SHIFT The RE4R01A Kit

TECHNOLOGY PRODUCTS

The Simple Solution

A DIVISION OF SUPERIOR TRANSMISSION PARTS, INC.

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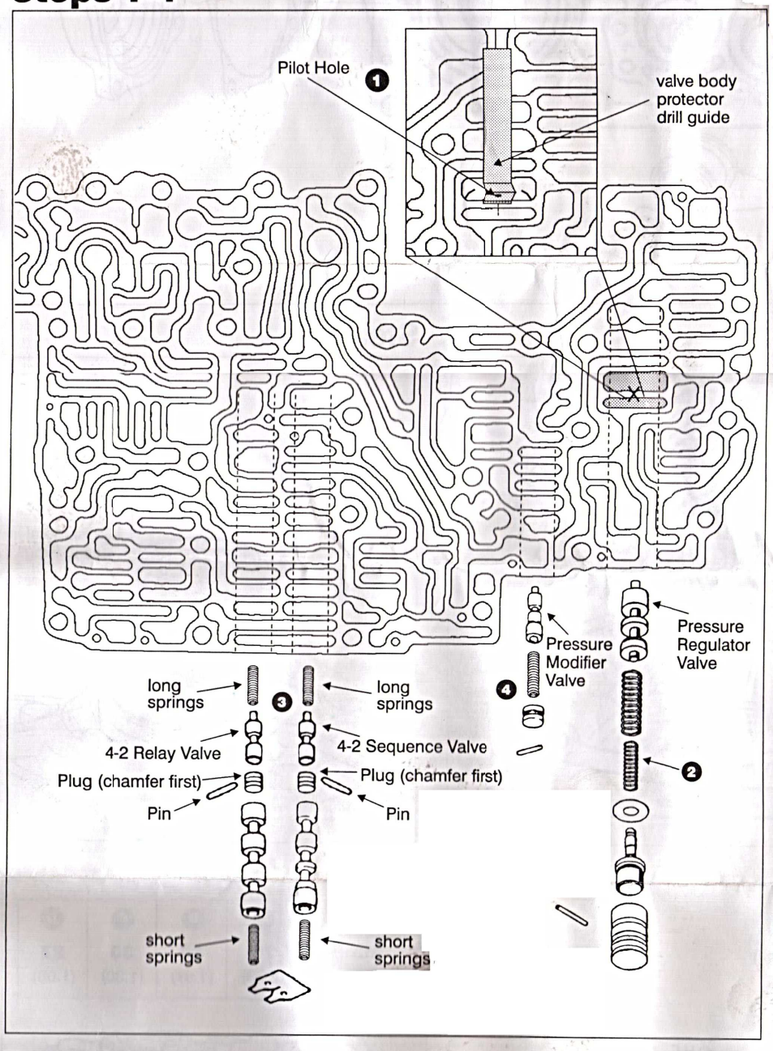
Regular And Heavy Duty Applications

This Correction Package Will Service All RE4R01A Transmissions Thru 2003.

Steps 1-4



Step 1 — Remove pressure regulator valve train from the valve body. Using the (.062 drill bit supplied, crossdrill the valve body wall at the X to connect the shaded areas. The valve body protector drill guide supplied will aid in drilling this hole. Set guide down in widest channel with pilot hole facing the wall you are going to drill. Thoroughly clean valve body after drilling.

Step 2 - Measure the pressure regulator spring from the O.E. valve train. If the spring measures between .540 to (.550 outer diameter install the blue spring supplied inside the O.E. spring then reinstall the valve train back into valve body. If the O.E. spring does not measure within .540 to .550, do not install blue spring. Reinstall the valve train as it was.

Step 3 — Remove the 4-2 relay valve train and the 4-2 sequence valve from the valve body. Replace both separator plugs and pins with the chamfer side going into the bore first for easier installation. Reinstall both valve trains back into valve body. Note: Insure pins are placed in center slot of plugs and secured with trans lube to keep pins from falling out when reassembling.

Step 4 — Remove and inspect the pressure modifier valve train to insure the end plug is snug and not cracked. If necessary use a tubing cutter and make a small knurl around the edge of the plug to snug it in the bore.

Step 5 — Remove and inspect the modifier accumulator valve train. Insure end plug is snug and not cracked. If necessary use a tubing cutter and make a small knurl around the edge of the plug to snug it in the bore. **Note:** This valve may use a clip retainer in place of a plug, in either case insure the valve is moving freely and reinstall.

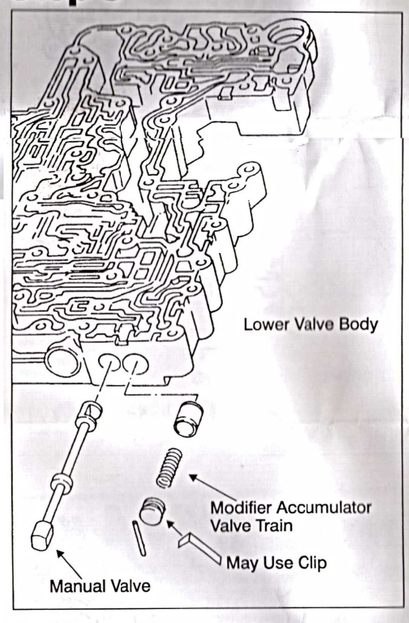
Step 6 — Drill separator plate as follows with drill bits supplied.

	(Regular Duty)	(Heavy Duty)
Hole A	.078	.093
Hole B	.093	.109
Hole C	.078	.078
Hole D	.109	.109
Hole E	.093	.109
Hole F	do not drill	.041
Hole G	.093	.093

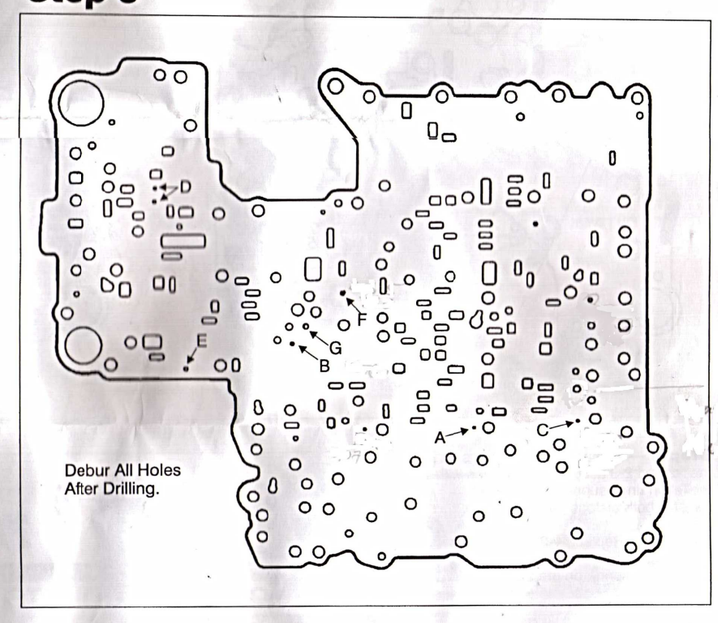
Debur all holes after drilling.

Step 7 — Reassemble valve body insuring all check balls and retaining pins are in place and secure with some trans lube in the upper valve body. Insure check valve and spring, pilot screen, retaining pins, and accumulator screen (if used) is in place in the lower valve body. Insure alignment bolts are in proper location with nut on lower valve body side.

Step 5



Step 6



Step 7

