

## T-400 2-3 TRANSBRAKE

Part # 403084 - FORWARD PATTERN

### PACKING LIST

- |   |   |
|---|---|
| <input type="checkbox"/> (1) Valve Body Assembly            | <input type="checkbox"/> (1) Modulator Spring, heavy (optional)                         |
| <input type="checkbox"/> (1) Separator Plate                | <input type="checkbox"/> (1) ATI Solenoid Assembly with spacer<br>(sealed with red cap) |
| <input type="checkbox"/> (1) Big spring, rear servo         | <input type="checkbox"/> (1) Instructions   |
| <input type="checkbox"/> (32) Drum Springs (rear & forward) |   |

Packed by: \_\_\_\_\_

**⚠ Professional Installation Is Recommended! ⚠**

**FORWARD PATTERN - P R N 3 2 (OEM 1ST IS LOCKED OUT)**

**Note! This Transbrake will work in any gear.**

**For Reverse gear, select R or N, then press transbrake button.**

**For best results, set line pressure to 200 - 225 PSI.**

#### STEP 1 - Preparing the case

- Flat file the case.
- Remove the casting wall in case as shown in figure.

#### STEP 2 - Rear Servo

- Remove accumulator rings.
- Install heavy spring (provided).

#### Step 3 - Center Support

- Remove 2nd ring from top.

#### Step 4 - Intermediate Clutch

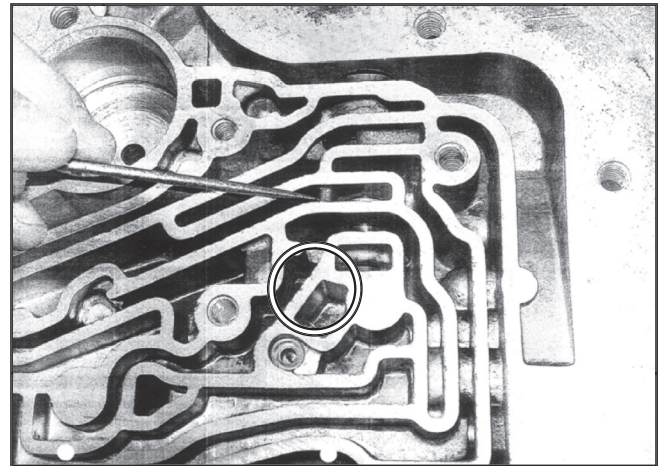
- Set clutch as tight as possible (.030" is good).

#### Step 5 - Direct Drum

- Discard the center seal.
- Drill .062" bleed hole in the outer diameter of the drum.
- Install piston with heavy springs (provided).
- Set clutch clearance to .070"

#### Step 6 - Forward Drum

- Install piston with heavy springs (provided).
- Set clutch clearance to .070"



#### Step 7 - Modulator Valve

- The OEM modulator valve now functions as the brake valve.
- Install valve, spring (provided) and solenoid.
- Make sure valve strokes free.
- OEM modulator spring may be used to soften hit.

#### Step 8 - Install the valve body

- Uses the OEM stock manual valve.



**Accidental transbrake engagement poses a serious safety risk! You must have safety electronics in place to safeguard against accidental engagement of the transbrake solenoid when not intended.**