

TFOD-HD2 Reprogramming Kit™



**Fits: 1988-2007 Chrysler Torqueflite and Loadlite rear wheel drive four speed.
Diesel or gas V6, V8 and V10; A500-518-618 42-44-46-47RH and RE.
Does not fit 2003 and later 48RE (see below)**

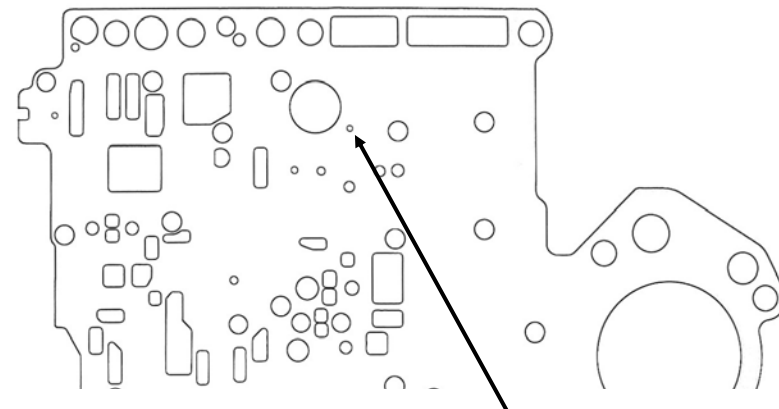
**This is not a “do it yourself” kit.
It is for the experienced, professional transmission technician only.**

**Short, firm shifts with performance, durability and “class”.
Holds 1st, 2nd and 3rd to any engine speed.**

Gear Command™ option: back shift to any gear you want at any speed.

Assures lube flow even with heavy loads on long hills.
Reduces converter drainback and leak out the vent and side seal.
Reduces killing engine in reverse.

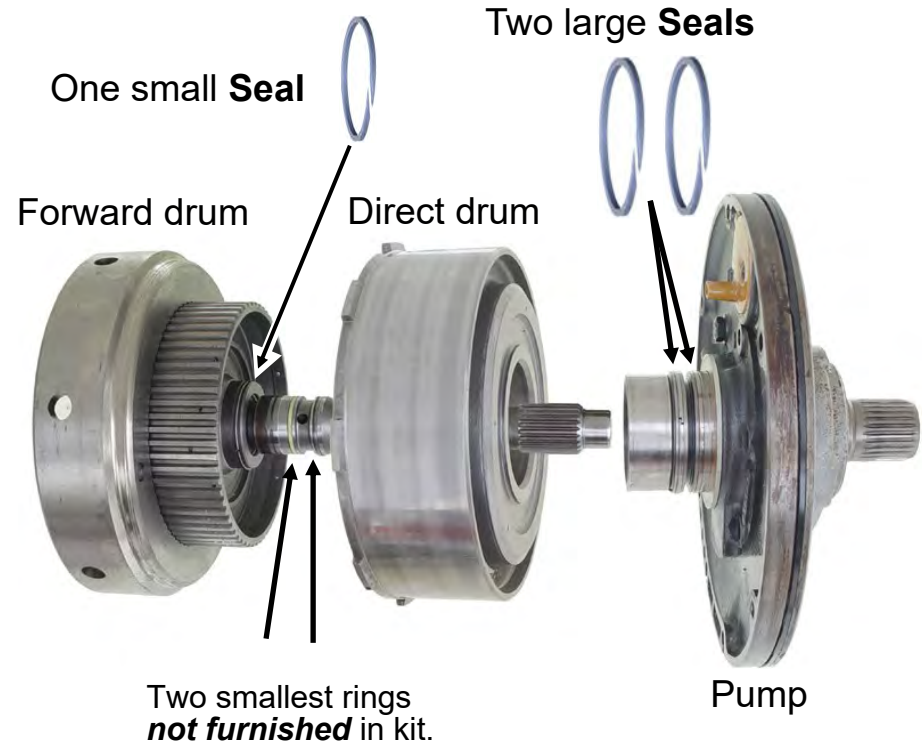
**Listen up!
Check your valve body type
before proceeding.**



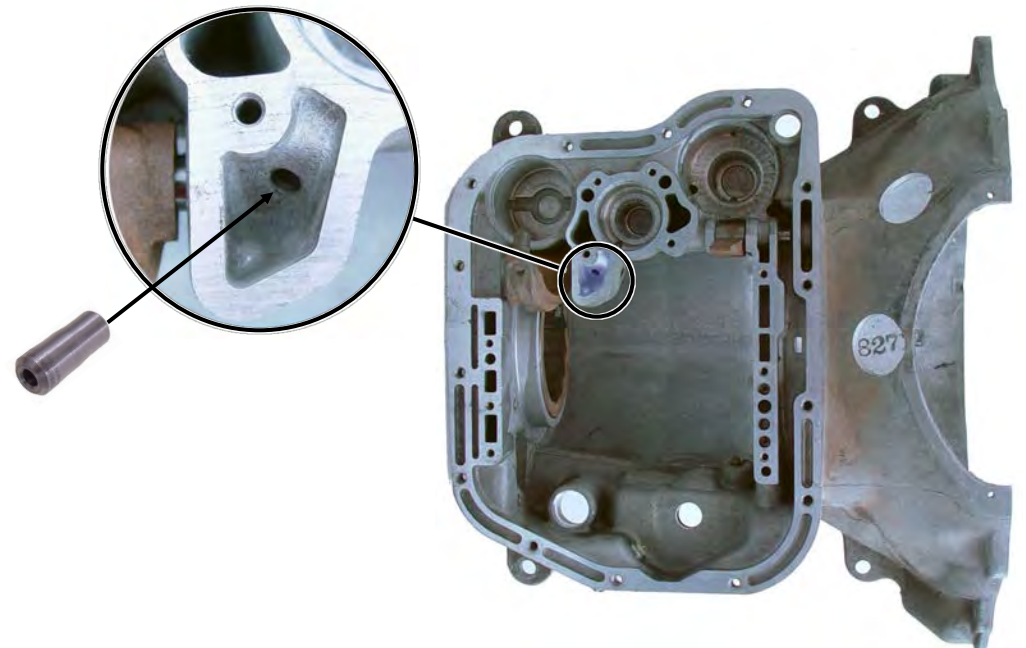
This kit **only fits** valve bodies **without this balance hole** in the separator plate.
If your original plate **has this balance hole**, use part # **SK 48RE** instead

1. If trans is apart, install Seal Rings.

Note: Replacement rings not used on 42-44RE



2. Skip this step IF your using the **NEW** separator plate provided. (Orifice is in the new plate)
With a VB bolt and small hammer **GENTLY** tap the **Tapered Orifice** into this hole.



Listen up: Diesels and HD Work Trucks Skip Step 1

Rear Servo parts **MUST** be installed **IF** 1-2 plate hole (pg 7) is greater than .093 **AND** trans will be manually up-shifted from M1 to M2. **If** 1-2 plate hole is .093 or smaller **OR** trans is never manually up-shifted from M1 to M2 then skip Rear Servo parts and leave band adjustment as is. Manual down-shifting ok with either setup.

2. 2nd Servo

Install **New White Spring** into 2nd Servo as shown.



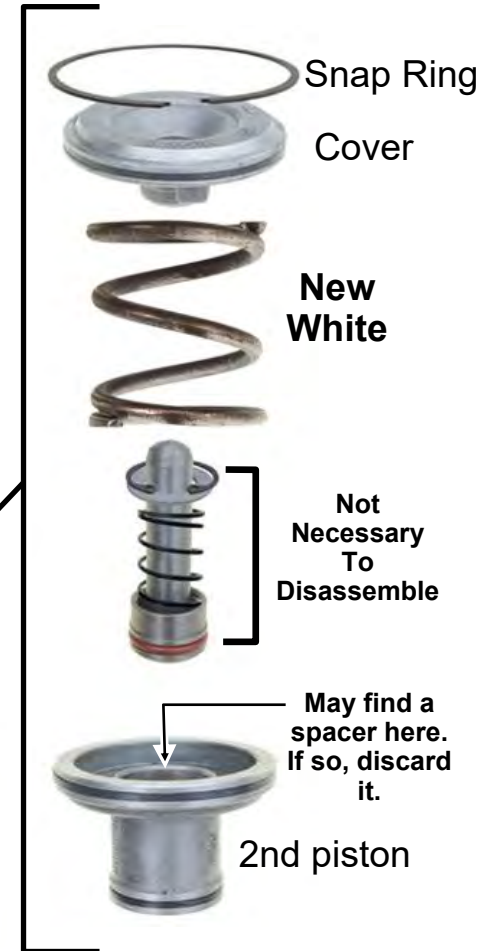
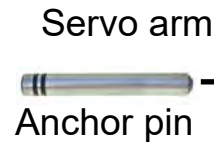
1. Rear Servo Parts

Install **Spacer** and reassemble piston. Two **PLAIN** Springs are furnished. Install **ONE** that fits piston & retainer. If neither spring fits, reuse original.

3. Install New 1-2 Accum spring.

To install the rear servo parts on some models without removal of the trans, unbolt the overdrive housing and slide it back far enough to remove the anchor pin and rear servo arm.

Some models also have a spring here reuse it.



Replace piston if cracked here.

Adjust rear band
Tighten snug with short wrench.
Single wrap band: Back off 2 1/2 turns.
Double wrap band: Back off 3 1/2 turns
[Double wrap band has three sections across]
Tighten the locknut.

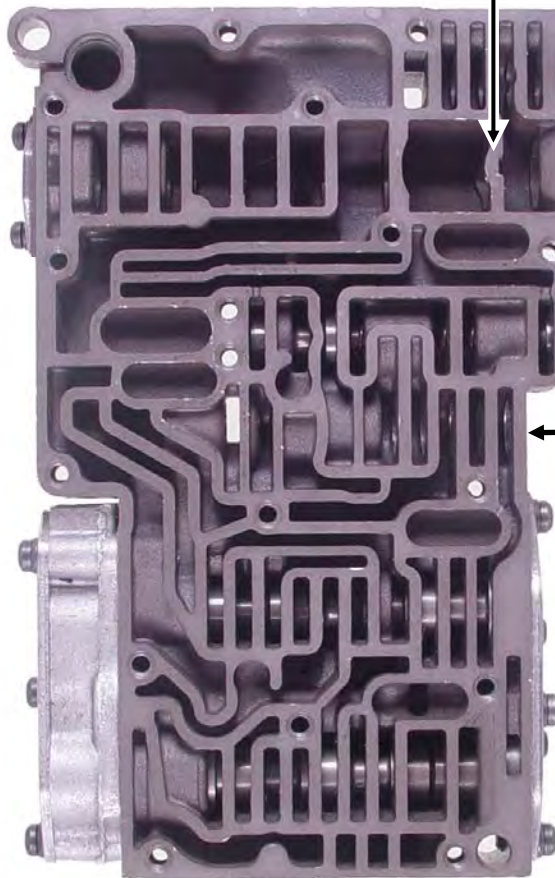
Front band adjustment:
Tighten snug with short wrench. Back off 1-3/4 to 2 turns and tighten nut.

Installing converter with multiple clutches or working on non lockup transmission SKIP step one.

1. Drill one or two .076 to .096 holes down through the bottom of the most outboard passage.
One Hole = Slightly firmer lockup
Two Holes = Much firmer Lockup



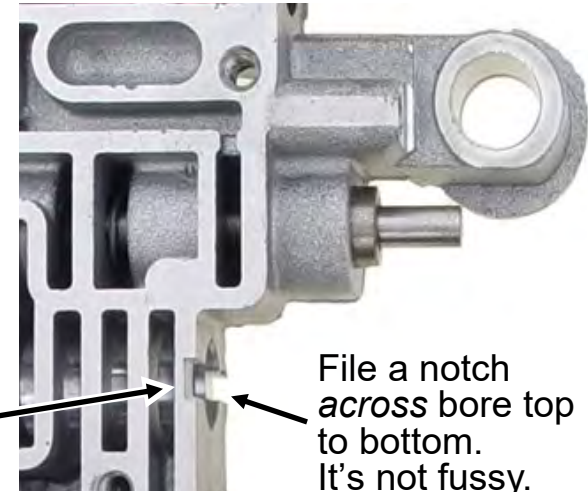
No cross drilling required. If VB has cross drilled hole through this partition from previous repair plug it.



1-2 Gov Valve
For Gas Hot Rods **ONLY!**
NOT FOR DIESEL
OR
HD Work Trucks!



2. Turn the valve body over. Using the edge of a large file, file a notch about *halfway* thru the thickness of this partition.



File a notch *across* bore top to bottom. It's not fussy.

3. For later throttle on up-shifts install new GREEN TV spring, otherwise **skip** this step for **normal** use. No need to grind TV valve.



4. Optional--COMMAND CONTROL: Allows *backshifting* to Manual Low at any speed. Install new 1-2 Gov Valve.

Skip this step for HD work trucks, Diesels & Motor Homes.

2. Install new transfer plate between Cover and part throttle body.



Cover

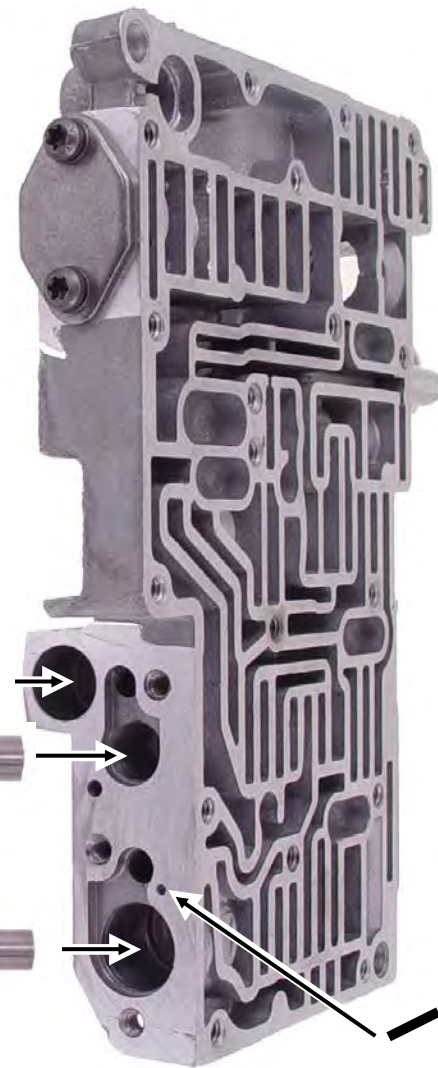


Transfer plate



PT Body

1. Install New Spring
Yellow 12 Valve Engine
White 24 valve Engine
White Gas Engine

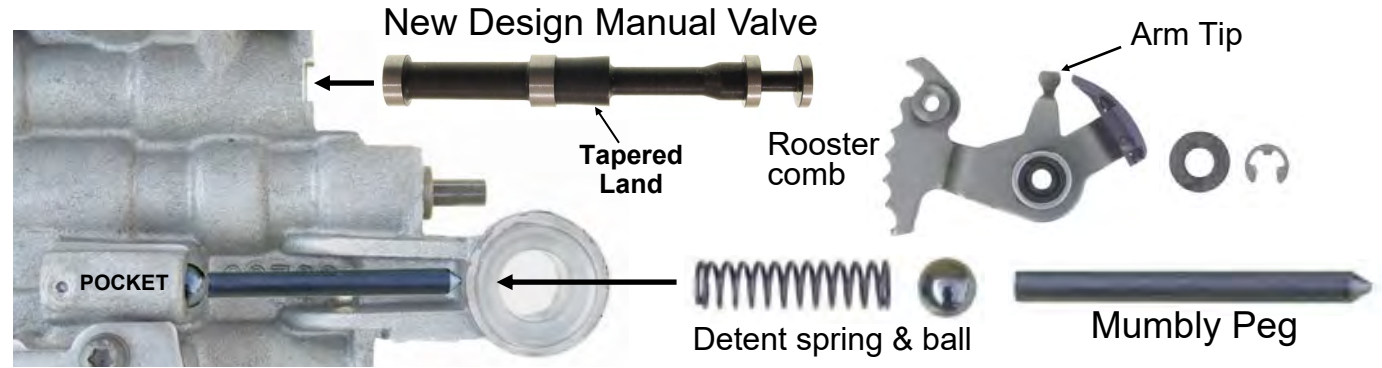


Pin

Listen up!
New Transfer Plate DOES NOT install on this side of PT body!

3. Using a pick and small hammer taper top of this hole to help start the pin.
Install tapered end of pin (furnished) into this hole using needle-nose pliers and small hammer. File flush if needed. PT body must sit flush against VB.

1. Insert spring and ball into VB pocket using the Mumbly Peg to hold the ball in place. Insert new Manual Valve and reassemble the rooster comb. Remove peg.

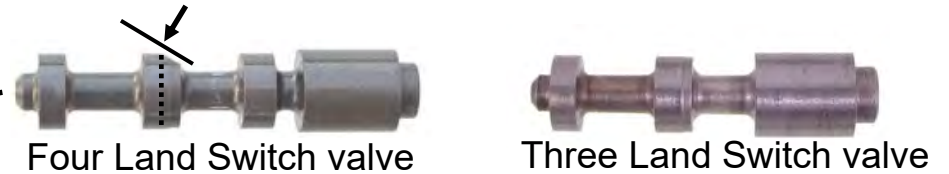
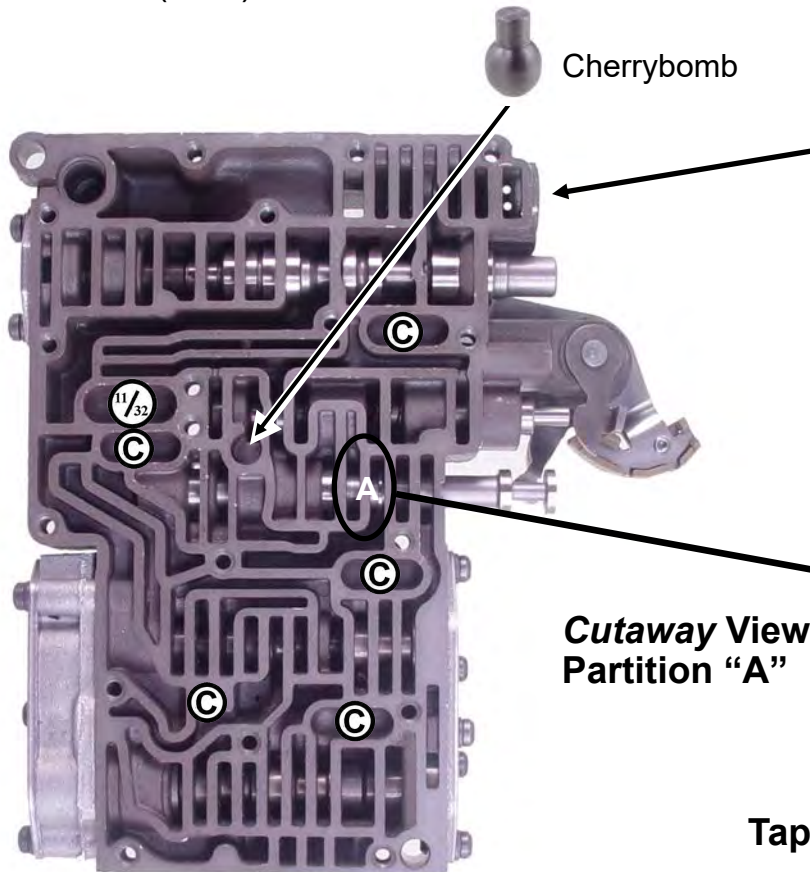


**Six Check-balls
One Cherrybomb**

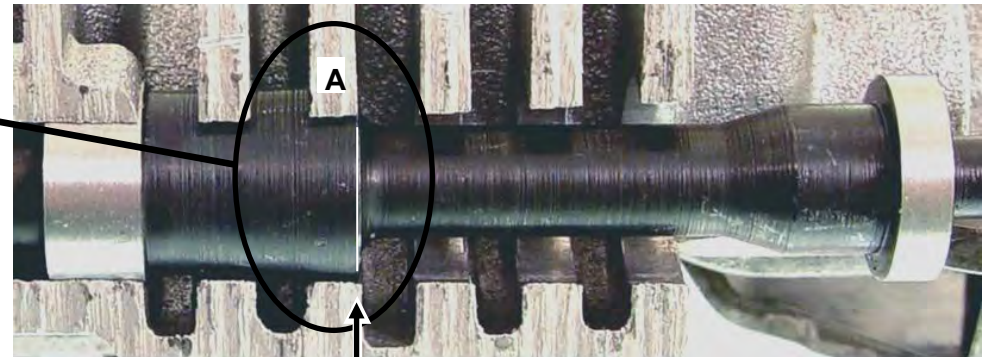
2. Discard this check-ball install Cherrybomb here: Careful to align stem of Cherrybomb through hole in plate when putting VB half's together.

- © Five 1/4" (.250)
- © One 11/32" (.343)

3. Four Land switch valve ONLY Grind one notch on slight *angle* to about the middle of this the land. Don't Grind three land switch valve. VB with three land switch valve reuse original separator plate.



4. Manual Valve position. With valve all the way inboard (Park position) the *right edge* of the Tapered land must be flush with *right edge* of partition "A". (.030" from flush either way is ok.)
To Adjust: Bend **Arm tip** with pliers.



Tapered Land flush with right edge of Partition "A"

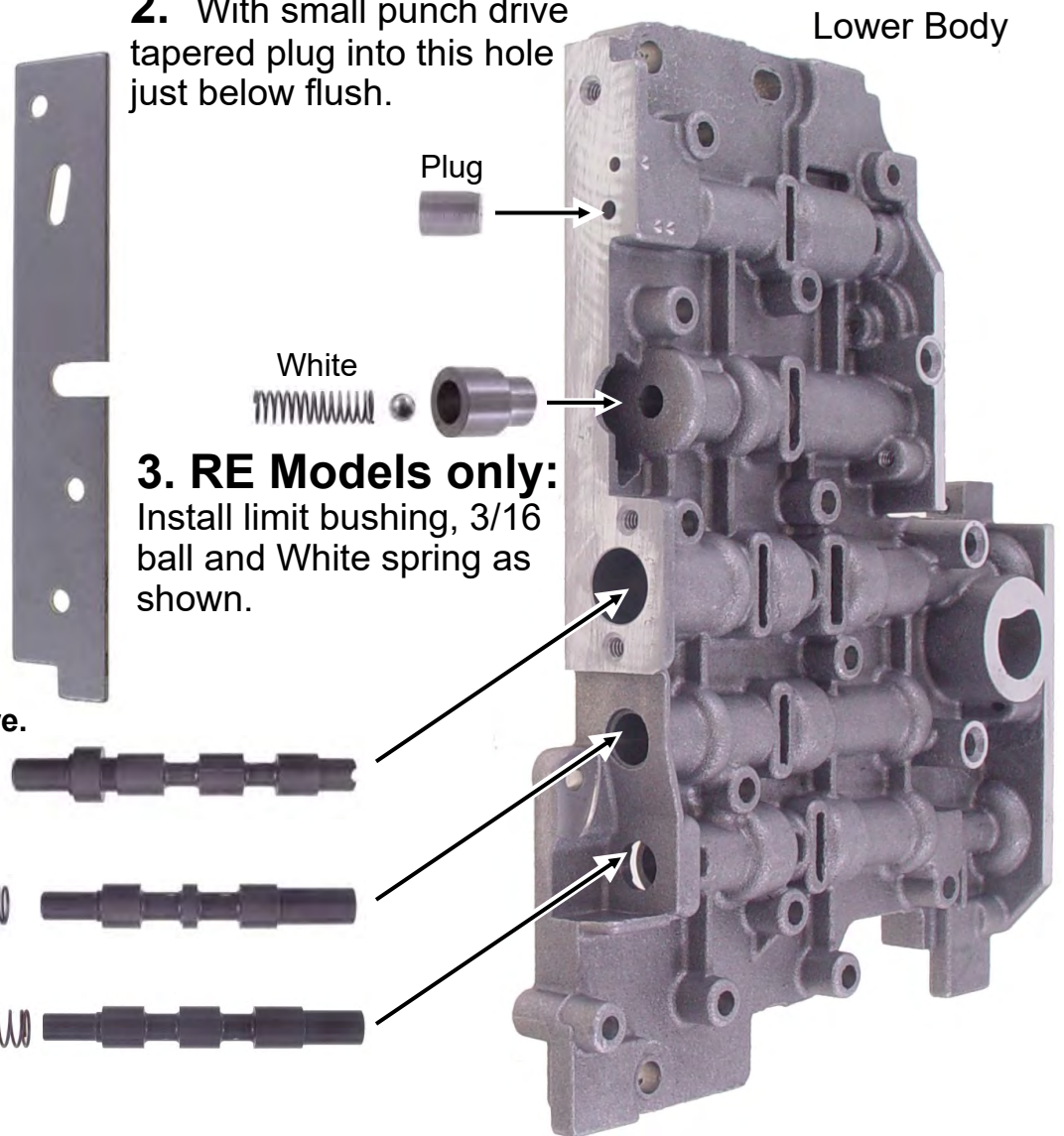
1. Place .156 drill into hole shown and drill all the way through the accumulator housing and out the other side. With small punch drive plug into hole just below flush.

If working on RH model with Governor on output-shaft Skip Step 3



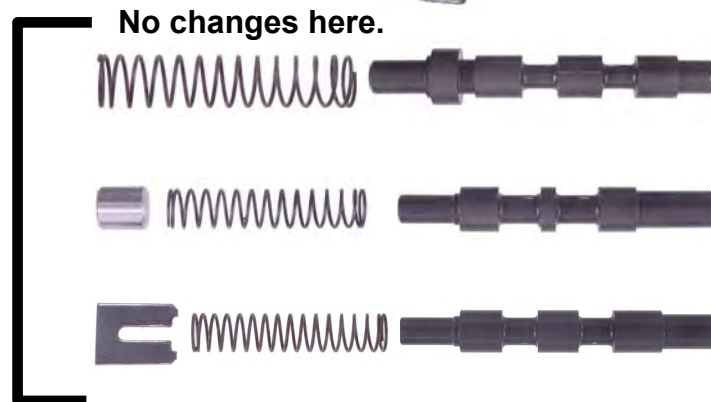
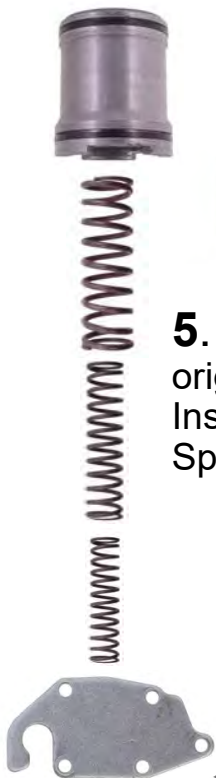
4. Install new transfer plate as shown between VB & Accumulator housing

2. With small punch drive tapered plug into this hole just below flush.



3. RE Models only: Install limit bushing, 3/16 ball and White spring as shown.

5. Discard original spring Install new **Red** Springs.

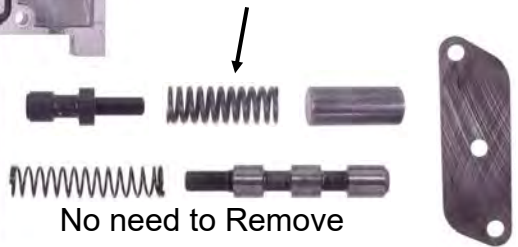


If working on RH model with Governor on output-shaft Skip Steps 1, 2 & 3.

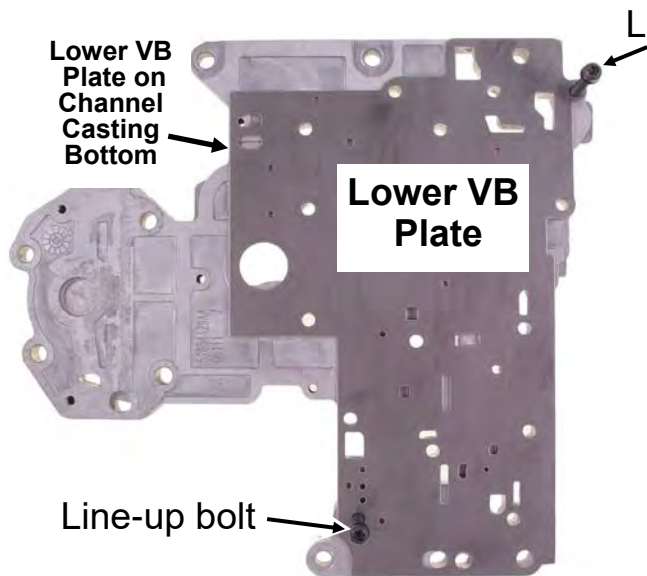


1. RE Models only:

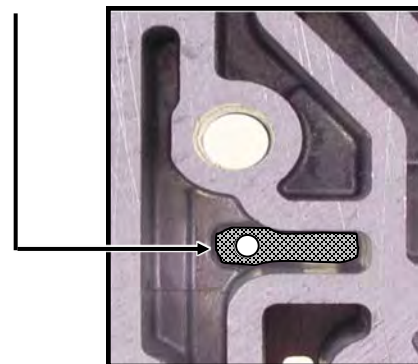
Install new spring here.
White 12 Valve Engine
Orange 24 Valve Engine
Orange Gas Engine



2. RE Models only: We need to add a hole to the **Lower VB Plate**. Use channel casting as drill guide. Place plate on channel using two VB bolts to line it up as shown below, then flip it over.



3. RE Models only: Use this rectangle passage as guide to drill a 0.106" hole through **lower** plate as shown with the drill bit furnished.



USE New Plate on 4 land switch valve

(Switch valve ID see page 5.)

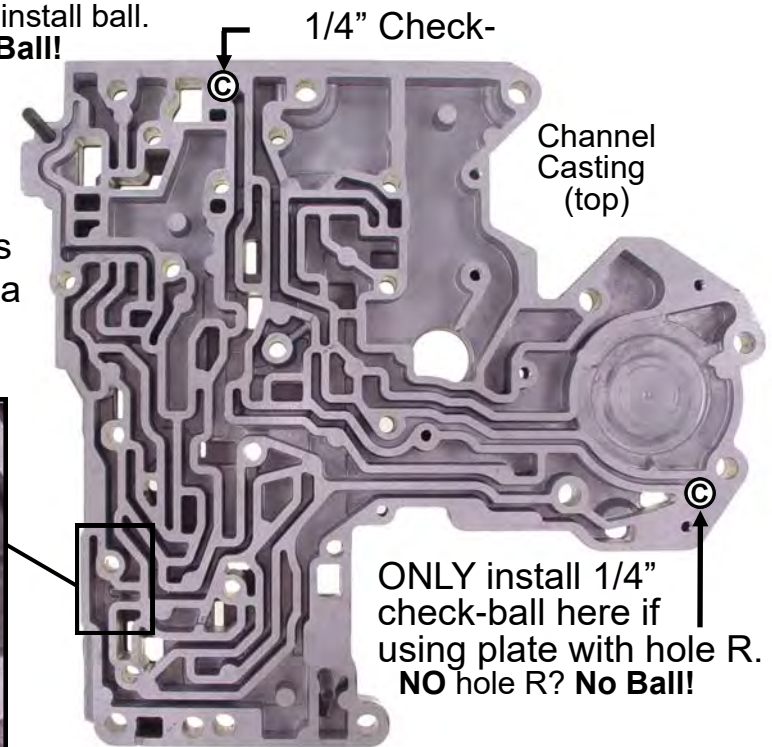
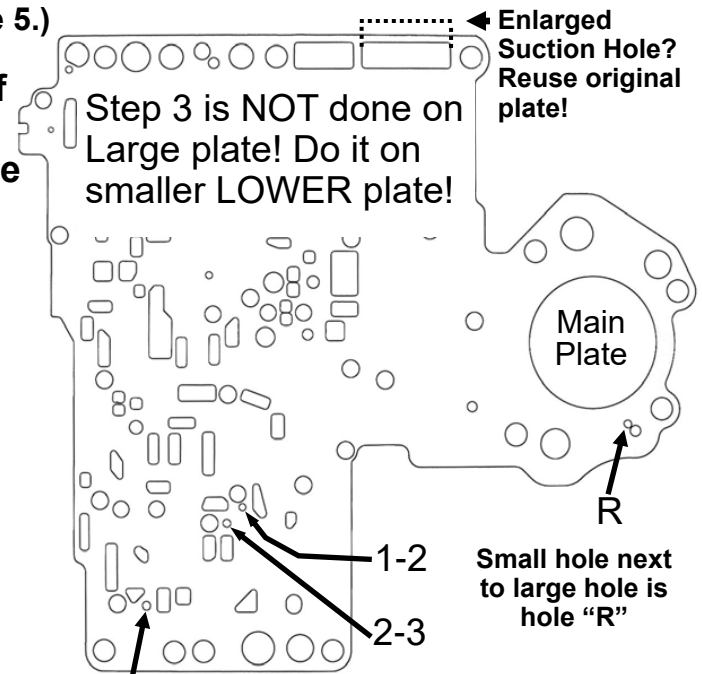
Reuse original plate if VB has 3 land switch valve or has larger hole for pump suction!

4. Plate Holes

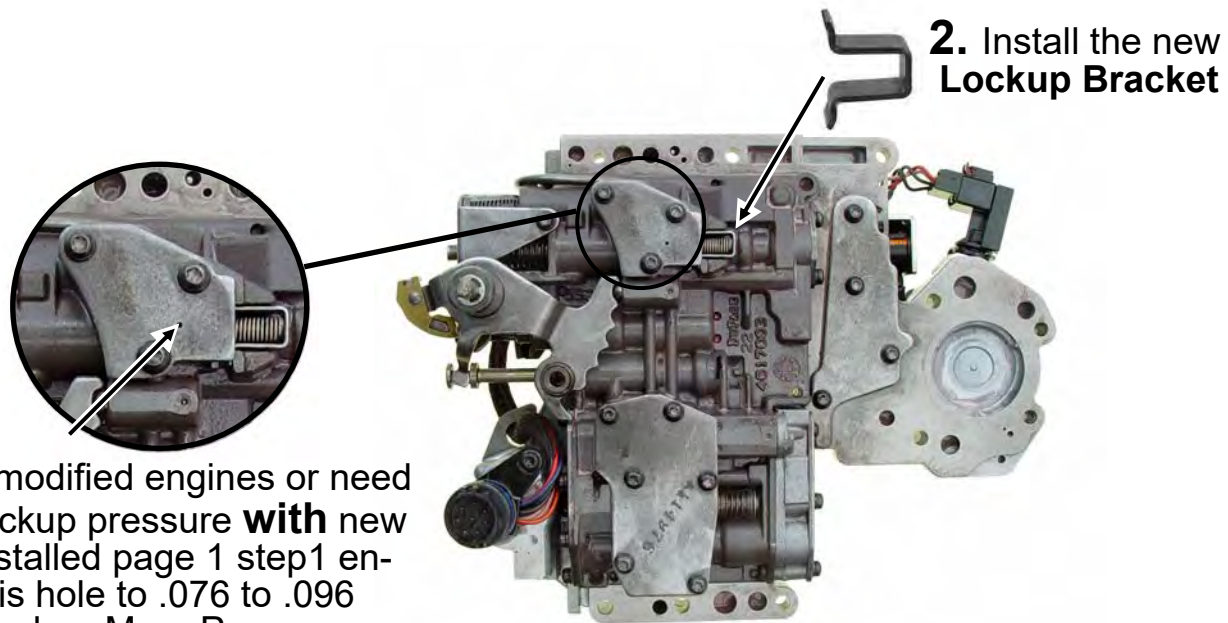
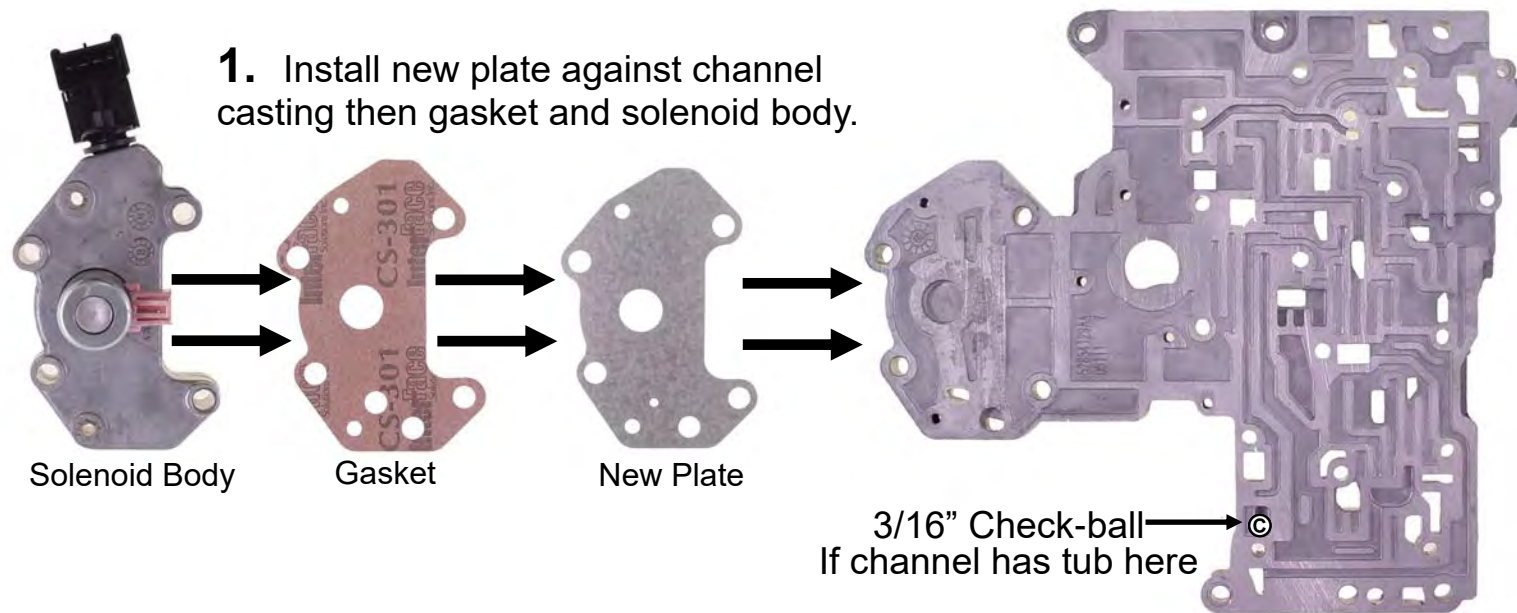
Towing and HD Use

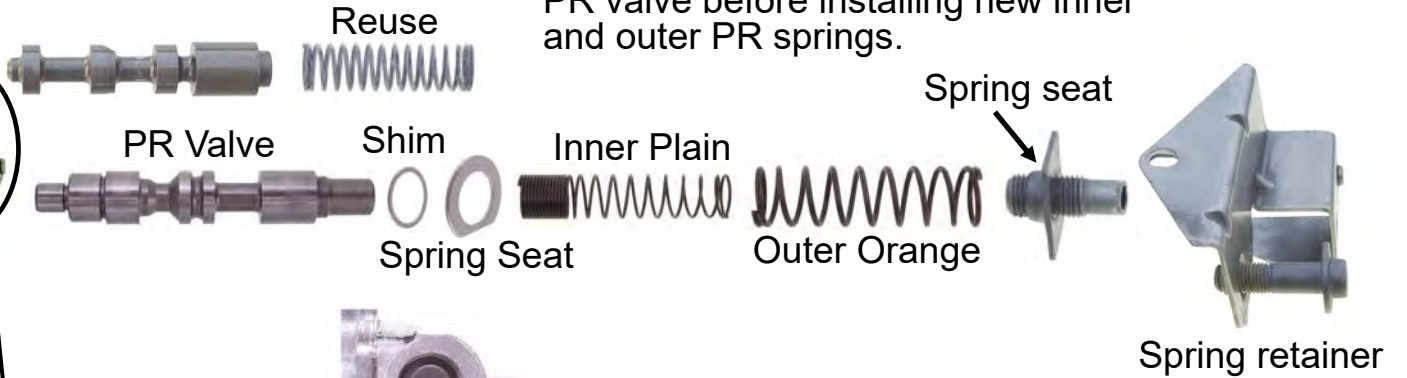
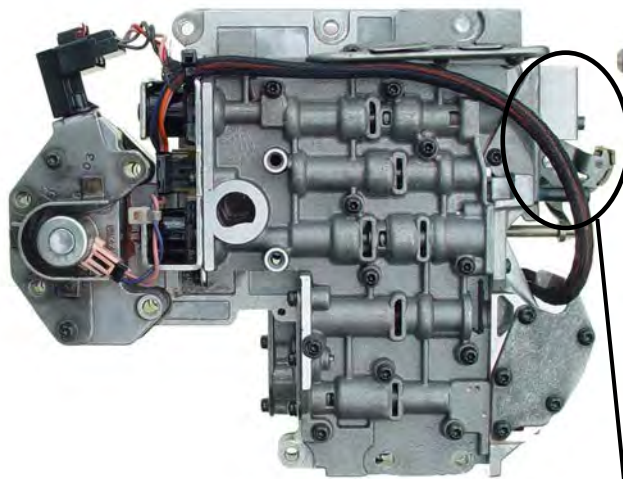
- 1-2 hole:
 - Normal .068 to .072
 - Crisp .076 to .086
- 2-3 holes .089 to .093
- Street Toys**
- 1-2 hole .093 to .106
- 2-3 holes .125 to .135
- Bigger hole = Firmer

For Snow Plow ONLY:
 Make hole R .093 and install ball.
NO hole R? No Ball!

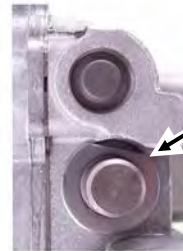


RH Models without Solenoid Body, Skip Step 1.

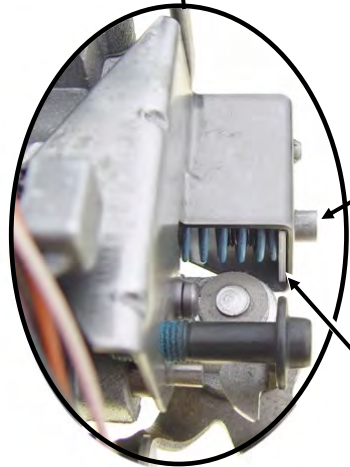




1. Install New shim and spring seat on PR valve before installing new inner and outer PR springs.



Install Spring Seat as shown. Make sure flat on spring seat has some clearance from casting. File casting if necessary to give it a little room to rotate slightly. Do not allow it to bind between PR valve and casting!



2. PR Adjustment

With 3/16" allen wrench, turn adjusting screw *clockwise* until spring seat is just *flush* against the inside edge of spring retainer. Then turn counterclockwise 2 turns for mild horsepower, 4 turns for major horsepower. Stock HP leave flush.

Flush Here

Fluid level checking: While the new manual valve provides oil to the converter in park, **DO** check fluid level in **Neutral** for accuracy as the converter is charged **MORE** in neutral.