





4th Accumulator

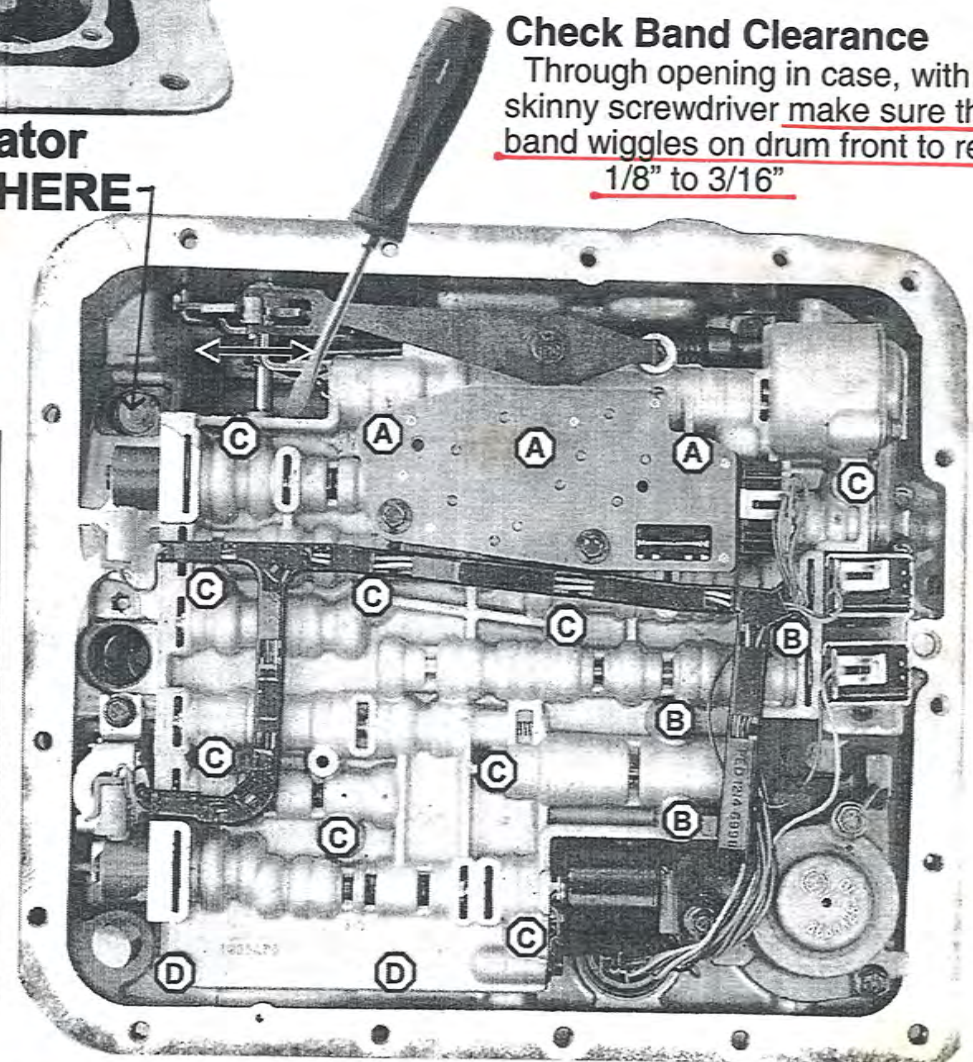
1. Remove and discard original spring.
2. Install **YELLOW** spring into case
3. INSTALL NEW PIN , PISTON AND SEAL.

Case **C** TORLON Checkball goes in the case here. **Regulator Valve HERE**

Check Band Clearance
Through opening in case, with a skinny screwdriver make sure the band wiggles on drum front to rear
1/8" to 3/16"

WARNING: Wrong bolt locks gear train.
Install bolts like this:

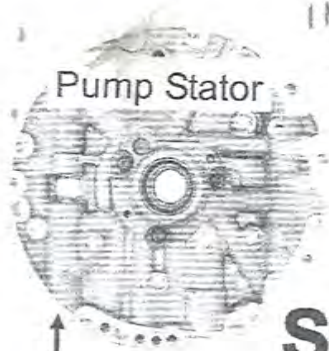
A 10 MM		3 A bolts
B 8MM		3 B bolts
C 10MM		9 C bolts
D 10MM		2 D bolts



INSTALL TORLON CHECKBALLS AT GREEN DOTS.

Separator Plate

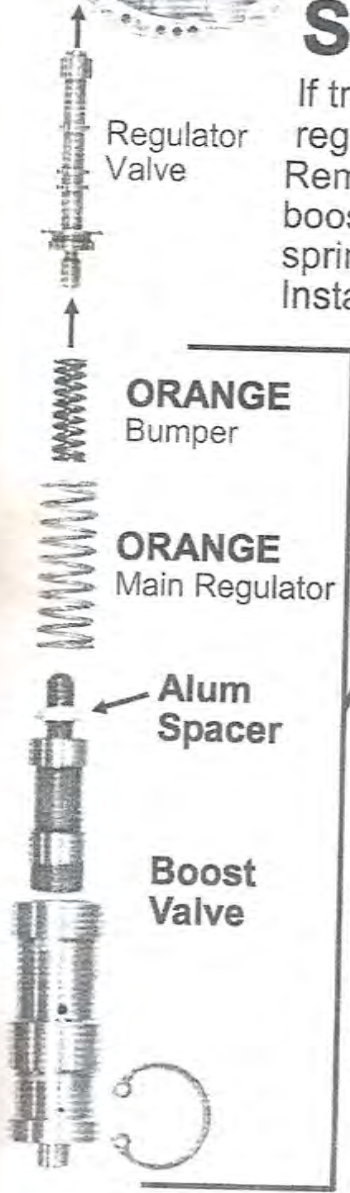
INSTALL PRE-DRILLED SEPARATOR PLATE "AS IS."



Pump Stator

Step 1

If trans is in vehicle, find regulator valve, **Page 5**. Remove & discard original boost valve, main regulator spring and bumper spring. Install **NEW** parts furnished.



Regulator Valve

ORANGE Bumper

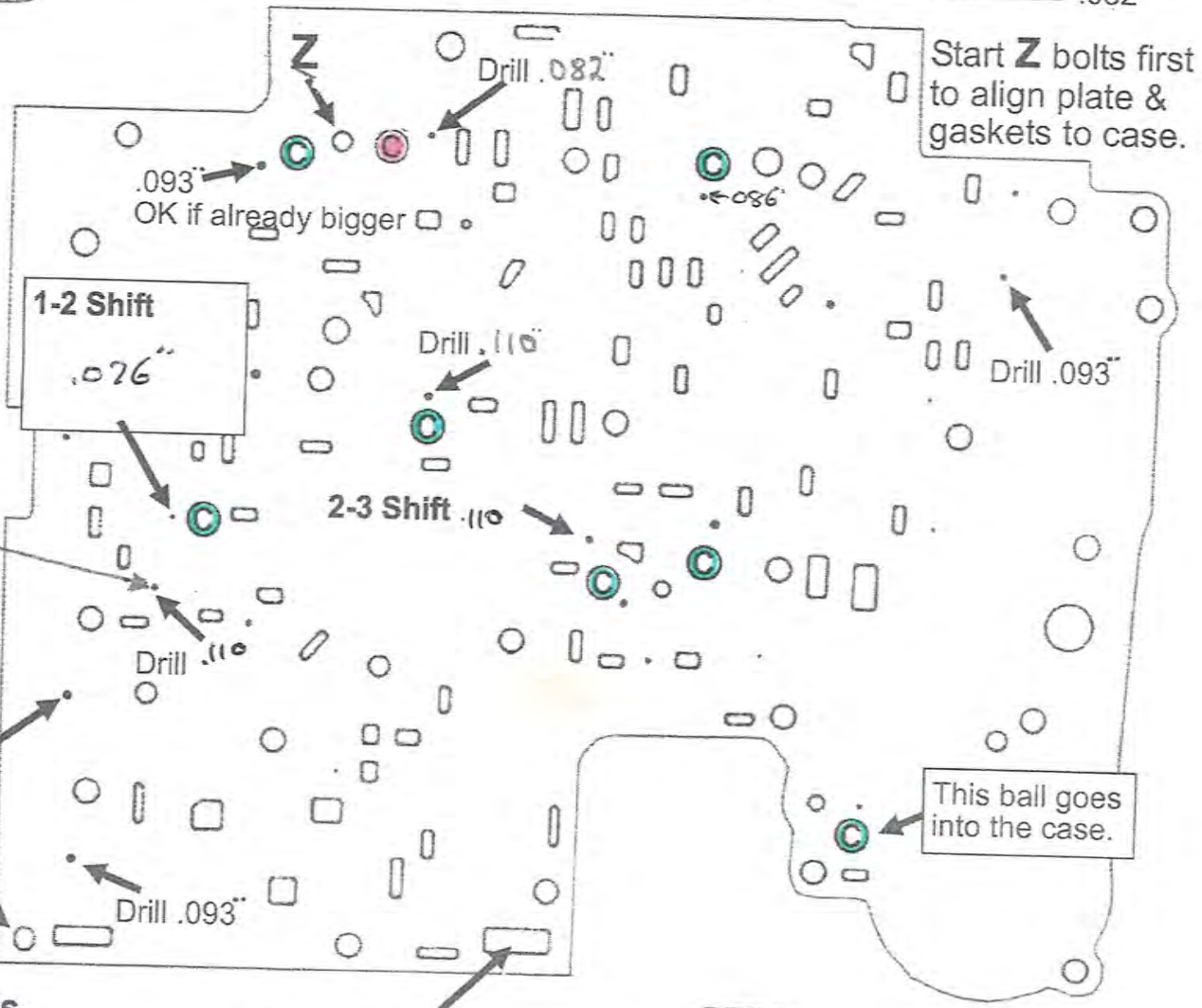
ORANGE Main Regulator

Alum Spacer

Boost Valve

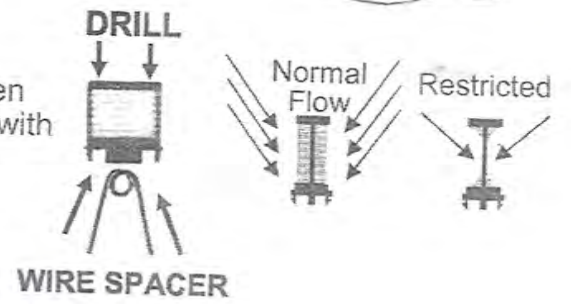
GASKETS MUST NOT COVER ANY HOLES ON THE SEPARATOR PLATE.

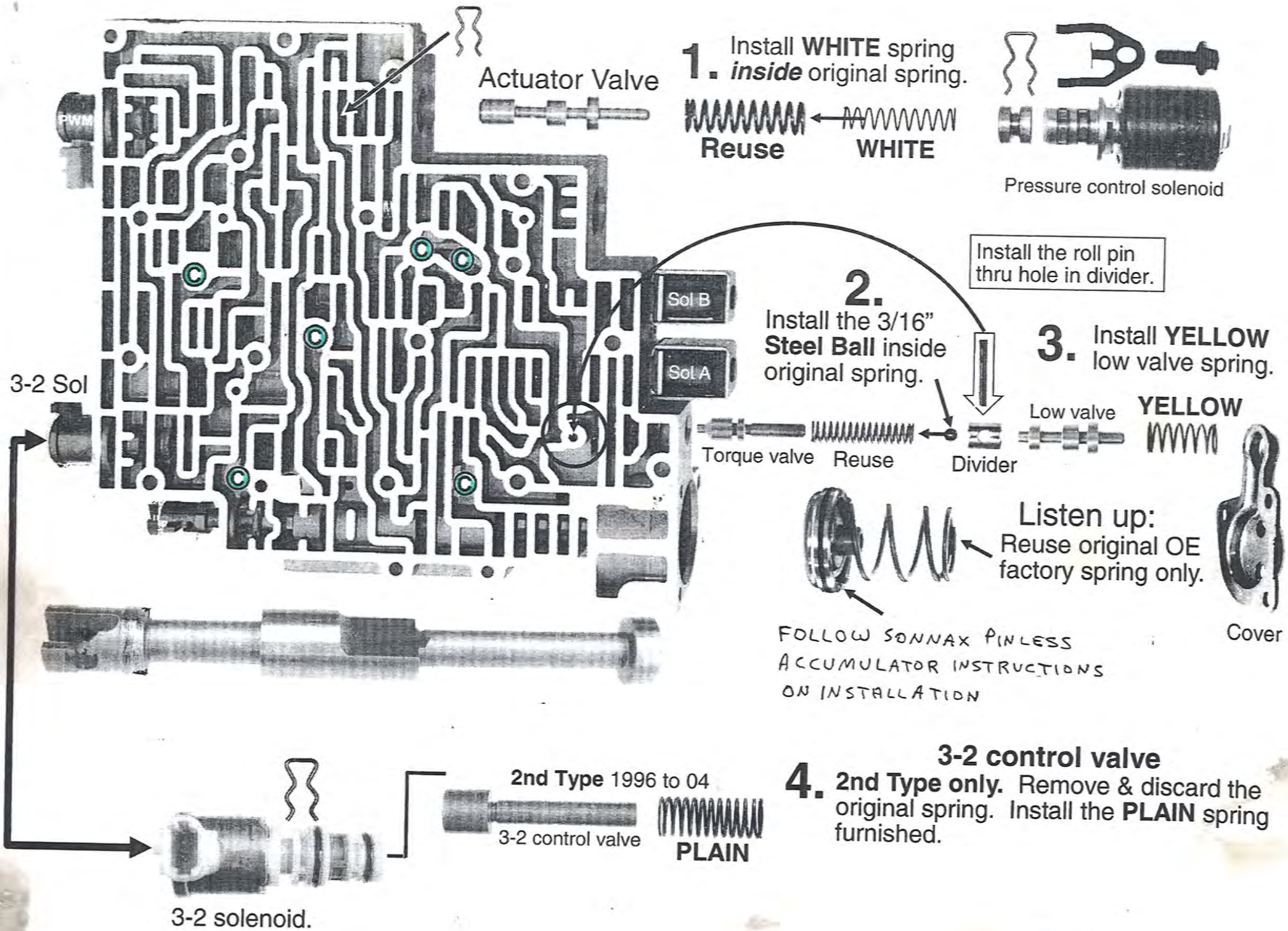
TORLON Checkballs
Six on plate, 1 in case.



.093
.082

EPC Screen Fix
Large screen in VB plate. Sides of screen suck together causing low line pressure with high throttle. Burns clutches and band. **Wire Spacer** will keep screens apart.
Additional safety: Drill four .040 to .047 or two 1/16" holes thru top of screen.



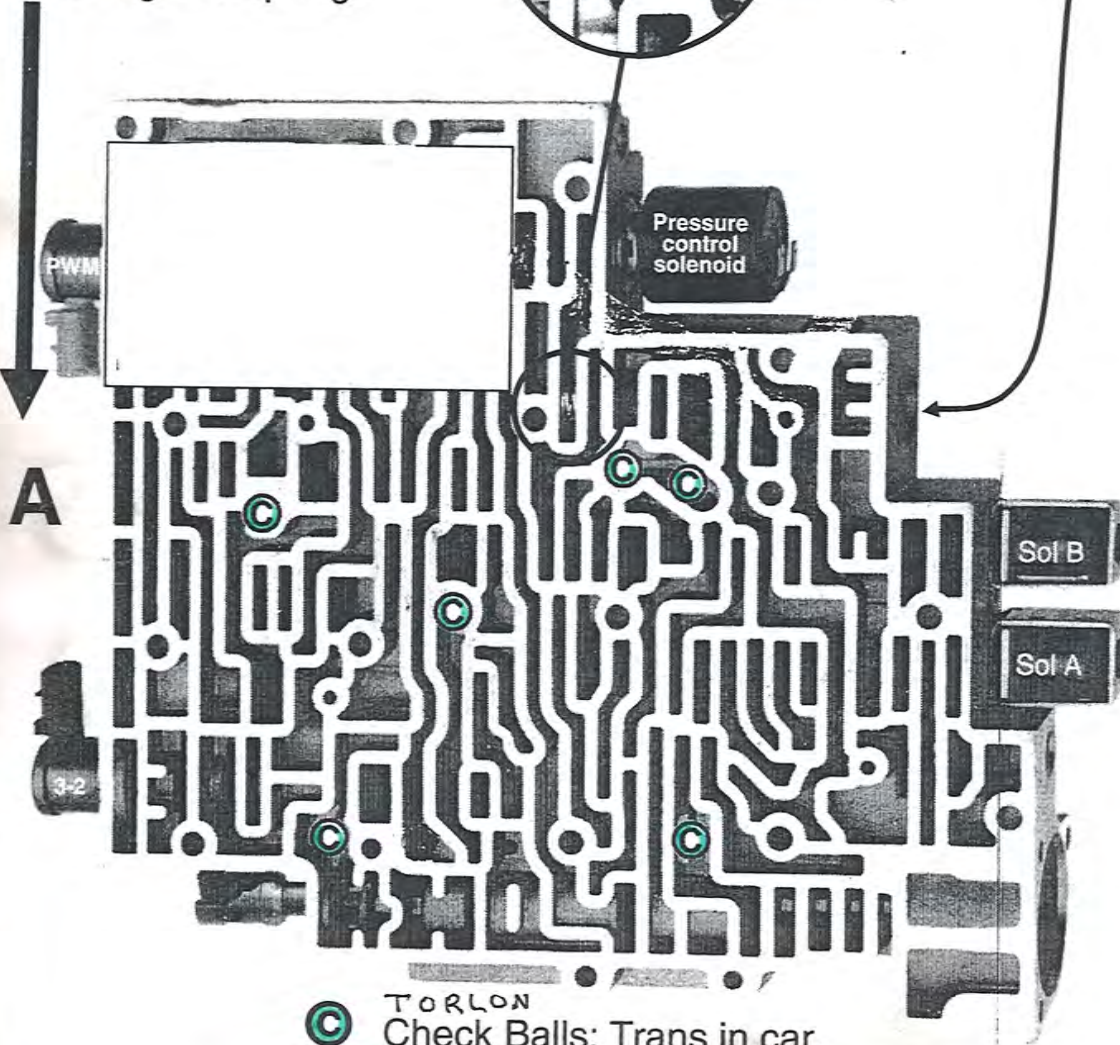


Matching accumulator to ECM, accum code.

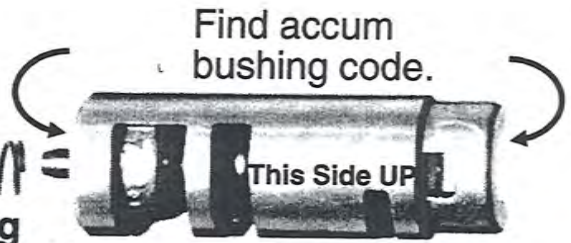
LISTEN: Hold side A towards ceiling when installing accumulator bushing and spring.



Make sure that accum spring is not **crooked**.



© TORLON
 Check Balls: Trans in car.
 6 In Valve Body. 1 in the Case



Find accum bushing code.

Install **Spring** selected from 1-2 accum bushing & valve chart below.

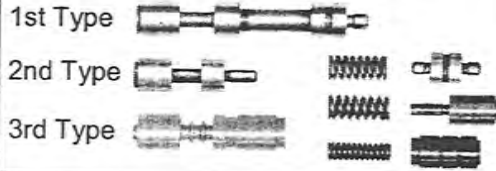
Match 2nd piston & 1-2 accum bushing code to **Spring** color.

Piston #	Bushing Code	Spring	OZ
CORVETTE SERVO	D,DX,R	WHITE	24
	C,CX	BLUE	56
	A,AX,B,BX	YELLOW	72

- 1. Remove and discard** the converter reg valve, spring and isolator valve. Save the end plug and clip.



Remove and discard.



Hello Mechanic: Upgraded **Isolator & Converter Regulator Valve** works great even in a very worn valve body.

This upgrade will let you use a torque converter with any style lockup plate.



Having fun fixing trans since 1959.

New ISO-CONV valve replaces all of the earlier type Isolator and Converter valves.



- 2.** Insert **ISO-CONV Valve** into bore. Using hex bolt as a handle, push valve in and out at least 20 times with slight side pressure. The valve must fall in and out of bore. Clean the bore. Remove the bolt. Install **BLUE** spring & **ISO-CONV Valve**.

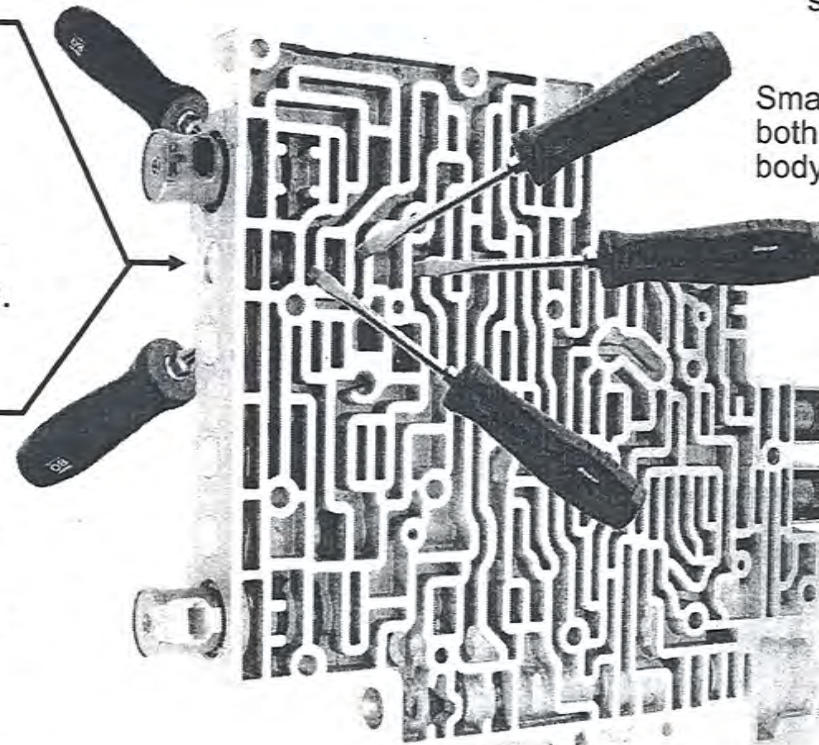
Valve feels **sticky?** Do step 3.

ONLY DO STEP 3 IF VALVE FEELS STICKY.

GM & SRTA: OVERSIZE valves.



SRTA & GM rebuilds have **OVERSIZE** valves, but still wears VB. For upgraded valve order **TransGo 4L6-ISO-3**.



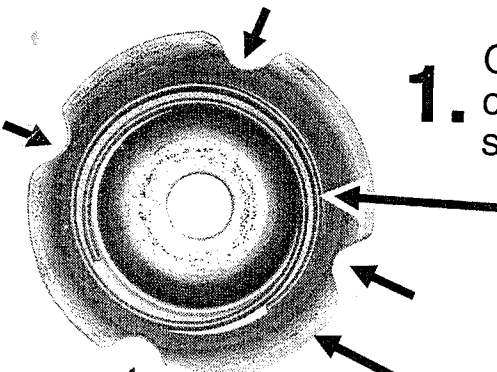
Smack valve from both sides of valve body at all angles.

3/4" end wrench

- 3.** Insert new valve into bore. Place screw driver with tip against valve between the lands. Whack screw driver **smartly** with 3/4" end wrench from all angles and from back side. Then repeat step 2.

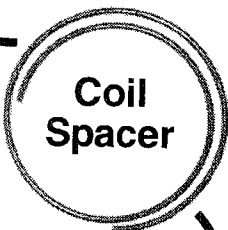
"You just **FIXED** this valve body." Gil

2nd Piston Upgrades



1. Grind 4 oil exit notches on the steel cover about like this. It gets real hot so have a dish of water handy.

Grind 4 notches

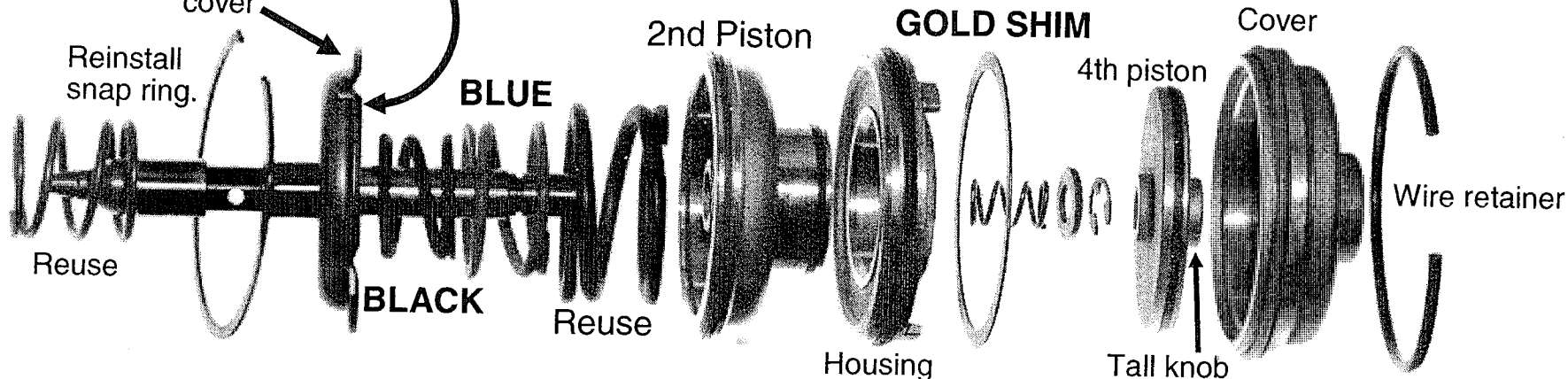


Steel cover

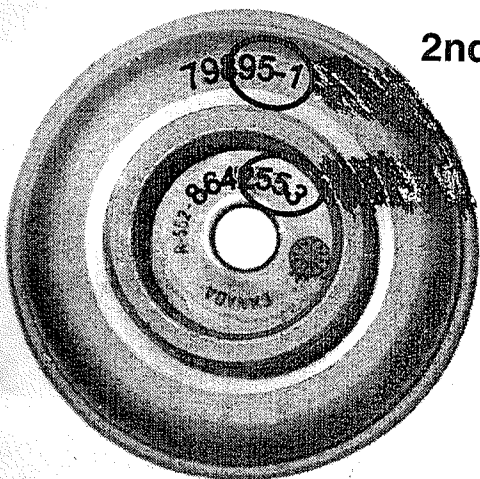
Reinstall snap ring.

2.

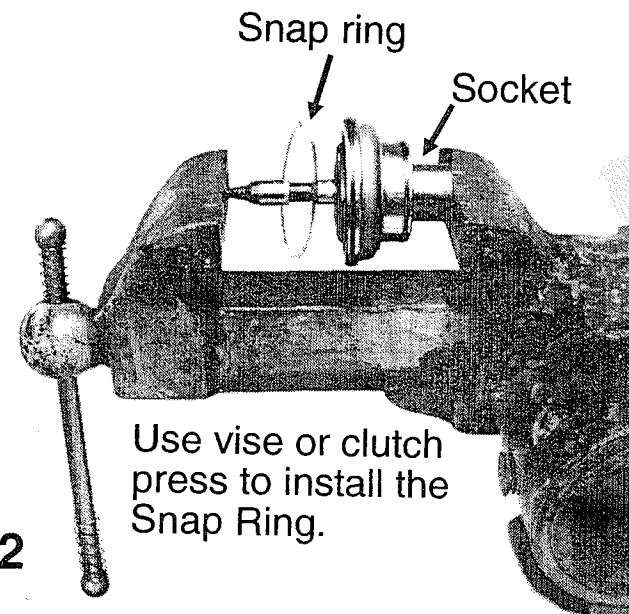
Stick **Coil Spacer** into the recess of steel cover with some assembly Jel.



3. Install **BLUE** and **BLACK** cushion springs inside the original cushion spring and reassemble. Install the **GOLD SHIM** between housing and cover. Make sure the band moves freely on drum from front to rear. (see **Page 5.**) If band is too tight remove shim, don't shorten pin.



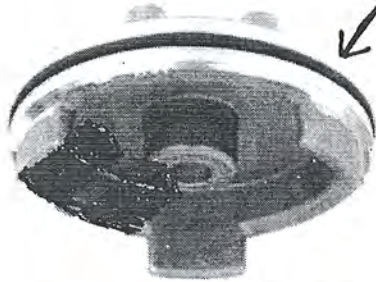
2nd Piston



DETERMINE WHICH ACCUMULATOR HOUSING YOU HAVE.

1-2 Accumulators

INSTALL NEW
PISTON AND SERL.



ORANGE

Reuse original
outer spring

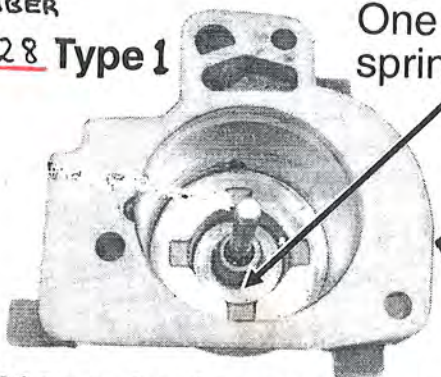
WHITE

RED

ORANGE

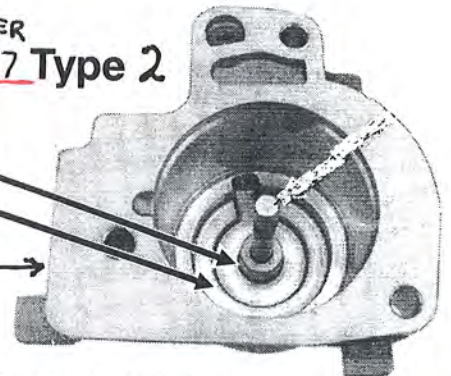
PART NUMBER
8684428 Type 1

One .485 deep
spring pocket. PART NUMBER
24219937 Type 2



Inner and outer
spring pockets.

PART NUMBER ON
TOP OF HOUSING



Page 1

INSTALL HARDENED PIN BEVELED END IN FIRST, THEN INSTALL FLUSH WITH BOTTOM OF HOUSING.