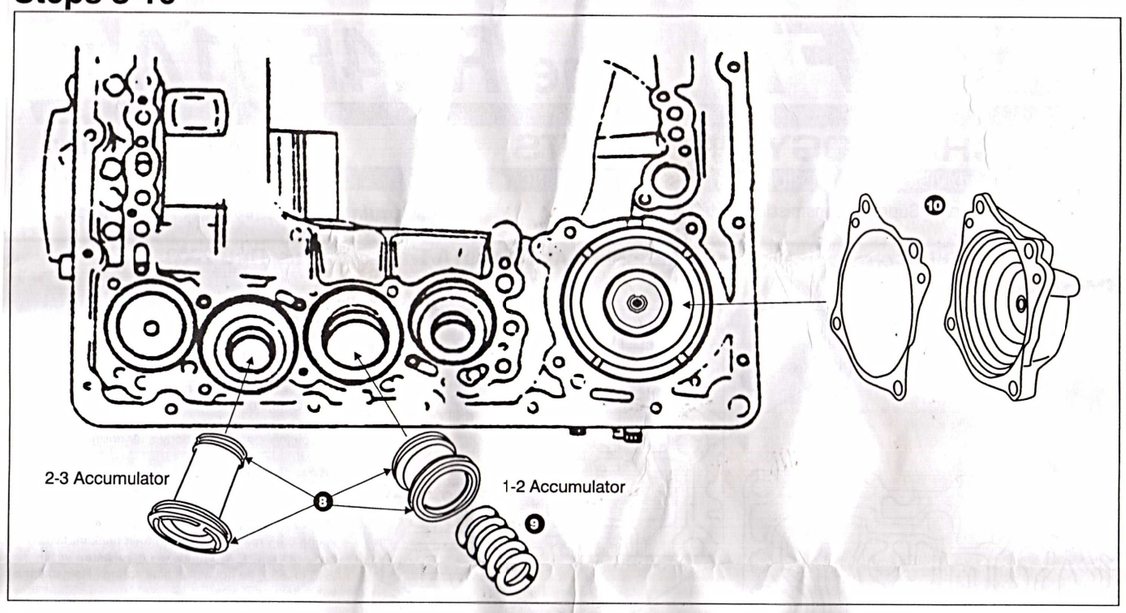
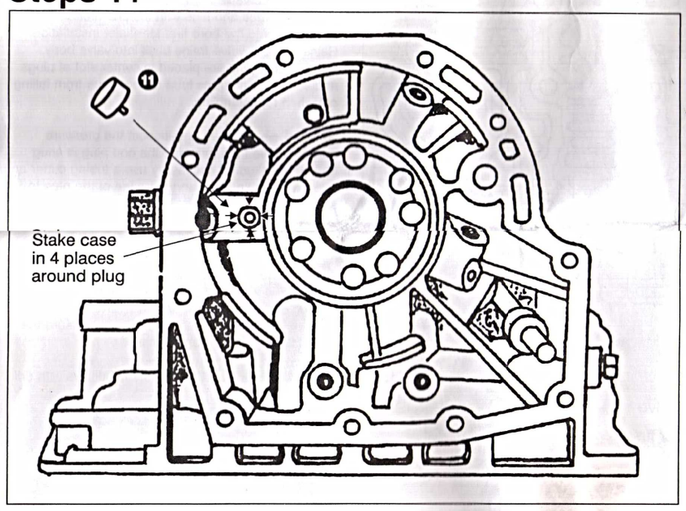
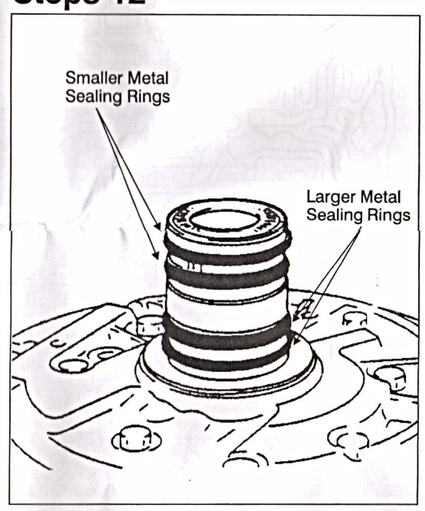
Steps 8-10



Steps 11

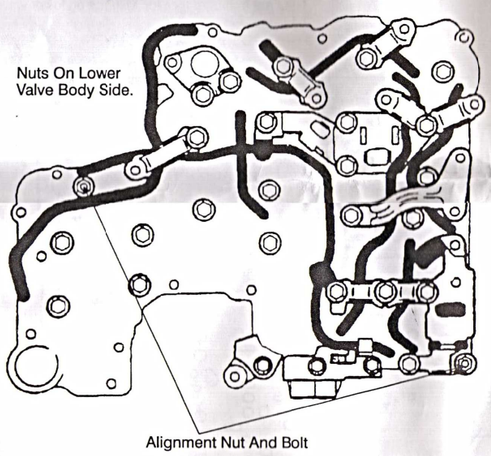


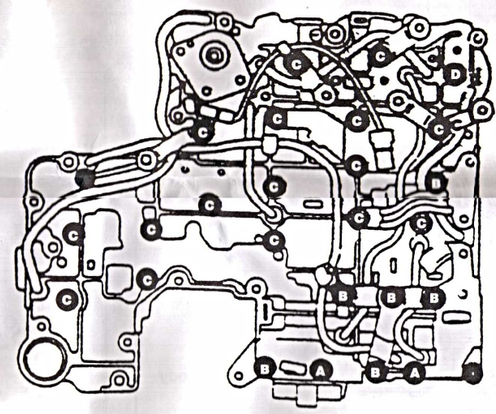
Steps 12



Reinstall valve body to case.
Torque all bolts to 85 (in) lbs. (10 n.m)

Bolt Length	mm(in)	A	B	C	D
		70 (2.76)	50 (1.97)	33 (1.30)	27 (1.06)





Step 8 — Replace rubber O-rings on the1-2 and 2-3 accumulator pistons with theTeflon rings supplied. Carefully reinstall both pistons back into case.

Step 9 — Replace 1-2 accumulator spring with the red spring supplied. Reuse O.E. spring on the 2-3 accumulator.

Step 10 — Replace the 2-4 servo cover gasket with the gasket supplied. Torque servo cover bolts to 100 (in) lbs. (11.5 n.m) Set band clearance to 1 3/4 turns out from 4 1/2 (ft) lbs.(6 n.m) tight. **Note:** Insure band strut is on servo pin side of the band.

These Steps can be skipped if transmission is not being rebuilt.

Step 11 — If your case has the orifice plug and ball in location shown, plug case using the step plug supplied. Drive plug into orifice plug and case as illustrated until plug is below flush to case. Stake case in 4 places around plug.

Step 12 — Install the 2 sets of metal rings supplied on the stator support shaft.

SHIFT The RE4R01A Kit

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