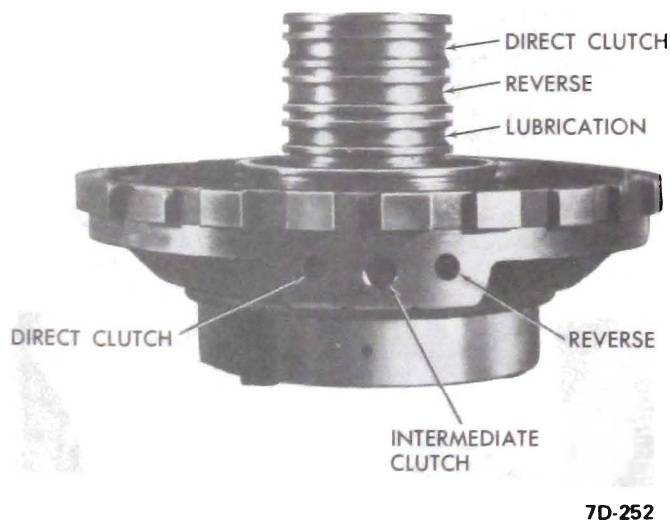


Figure 7D-177

4. Inspect piston sealing surfaces for scratches.
5. Inspect the piston seal grooves for nicks or other damage.
6. Inspect the piston for cracks or porosity.
7. Inspect the release springs. Evidence of extreme heat or burning in the area of the clutch may have caused the springs to take a heat set and would justify replacement of the springs.

Reassembly

1. Install new inner seal on the piston with lip of the seal facing away from the spring pocket. See Figure 7D-174.
2. Install new outer seal with the lip away from the spring pockets. See Figure 7D-175.
3. Install inner seal protector, Tool J-21363, on the center support hub, install piston. See Figure 7D-178.

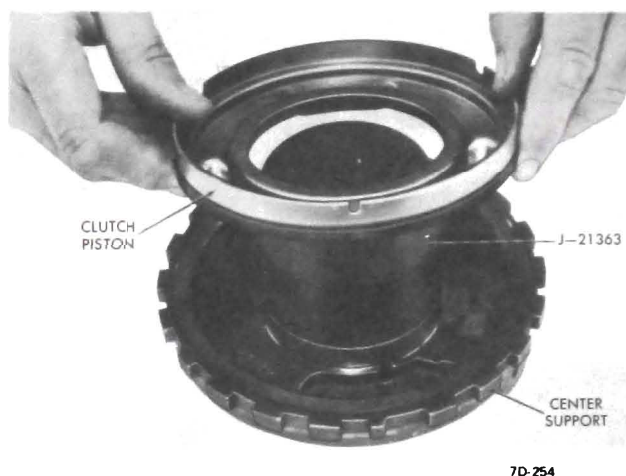


Figure 7D-178

4. Install spring guide and three (3) release springs into the piston. See Figure 7D-172.
5. Place the spring retainer and snap ring over the springs.
6. Compress the springs and install the snap ring.
7. Install 4 teflon oil seal rings on the center support. If the teflon oil seal rings need replacing, use the



Figure 7D-179

service center support oil seal rings, hook type cast iron. See Figure 7D-168.

8. Air check operation of intermediate clutch piston. See Figure 7D-179.

INSPECTION OF TRANSMISSION PARTS

Case Bushing

1. Inspect case bushing for wear or galling. If replacement is necessary proceed as follows:

a. Thread Extension Handle J-21465-13 into Bushing Remover J-21465-8. Using Drive Handle J-8092 remove bushing. See Figure 7D-180.

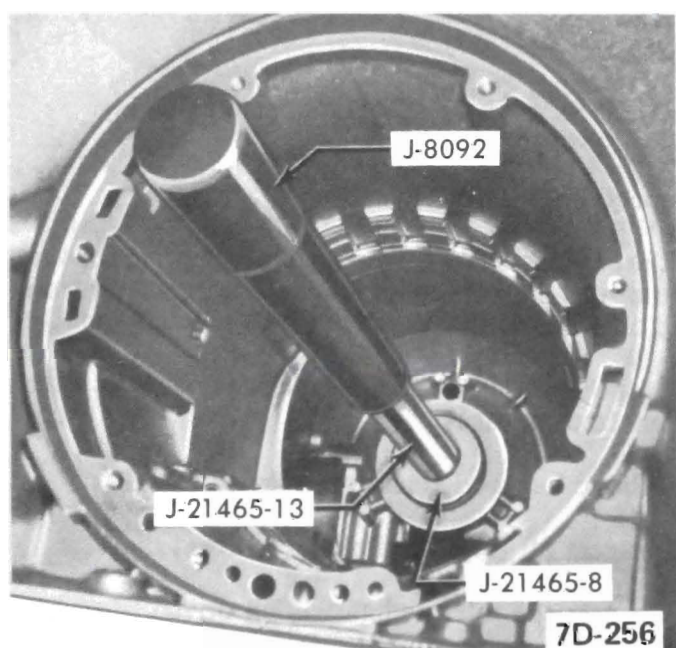


Figure 7D-180

b. Using Adapter J-21465-9 on J-21465-8 driver handle and extension J-21465-13, with lube passage facing front of transmission case, install new bushing into case, until .040" - .055" above selective thrust washer face. See Figure 7D-181.

c. Using J-21465-10 stake bushing in oil groove.

B. Inspection of Front and Rear Bands and Center Support-to-Case Spacer

1. Inspect the lining for cracks, flaking, burning or looseness. See Figure 7D-182.

2. Inspect the bands for cracks or distortion.

3. Inspect the end for damage at the anchor lugs or apply lugs.

4. Inspect support to case spacer for burrs or raised

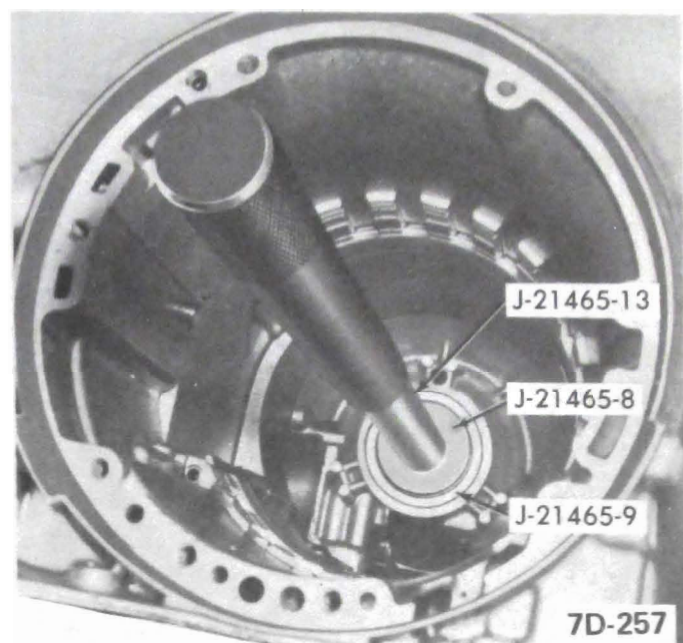
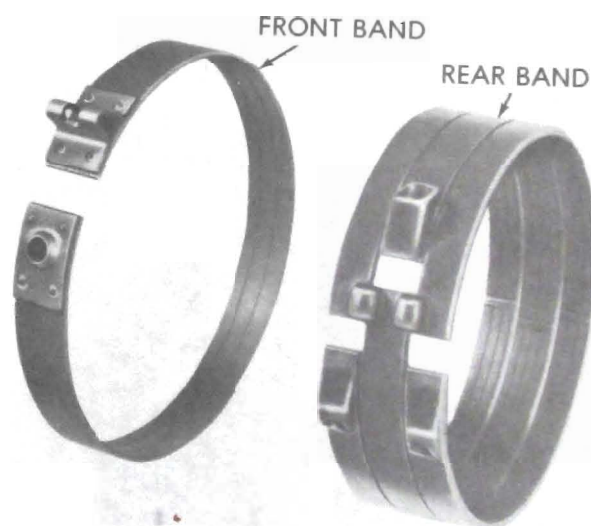


Figure 7D-181



7D-258

Figure 7D-182

edges. If present, remove with a stone or fine sand paper.

Inspection of Case Extension

1. Inspect the bushing for excessive wear or damage. If replacement is necessary, remove rear seal, position housing on bench with seal end up, and proceed as follows:

a. Using Drive Handle J-8092 and Tool J-21465-17, remove bushing. See Figure 7D-183.

b. Using Drive Handle J-8092 and Tool J-21465-17, install bushing. See Figure 7D-183.

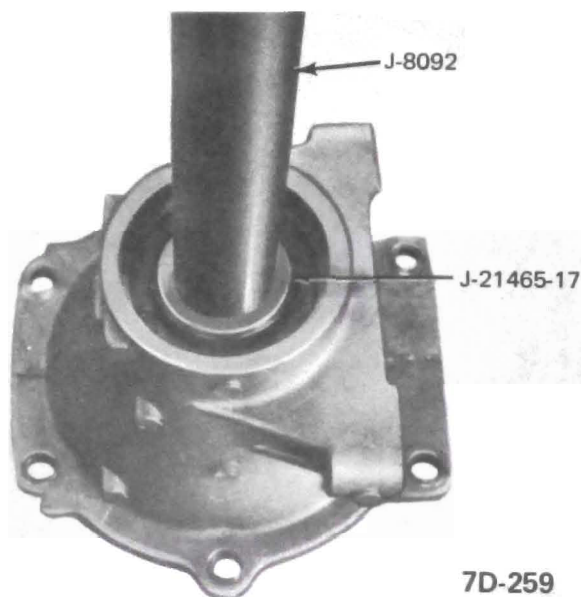


Figure 7D-183

- c. Using J-21465-10, stake bushing in oil grooves.
See Figure 7D-184.

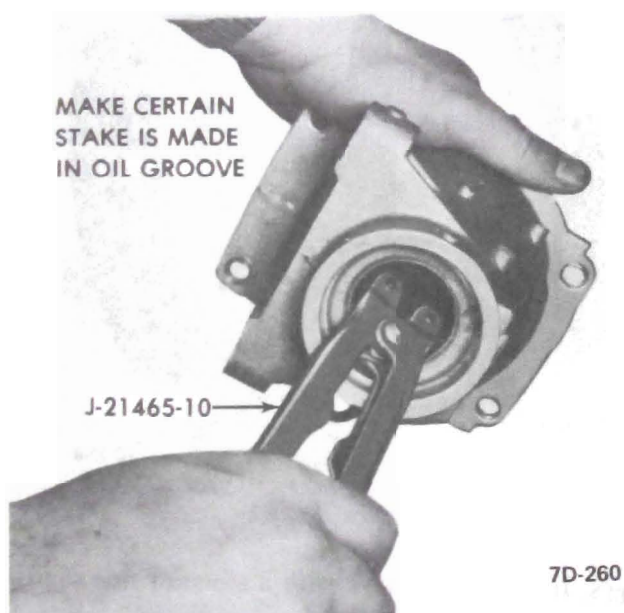


Figure 7D-184

2. Inspect the housing for cracks or porosity.
3. Be sure rear seal drain back port is not obstructed.

Inspection of Manual and Parking Linkage

1. Inspect the parking pawl actuator rod for cracks or broken spring retainer lugs.
2. Inspect the actuator spring for damage.

3. Inspect actuator for a free fit on the actuator rod.
4. Inspect the parking pawl for cracks or wear, if removed.
5. Inspect the manual shaft for damaged threads, rough oil seal surface or loose lever.
6. Inspect the inside detent lever for cracks or a loose pin.
7. Inspect the parking pawl shaft for damaged retainer groove if removed.
8. Inspect the parking pawl return spring for deformed coils or ends.
9. Inspect the parking lock bracket for cracks or wear.
10. Inspect detent roller and spring assembly.

Inspection of Case Assembly

If the case assembly requires replacement, make sure the center support-to-case spacer is removed from the old case and reinstalled in the new case.

1. Inspect case assembly for cracks, porosity or interconnected passages.
2. Check for good retention of band anchor pins.
3. Inspect all threaded holes for thread damage.
4. Inspect the intermediate clutch driven plate lugs for damage or brinelling.
5. Inspect the snap ring grooves for damage.
6. Inspect the bore of the governor assembly for scratches or scoring.
7. Inspect the modulator valve bore for scoring or damage.
8. Inspect the cup plug inside the case for good staking and sealing.

Inspection of Torque Converter

1. Check converter for leaks as follows: (See Figure 7D-185).
 - a. Install Tool J-21369, and tighten.
 - b. Fill converter with air; 80 psi.
 - c. Submerge in water and check for leaks.

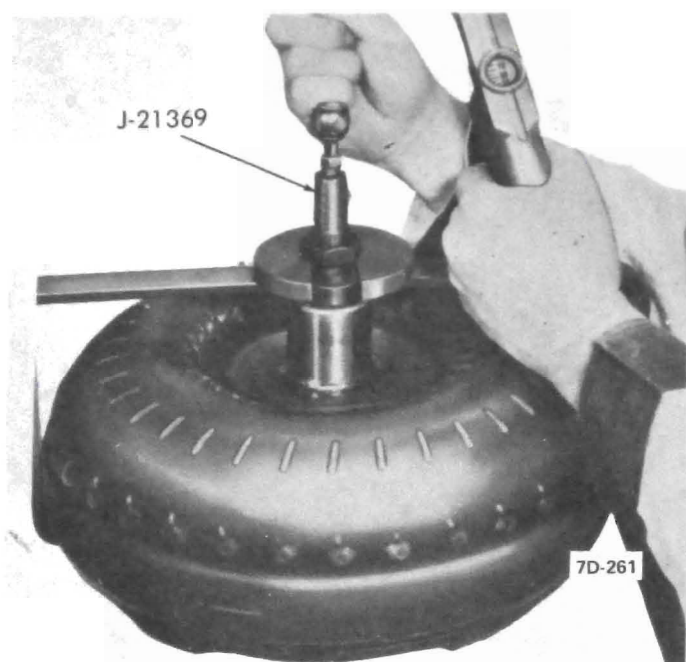


Figure 7D-185

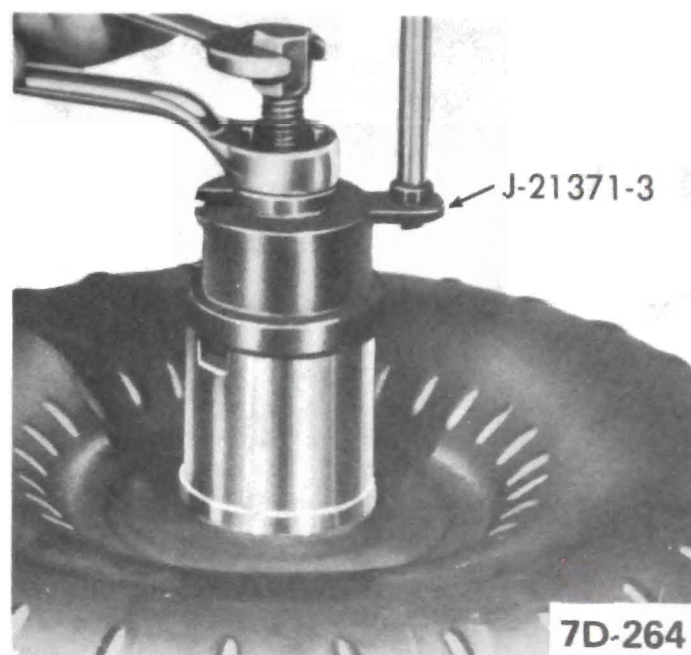


Figure 7D-188

2. Check converter hub surfaces for signs of scoring or wear.

3. Check converter end clearance as follows:

a. Install Tool J-21371-2 and tighten brass nut. See Figure 7D-186.

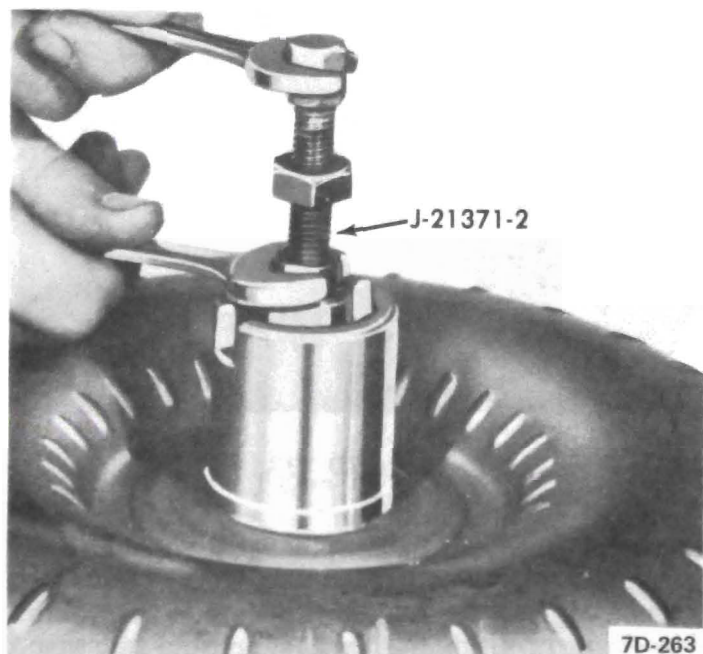


Figure 7D-186

b. Install Tool J-21371-3 and tighten hex nut. See Figure 7D-188.

c. Install dial indicator set at 0 as shown in Figure 7D-189.

d. Loosen hex nut. When nut is fully loosened the

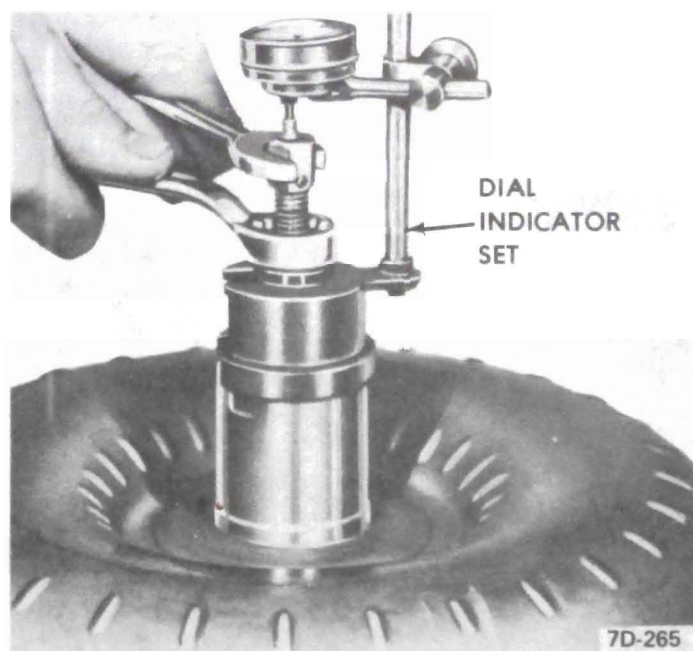


Figure 7D-189

reading obtained on the dial indicator will be converter end clearance. If clearance is .050" or over and the oil has the appearance of having been mixed with aluminum paint, replace the converter. See Figure 7D-189.

ASSEMBLY OF MAJOR UNITS

The first three steps can be omitted if the parts involved were not removed on disassembly.

1. Install the parking pawl, tooth toward the inside case and parking pawl shaft. See Figure 7D-190.

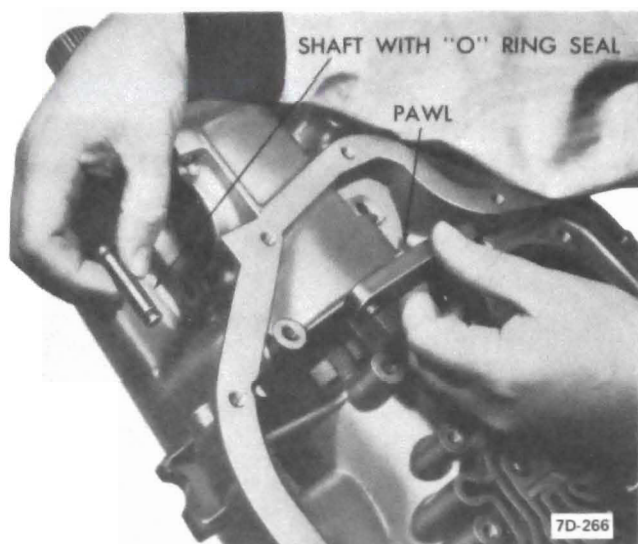


Figure 7D-190

2. Install the parking pawl shaft retainer clip. See Figure 7D-191.

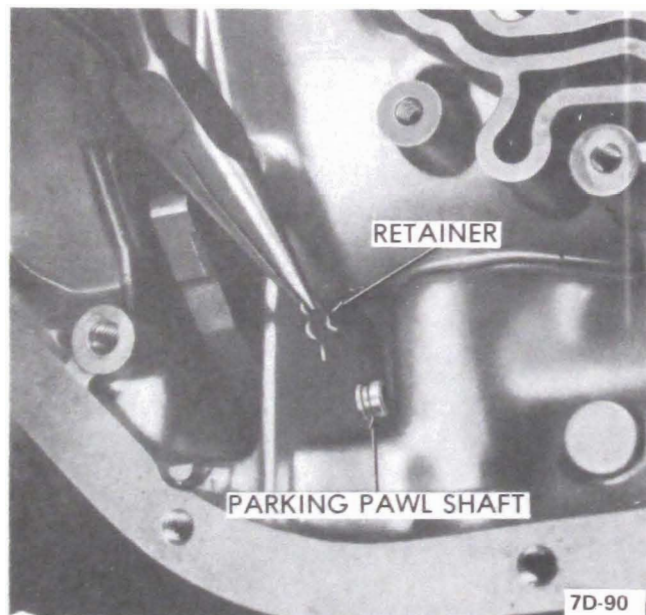


Figure 7D-191

3. Install cup plug and drive into case, using a 3/8" dia. rod, until parking pawl shaft bottoms on case rib. See Figure 7D-192.

4. Install the parking pawl return spring, square end hooked on pawl. See Figure 7D-193.

5. Install the parking lock bracket, guides over parking pawl, using two attaching bolts torque to 15-20 lb.ft. See Figure 7D-194.

6. Install the support to case spacer against the shoulder at the bottom of case splines and the gap located

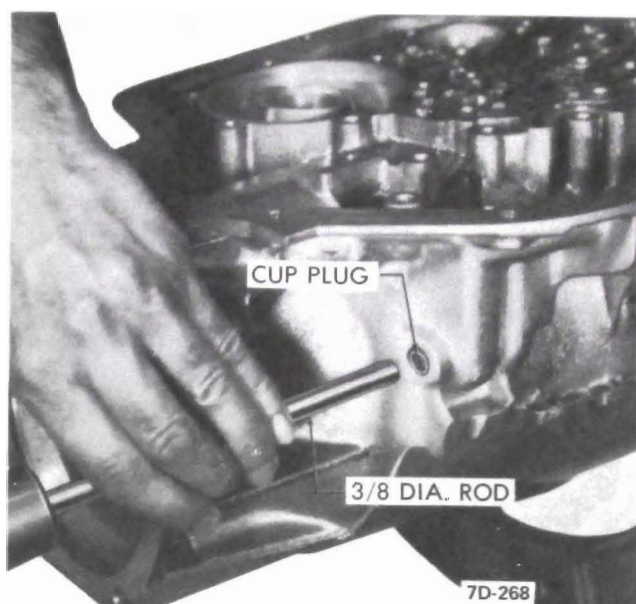


Figure 7D-192

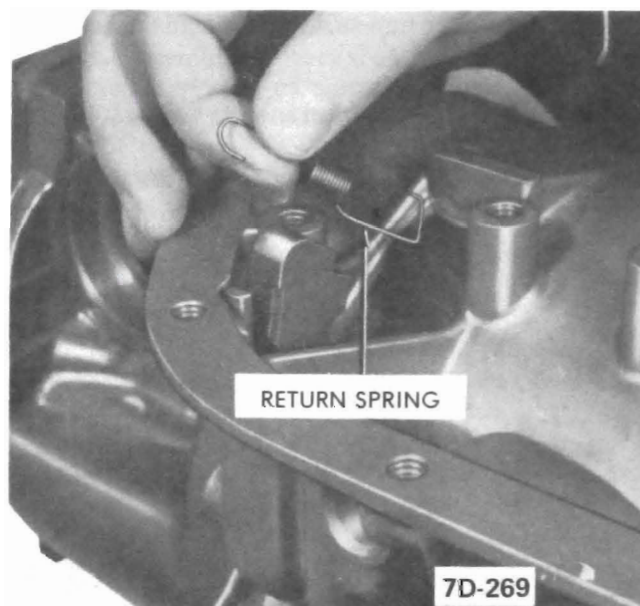


Figure 7D-193

adjacent to the band anchor pin. See Figure 7D-195.

Do not confuse this spacer (.040" thick and both sides flat) with either the center support to case snap ring (one side beveled) or the intermediate clutch backing plate to case snap ring (.093" thick and both sides flat).

7. Install the rear band assembly so that the two lugs index with the two anchor pins. See Figure 7D-196. Check band to be sure band ends are seated on lugs.

8. Lubricate and install selective washer into slots

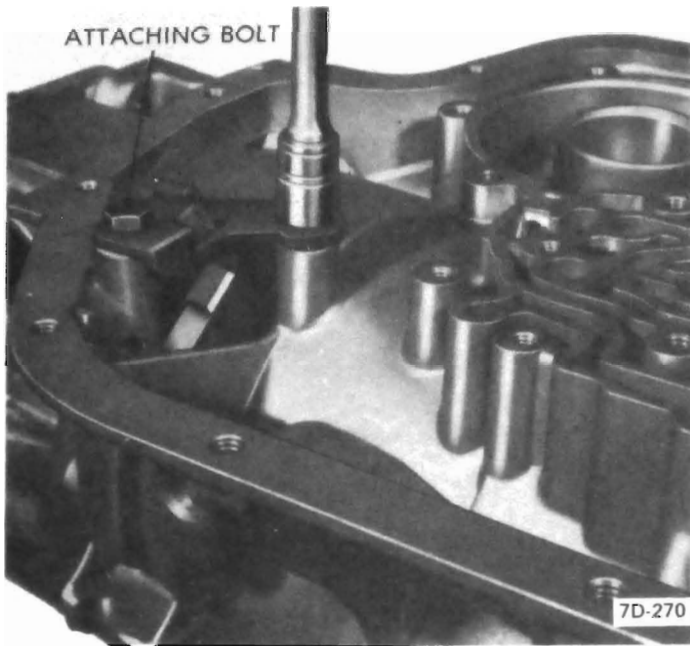


Figure 7D-194

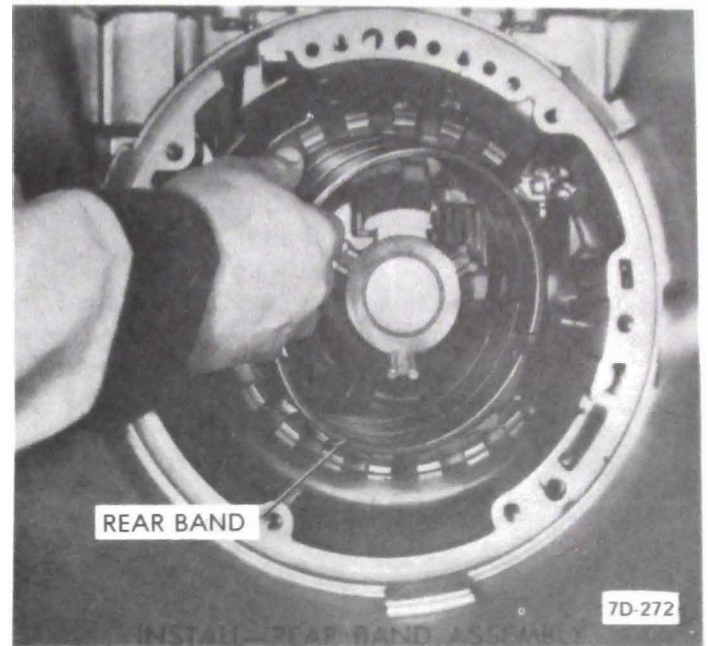


Figure 7D-196

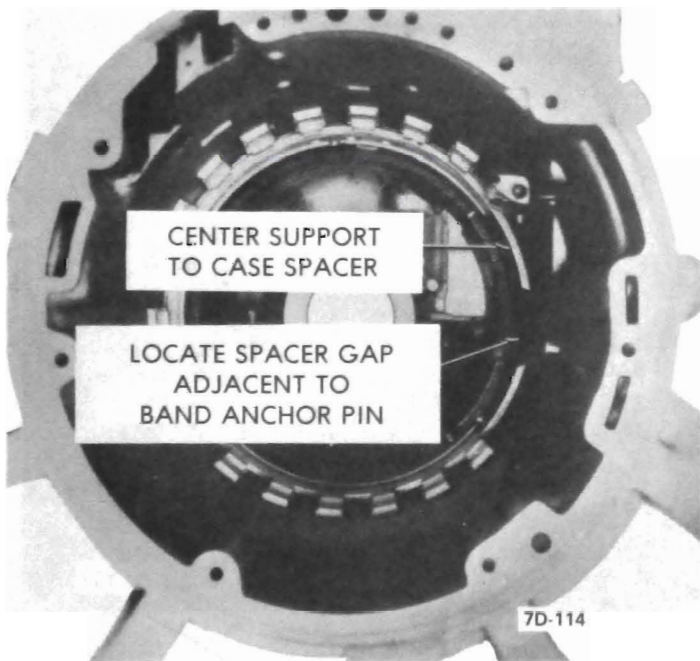


Figure 7D-195

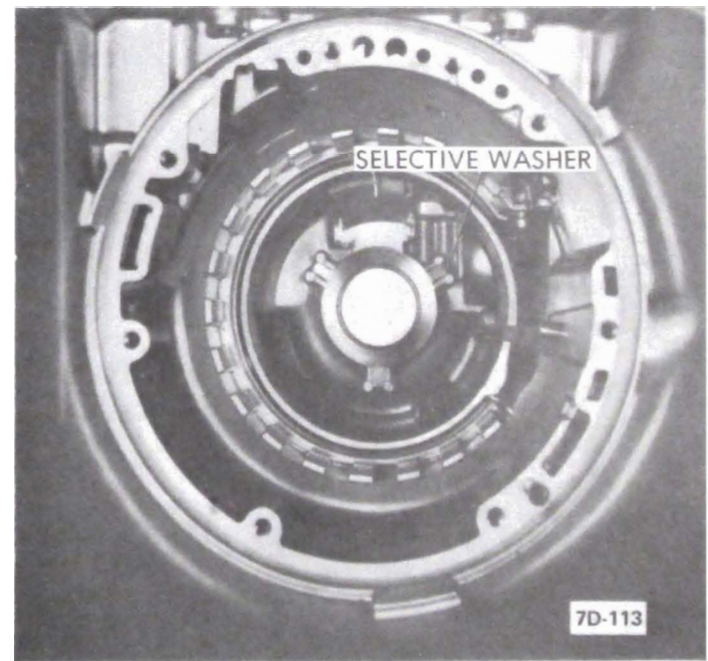


Figure 7D-197

provided inside rear of transmission case. See Figure 7D-197.

9. Install complete gear unit assembly into case making certain center support bolt hole is properly aligned with hole in case. See figure 7D-198.

Make certain tangs on output shaft to case thrust washer are positioned in pockets.

10. Install center support to case retaining snap ring with bevel side up, flat side against center support, and locating gap adjacent to band anchor pin. Make

certain ring is properly seated in case. See Figure 7D-199.

11. Install case to center support bolt by placing the center support locating tool J-23093 into the case direct clutch passage, with the handle of the tool pointing to the right as viewed from the front of the transmission and parallel to the bell housing mounting face. See Figure 7D-200.

Apply pressure downward on Tool J-23093 handle which will tend to rotate the center support counter-clockwise as viewed from the front of the transmission. While holding the center support firmly coun-

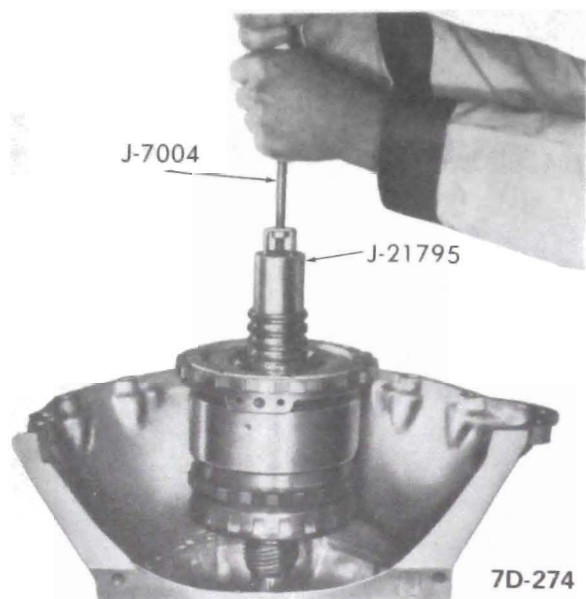


Figure 7D-198

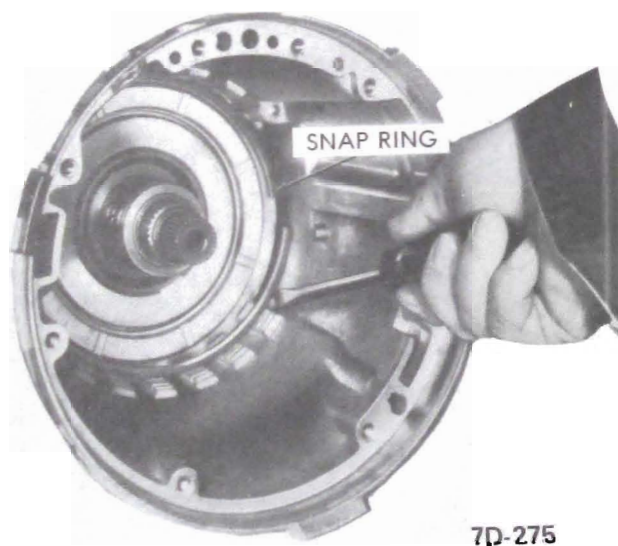


Figure 7D-199

ter- clockwise against the case splines, torque the case to center support bolt to 20-25 lb. ft., using a 3/8" 12- point thin wall deep socket.

When using locating tool, care must be taken not to raise burrs on the case valve body mounting face.

12. Lubricate with transmission fluid and install three (3) steel and three (3) composition intermediate clutch plates. Start with waved steel and alternate composition and steel clutch plates. See Figure 7D-201.

No waved plate used in Model "BB". Three (3) flat steel plates are used.

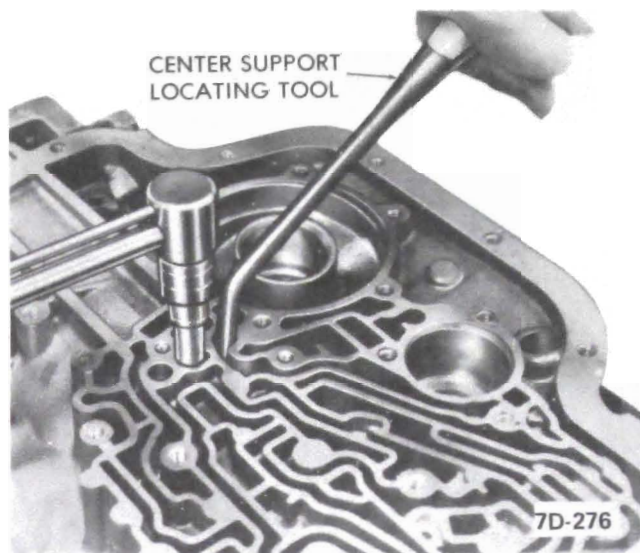


Figure 7D-200

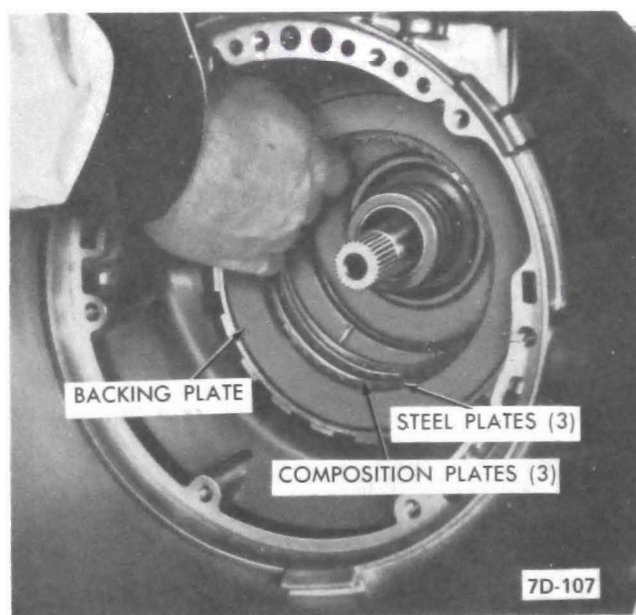


Figure 7D-201

13. Install the intermediate clutch backing plate ridge up.

14. Install the intermediate clutch backing plate to case snap ring. Gap in snap ring should be opposite band anchor pin. See Figure 7D-202.

Both sides of this snap ring are flat and it is .093" thick.

15. Check rear end play as follows:

a. Install J-7004 into an extension housing attaching bolt hole. See Figure 7D-203.

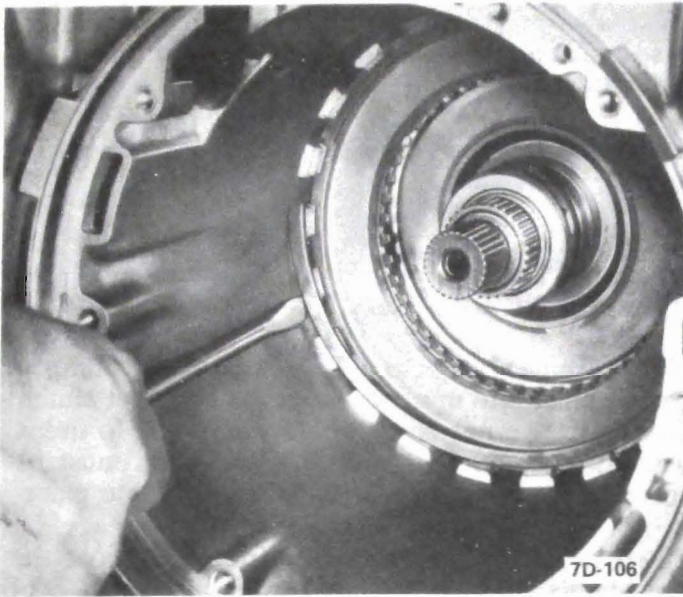


Figure 7D-202

b. Mount the Dial Indicator, J-8001, on the rod and index with the end of the output shaft.

c. Apply air pressure to apply the intermediate clutch (center oil passage) while moving the output shaft in and out to read the end play. End play should be from .007" - .019". The selective washer controlling this end play is the steel washer having 3 lugs that is located between the thrust washer and the rear face of the transmission case.

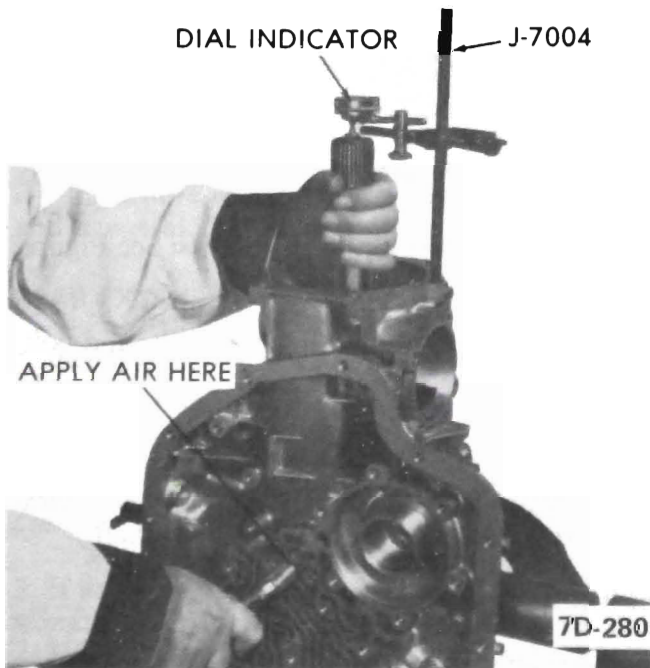


Figure 7D-203

If a different washer thickness is required to bring the end play within specification, it can be selected from the following chart.

Thickness	Notches and/or Numeral	
.074"-.078"	None	1
.082"-.086"	1 Tab Side.....	2
.090"-.094"	2 Tabs Side.....	3
.098"-.102"	1 Tab O.D.....	4
.106"-.110"	2 Tabs O.D.....	5
.114"-.118"	3 Tabs O.D.....	6

16. Install front band with band anchor hole placed over the band anchor pin and apply lug facing servo hole. See Figure 7D-205.

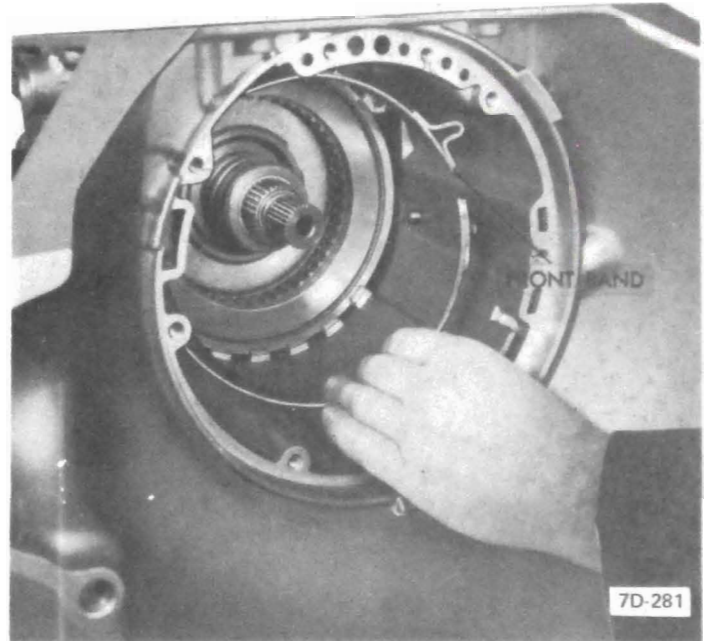


Figure 7D-205

17. Install the direct clutch and intermediate roller clutch assembly. It will be necessary to twist the

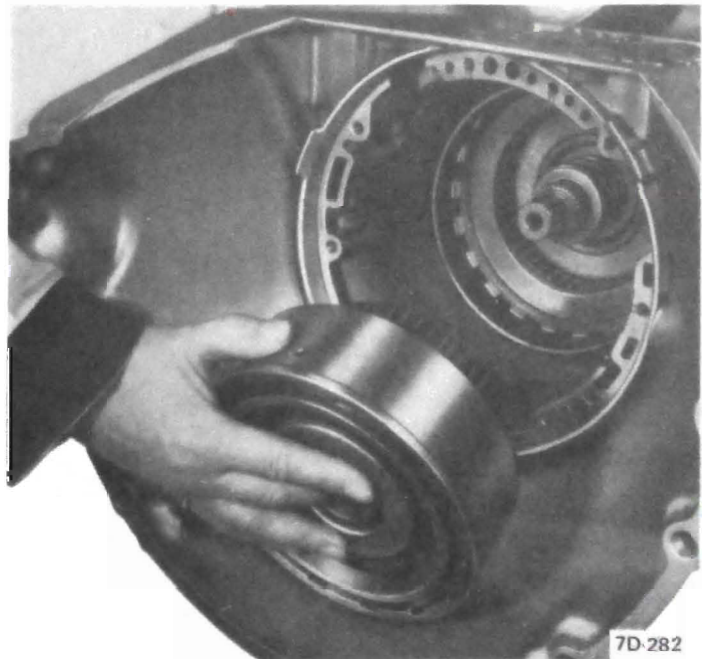


Figure 7D-206

housing to allow the outer race to index with the composition clutch plates. The housing hub will bottom on the sun gear shaft. See Figure 7D-206.

Removal of direct clutch, composition and steel plates may be helpful.

18. Install the forward clutch hub to direct clutch housing thrust washer on the forward clutch hub. Retain with petroleum jelly.

19. Install the forward clutch and turbine shaft assembly, see Figure 7D-207, indexing the direct clutch hub so end of the mainshaft will bottom on

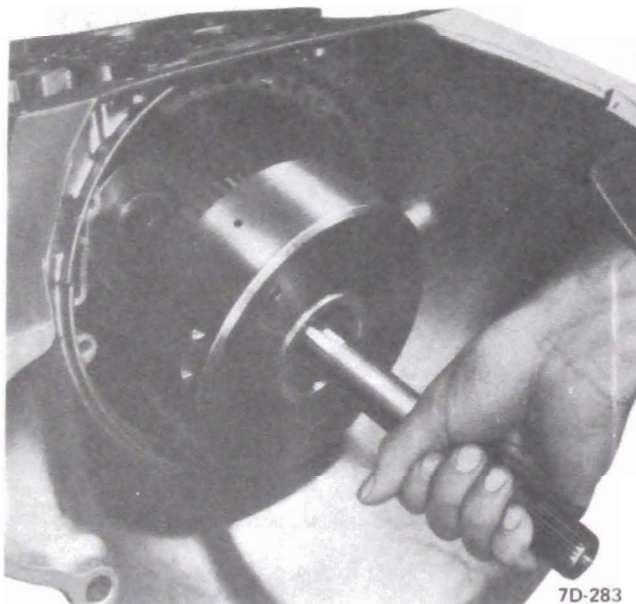


Figure 7D-207

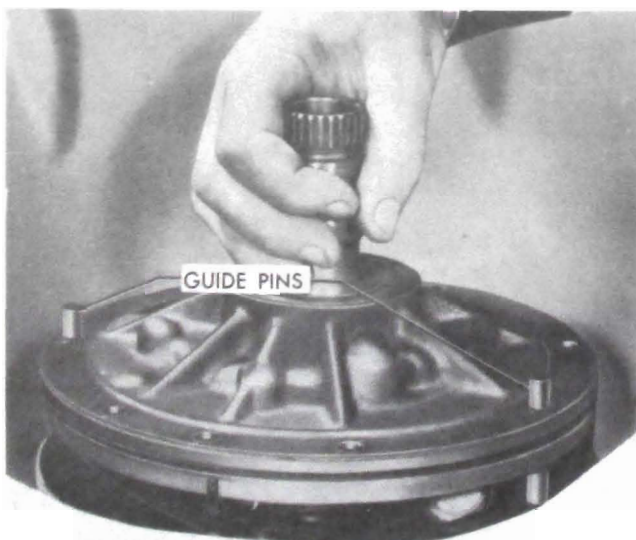


Figure 7D-208

end of the forward clutch hub. When forward clutch is seated it will be approximately 1-1/4" from pump face in case.

20. Install guide pins into transmission case. See Figure 7D-208.

21. Install the front pump assembly, gasket and pump and all but one attaching bolt and seal. *Always use new seal on bolt.* Torque 15-20 lb. ft.

If the turbine shaft cannot be rotated as the pump is being pulled into place, the forward or direct clutch housings have not been properly installed to index with all the clutch plates. This condition must be corrected before the pump is pulled fully into place.

22. If necessary, install a new front seal, coat the outside diameter with a good sealer and using Tool J-21359, drive the seal in place. See Figure 7D-209.

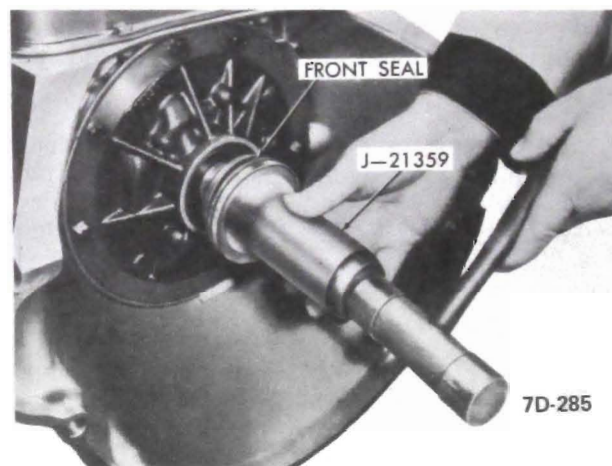


Figure 7D-209

23. Check front unit end play as follows: See Figure 7D-210.

- a. Remove one front pump attaching bolt, and bolt seal.
- b. Install J-7004, Slide Hammer into bolt hole.
- c. Mount the dial indicator on the rod and index indicator to register with end of turbine shaft.
- d. Push turbine shaft rearward.
- e. Push output shaft forward.
- f. Set dial indicator to zero.
- g. Pull turbine shaft forward.

Read the resulting travel or end play which should be .003" - .024".

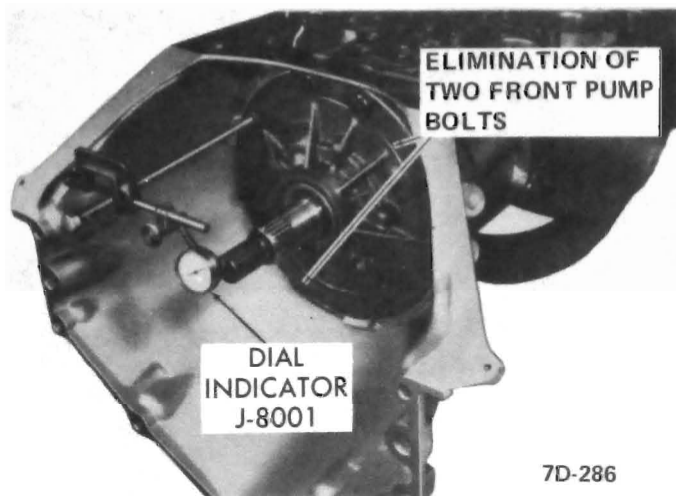


Figure 7D-210

The selective washer controlling this end play is the washer located between the pump cover and the forward clutch housing. If more or less washer thickness is required to bring end play within specifications, select the proper washer from the chart below.

Thickness	Color
.060-.064	Yellow
.071-.075	Blue
.082-.086	Red
.093-.097	Brown
.104-.108	Green
.115-.119	Black
.126-.130	Purple

An oil soaked washer may tend to discolor so that it will be necessary to measure the washer for its actual thickness.

24. Install the remaining front pump attaching bolt and new seal. Torque bolts to 15-20 lb. ft.

REAR EXTENSION HOUSING

1. Install the extension housing to case gasket on the extension housing.
2. Attach the extension housing to the case using attaching bolts. Torque bolts to 20-25 lb. ft. See Figure 7D-211.
3. If necessary, install a new rear seal, coat the outside diameter with a good sealer and using Tool J-21359 drive the seal in place. See Figure 7D-212.

INSTALLATION MANUAL LINKAGE

1. Install a new manual shaft to case lip seal.
2. If removed, insert the actuator rod into manual detent lever from side opposite pin.

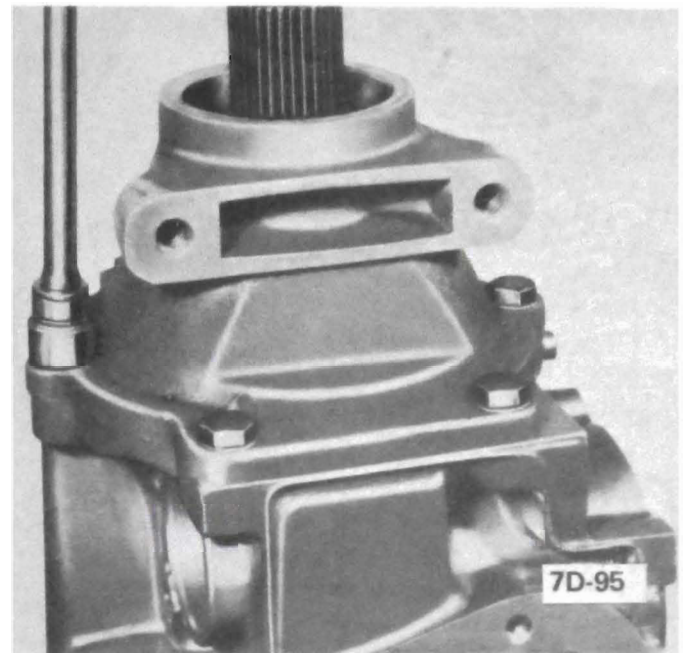


Figure 7D-211



Figure 7D-212

3. Install the actuator rod plunger under the parking bracket and over the parking pawl.
4. Install the manual shaft through the case and detent lever. See Figure 7D-213.
5. Install retaining hex-lock nut on manual shaft. See Figure 7D-214.
6. Install manual shaft retaining pin indexing with groove in manual shaft. See Figure 7D-215.

It may be necessary to bend pin to install. Straighten pin as it is installed.

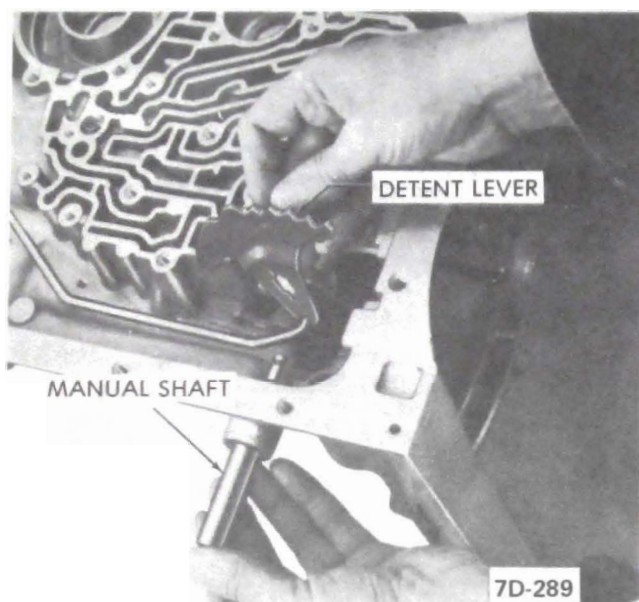


Figure 7D-213

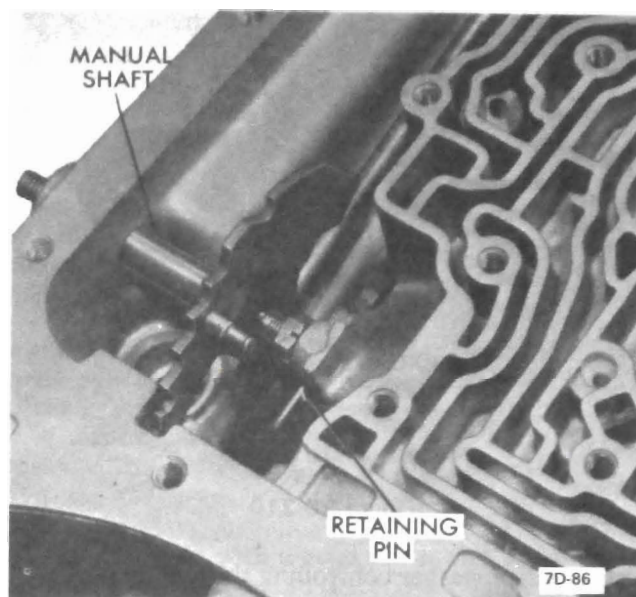


Figure 7D-215

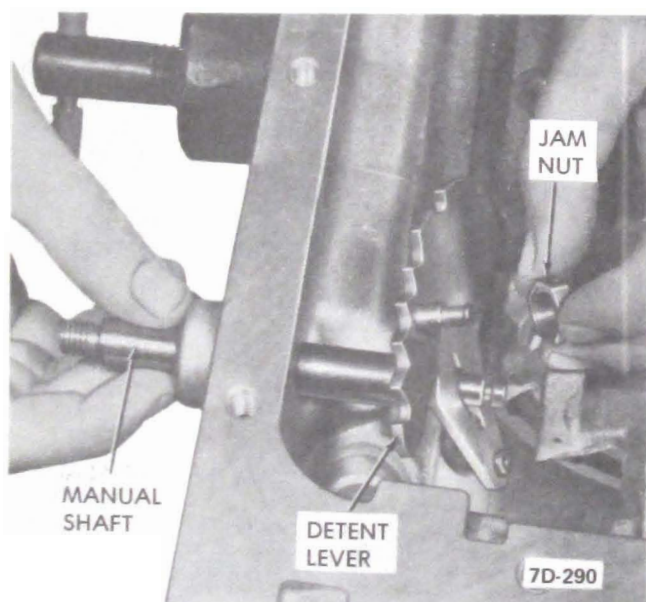


Figure 7D-214

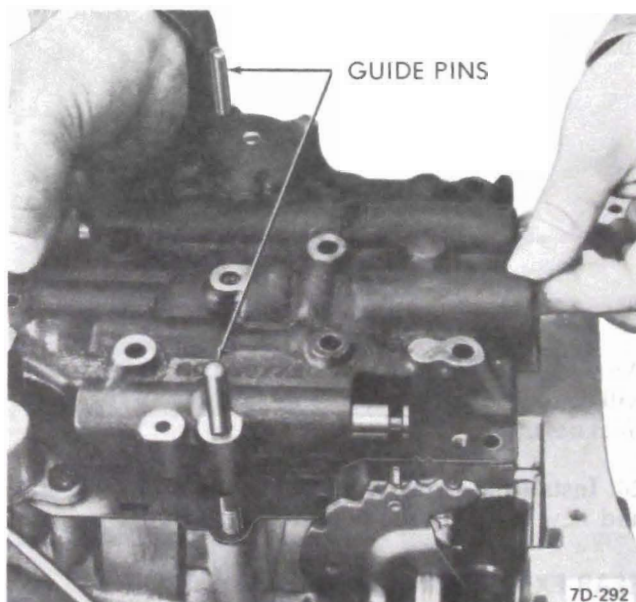


Figure 7D-216

7. Tighten lock nut on manual shaft.

INSTALLATION OF CHECK BALLS, CONTROL VALVE SPACER PLATE AND GASKET, DETENT SOLENOID, FRONT SERVO ASSEMBLY, AND ELECTRICAL CONNECTOR

1. Install two control valve assembly attaching bolts with heads cut off as guide pins, as shown in Figure 7D-216.

2. Install six check balls into ball seat pockets in transmission case. See Figure 7D-217.

If transmission is in car, install check balls into ball seat pockets on spacer plate. See Figure 7D-218.

3. Install control valve spacer plate-to-case gasket (gasket with extension for detent solenoid).

4. Install control valve spacer plate.

5. Install detent solenoid gasket. See Figure 7D-219.

6. Install detent solenoid assembly with connector facing outer edge of case. Do not tighten bolts at this time.

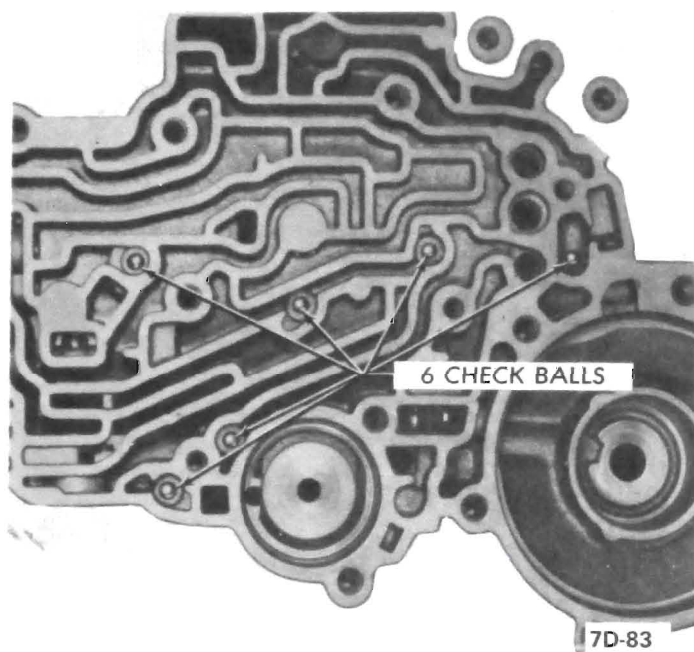


Figure 7D-217

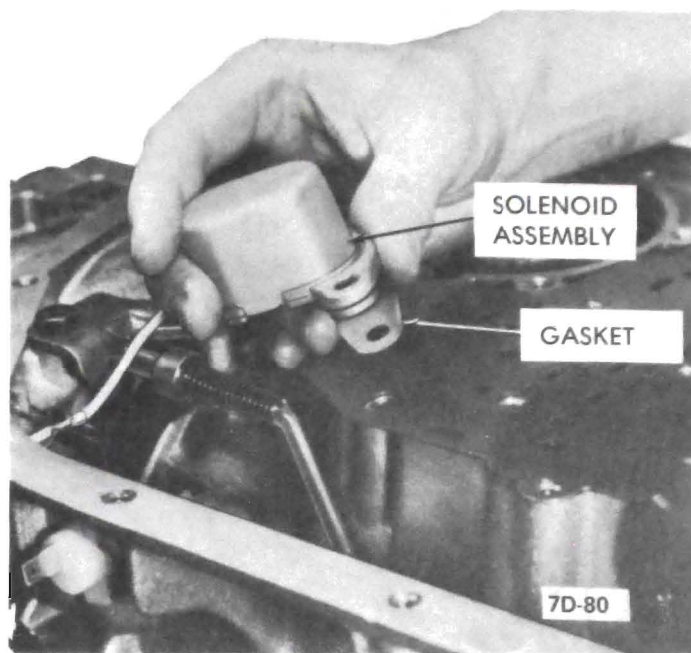


Figure 7D-219

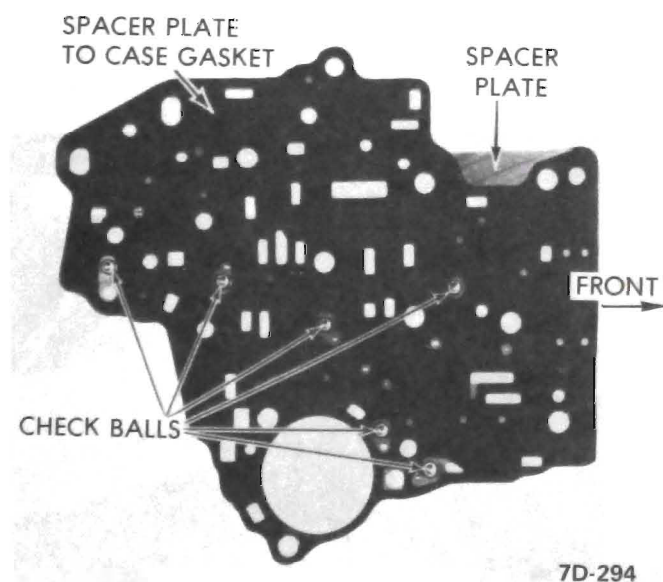


Figure 7D-218

7. Install front servo spring and spring retainer into transmission case. See Figure 7D-220.

8. Install retainer ring in front servo pin groove and install pin into case so that tapered end contacts band. Make certain retainer ring is installed in servo pin groove.

9. Install seal ring on servo piston, if removed, and install on servo pin with flat side of piston positioned toward bottom pan. See Figure 7D-220.

The teflon ring allows the front servo piston to slide very freely in the case. The free fit of the ring in the bore is a normal characteristic and does not indicate leakage during operation. The teflon ring should

only be replaced if it shows damage or if evidence of leakage during operation exists.

If transmission is in car, assemble front servo group, as shown in Figure 7D-220, and install this group of parts into front servo bore in case and hold. Slip a length of straight, clean feeler gauge or shim stock (about .020") between spacer plate and front servo piston to temporarily retain front servo group. See Figure 7D-222.

10. Install "O" ring seal on the solenoid connector.

11. Install connector with lock tabs facing into case, positioning locator tab in notch on side of case. See Figure 7D-223. *

12. Install detent wire and lead wire to case connector. See Figure 7D-224. (Lead wire used only with "BB" Model).

Check by pulling on detent connector wire. If detent connector wire can be removed, turn wire connector over and reinstall into connector. See Figure 7D-224.

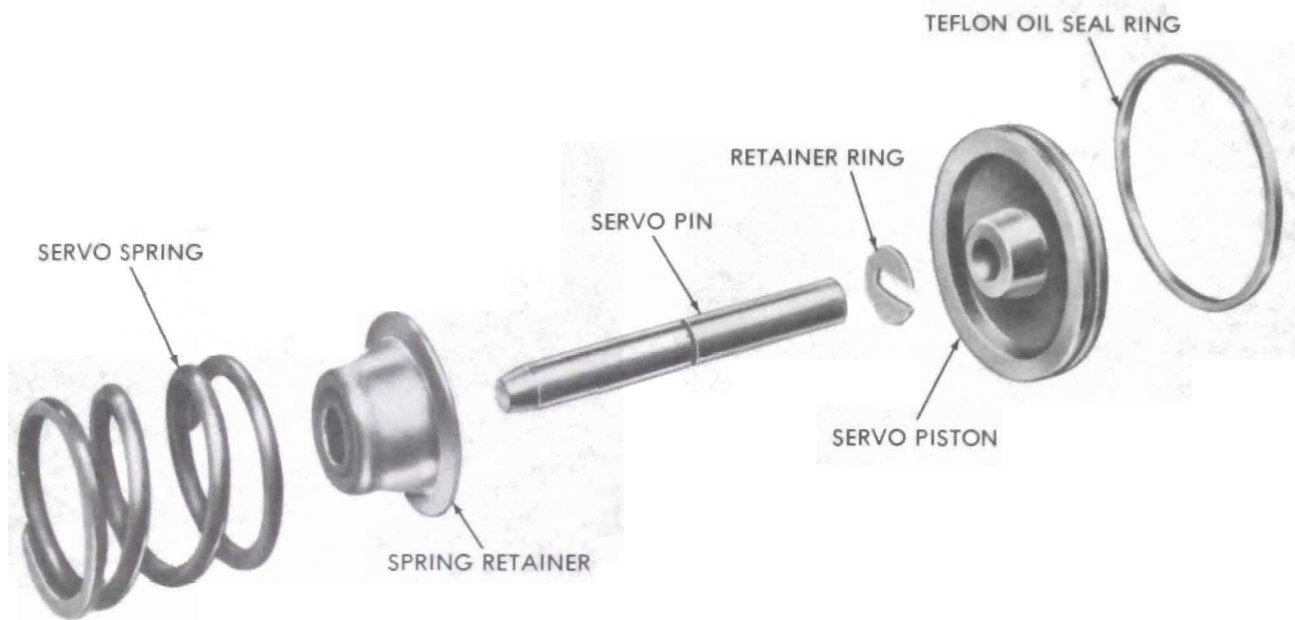
INSTALLATION OF REAR SERVO ASSEMBLY

1. Install rear servo accumulator spring into case.

2. Install rear servo assembly into case. See Figure 7D-225.

3. Install rear servo gasket and cover.

4. Install attaching bolts. Torque bolts to 15- 20 lb. ft. See Figure 7D-226.



7D-166

Figure 7D-220 Front Servo

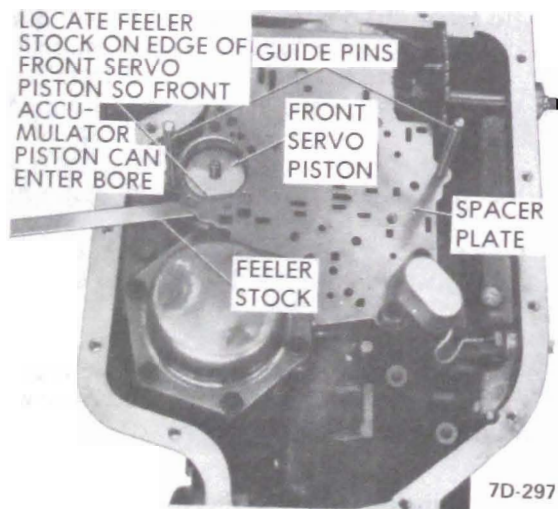


Figure 7D-222

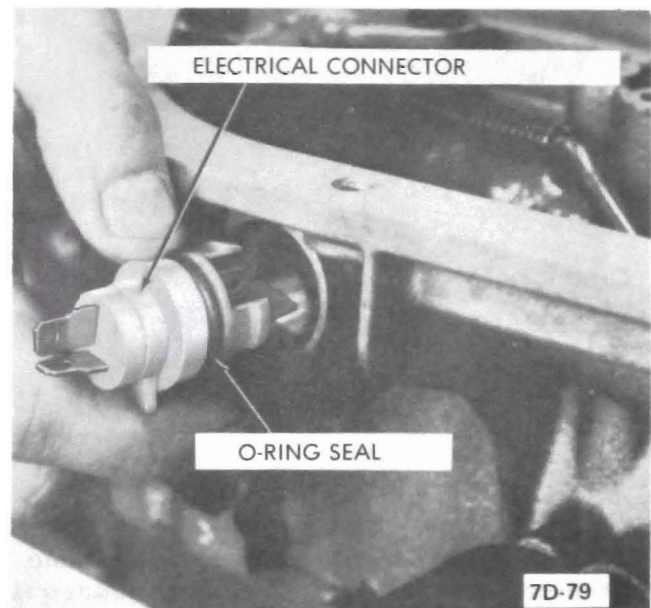


Figure 7D-223

INSTALLATION OF CONTROL VALVE ASSEMBLY, GOVERNOR PIPES, AND GOVERNOR SCREEN

1. Install valve body to spacer plate gasket. See Figure 7D-227.
2. Install governor pipes on control valve assembly. Governor pipes are interchangeable. See Figure 7D-228.
3. Install governor screen assembly, *open end first*,

into governor feed pipe hole in case (hole nearest the center of transmission). See Figure 7D- 229.

If transmission is in vehicle, before installing the control valve assembly and governor pipes, as outlined in Step 3 below, insert governor screen, closed end first, into governor feed pipe. (This pipe locates in the governor feed pipe hole in the case nearest the center of the transmission).

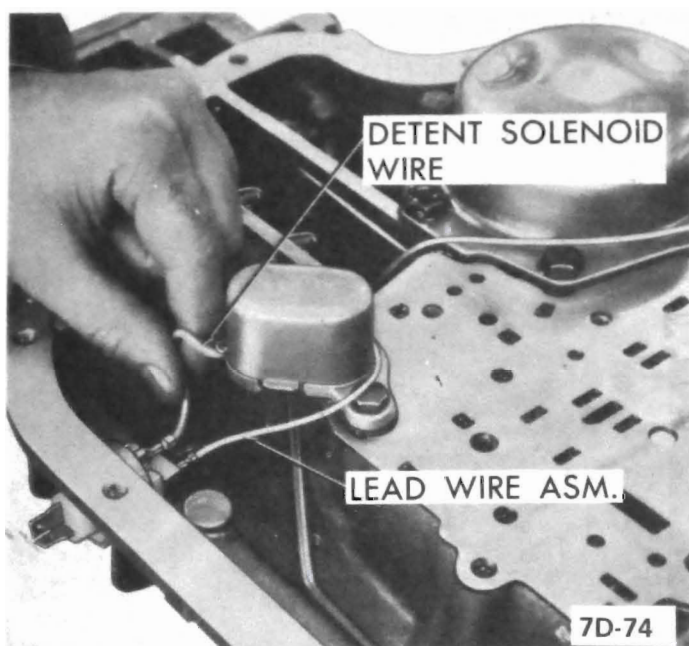


Figure 7D-224

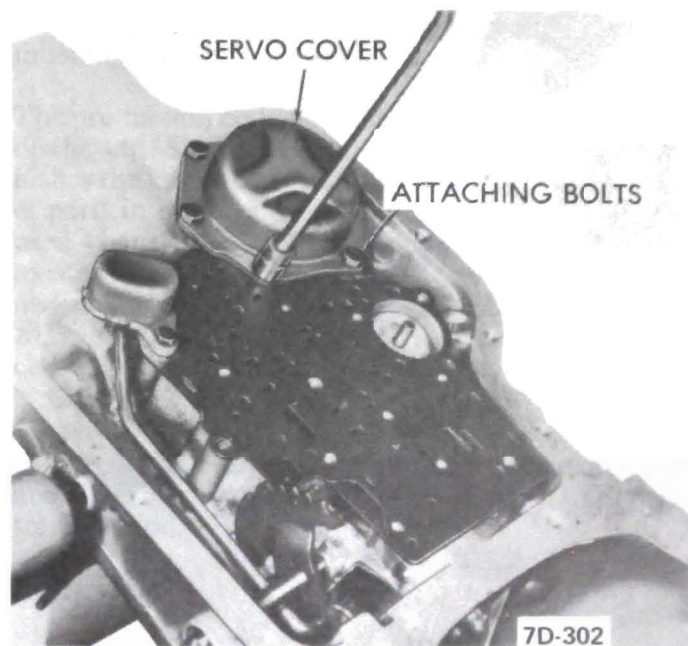


Figure 7D-226 Rear Servo Cover

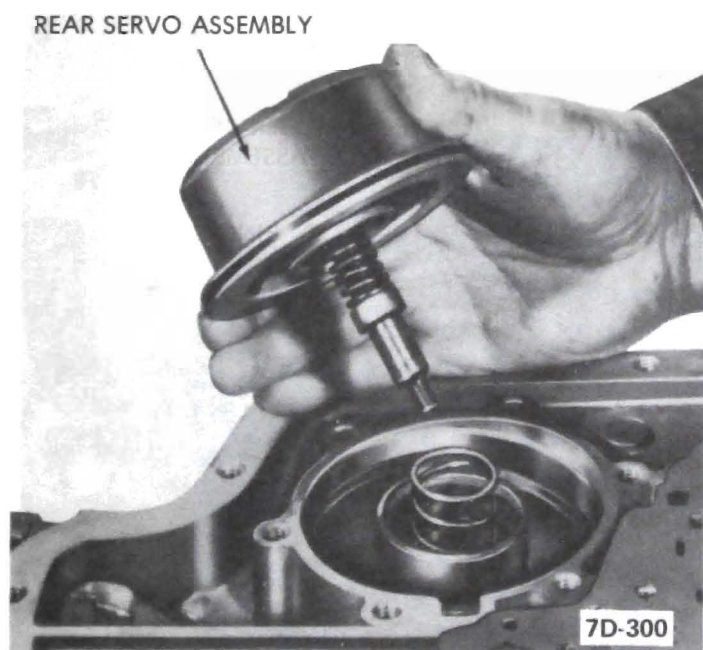


Figure 7D-225

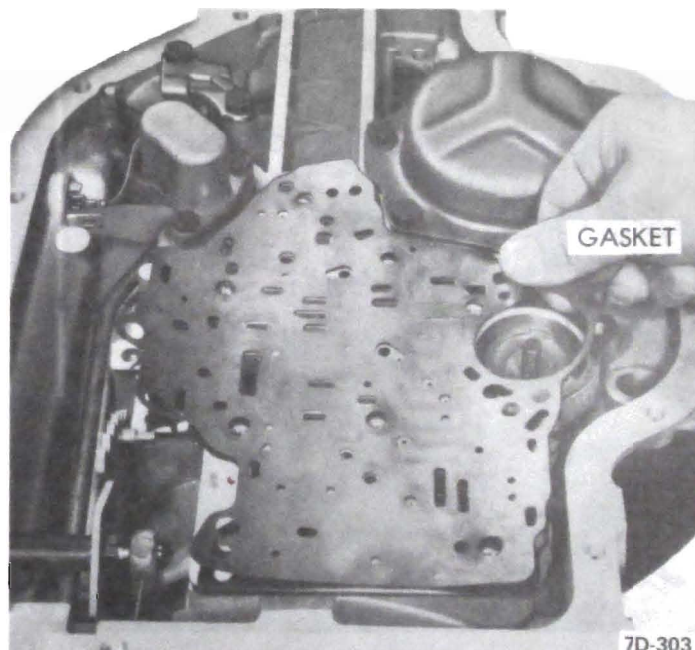


Figure 7D-227

4. Install control valve assembly and governor pipes on transmission, while carefully aligning the governor feed pipe over the governor screen. See Figure 7D-216. Make certain gasket and spacer do not become mispositioned.

Check manual valve to make sure it is indexed properly with pin on detent lever and governor pipes to make certain they are properly seated in case holes.

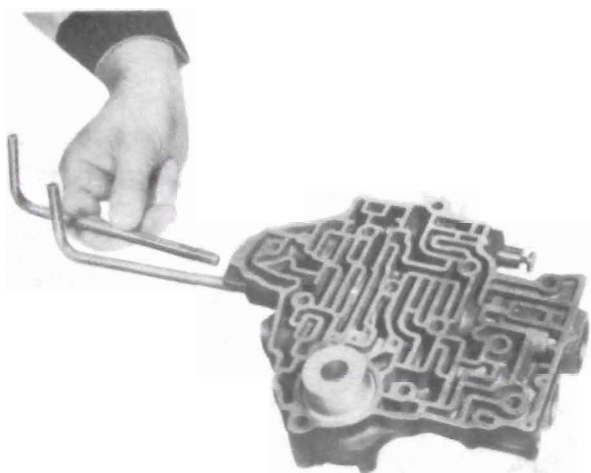
5. Start control valve assembly attaching bolts. If transmission is in vehicle, remove feeler stock before tightening any control valve bolts.

6. Remove guide pins and install detent roller and spring assembly and remaining bolts. See Figure 7D-230.

7. Tighten solenoid and valve body attaching bolts. Torque bolts to 7-10 lb. ft.

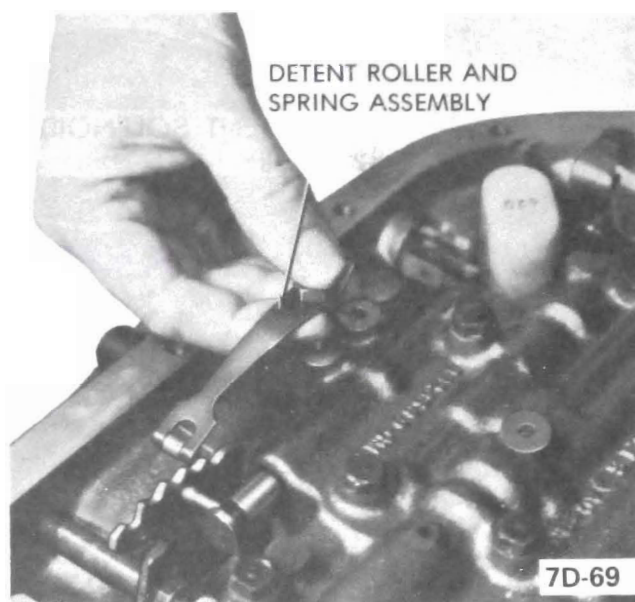
8. If removed, install the pressure switch assembly. (Model "BB" Only)

9. Connect lead wire assembly to pressure switch assembly. Route wire from case electric connector, around solenoid and under governor pipes to pressure switch.



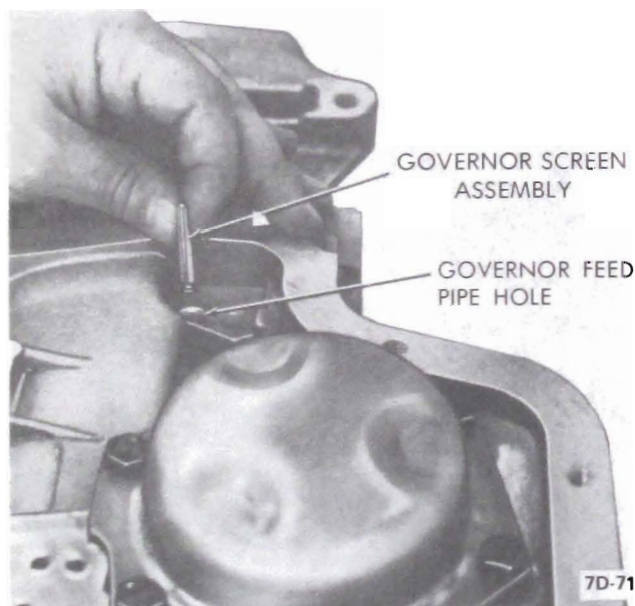
7D-304

Figure 7D-228



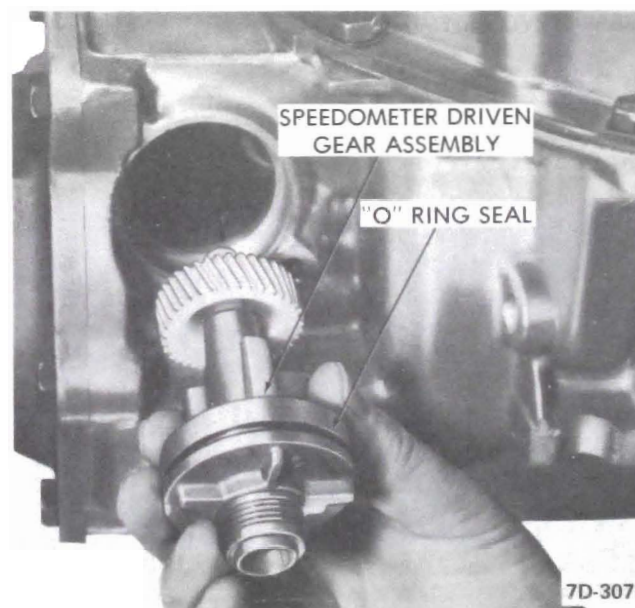
7D-69

Figure 7D-230



7D-71

Figure 7D-229



7D-307

Figure 7D-231

INSTALLATION OF SPEEDOMETER DRIVEN GEAR ASSEMBLY AND CONVERTER ASSEMBLY

1. Install the speedometer driven gear assembly. See Figure 7D-231.
2. Install the speedometer driven gear retainer and attaching bolt. See Figure 7D-232.
3. Install converter assembly into oil pump. Extreme care must be taken not to damage seal. Make certain converter hub drive tangs are fully engaged with pump drive gear tang.

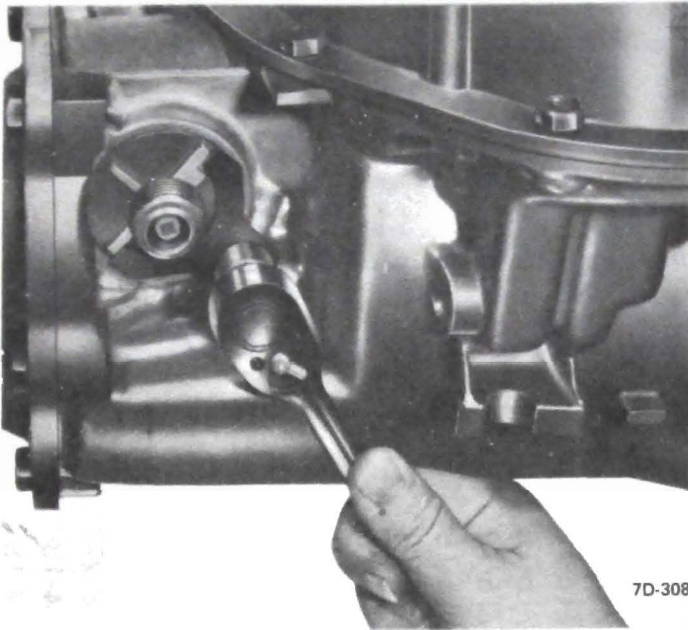
4. Install Converter Holding Tool J-21366 to retain converter until ready to install in car.

INSTALLATION OF GOVERNOR BUSHING

Although location of the governor on the 400 transmission is different from the 350, service procedures are identical. Refer to 350 Section for governor bushing replacement.

Transmission Identification Number

A production identification number is stamped on a



7D-308

Figure 7D-232

metal tag, located in the lower right side of the transmission case.

The production code number is located along the top of the tag. Since the production code number furnishes the key to construction and interchangeability of parts in each transmission, the number should be used when selecting replacement parts as listed in the master parts list. The number should always be furnished on product reports, *Warranty Document forms*, and all correspondence with the factory concerning a particular transmission.

On all 1974 Turbo Hydra-Matic 400 transmissions, the car serial number is stamped on a pad located just above the bottom pan face on the left hand side of the transmission.

SPECIFICATIONS

Trans. Code	Converter Identification Number	Speedometer Drive Gear	Forward Clutch					Direct Clutch			Intermediate Clutch		
			Flat Steel Plates		No. of Waved Steel Plates	No. of Composition Plates	No. of Flat Steel Plates	No. of Waved Steel Plates	No. of Composition Plates	No. of Flat Steel Plates	No. of Waved Steel Plates	No. of Composition Plates	
			No.	Thickness									
BS	5	17 Tooth	4	.0775"	1	5	5		2	1	3		
BC	5	18 Tooth	4	.0775"	1	5	4	1	2	1	3		
BT	5	18 Tooth	4	.0775"	1	5	4	1	2	1	3		
BB	5	17 Tooth	4	.0775"	1	5	6	0	3	0	3		

Forward & Direct Clutch

Waved steel plate thickness — All models — .0615"
 Direct clutch flat steel plate thickness — All models — .0915"

BOLT TORQUE SPECIFICATIONS

Location

	Thread Size	Torque Lbs. Ft.
Solenoid Assembly to Case	1/4-20	8
Valve Body to Case	1/4-20	8
Pump Body to Cover	5/16-18	18
Pump Assembly to Case	5/16-18	18
Rear Servo Cover to Case	5/16-18	18
Governor Cover to Case	5/16-18	18
Parking Brake Bracket to Case	5/16-18	18
Vacuum Modulator Retainer to Case	5/16-18	18
Valve Body to Case	5/16-18	8
Oil Pan to Case	5/16-18	12
Case Extension to Case	3/8-16	23
Oil Filter to Valve Body	1/4-20	10
Pressure Switch Assembly	1/8-27	6-10
Case to Center Support	3/8-16	20-25
Manual Shaft to Inside Detent Lever	3/8-24	15-20
Line Pressure Take-Off	1/8-27	10-15
Cooler Connector to Case	1/4-18	11
Cooler Connector to Radiator	1/4-18	20

4B7D309

Figure 7D-233

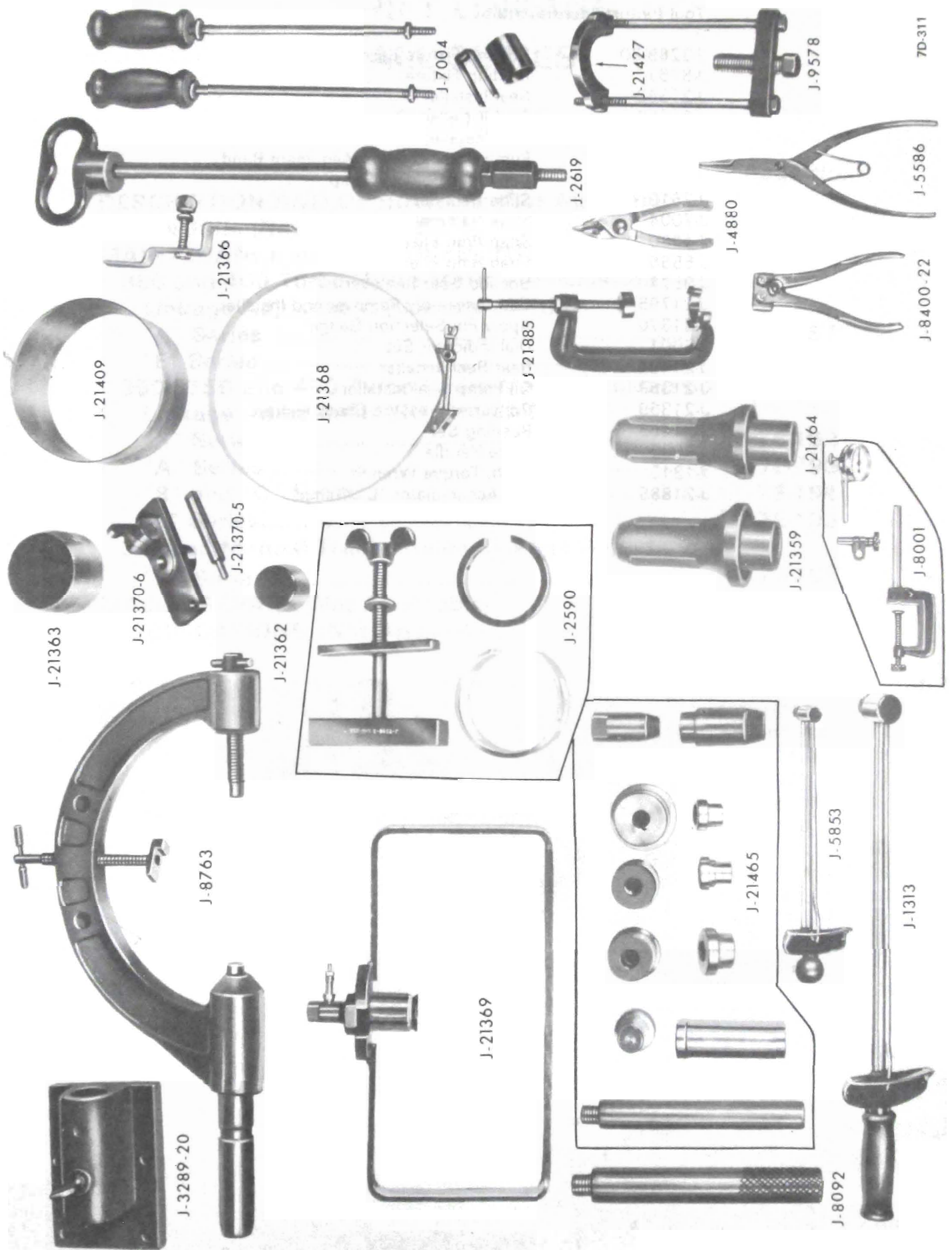


Figure 7D-234 - Tool Picture

Tool Picture Identification

J-3289-20	Holding Fixture Base
J-8763	Holding Fixture
J-21363	Seal Installer
J-21362	Seal Installer
J-21409	Seal Installer
J-21368	Pump Body to Cover Alignment Band
J-21366	Converter Holding Strap
J-2619	Slide Hammer
J-7004	Slide Hammers
J-4880	Snap Ring Pliers
J-5586	Snap Ring Pliers
J-9578	Speedo Gear Remover
J-21795	Gear Assembly Remover and Installer
J-21370	Apply Pin Selection Gauge
J-8001	Dial Indicator Set
J-21464	Rear Seal Installer
J-21359	Oil Pump Seal Installer
J-21369	Converter Pressure Check Fixture
J-21465	Bushing Set
J-8092	Drive Handle
J-1313	Ft.Lb. Torque Wrench
J-21885	1-2 Accumulator "C" Clamp