



# 5R55W SHIFT KIT®

*Fits: S/W/N 1999-10*

**This kit is about: Won't Move- Pump Noise  
No Lockup Hot- Code- Slip- Shudder**

**Lockup Problems: Usually valve body caused, not the converter.**

**Trouble Codes: P1740, PO732, 733, 735**

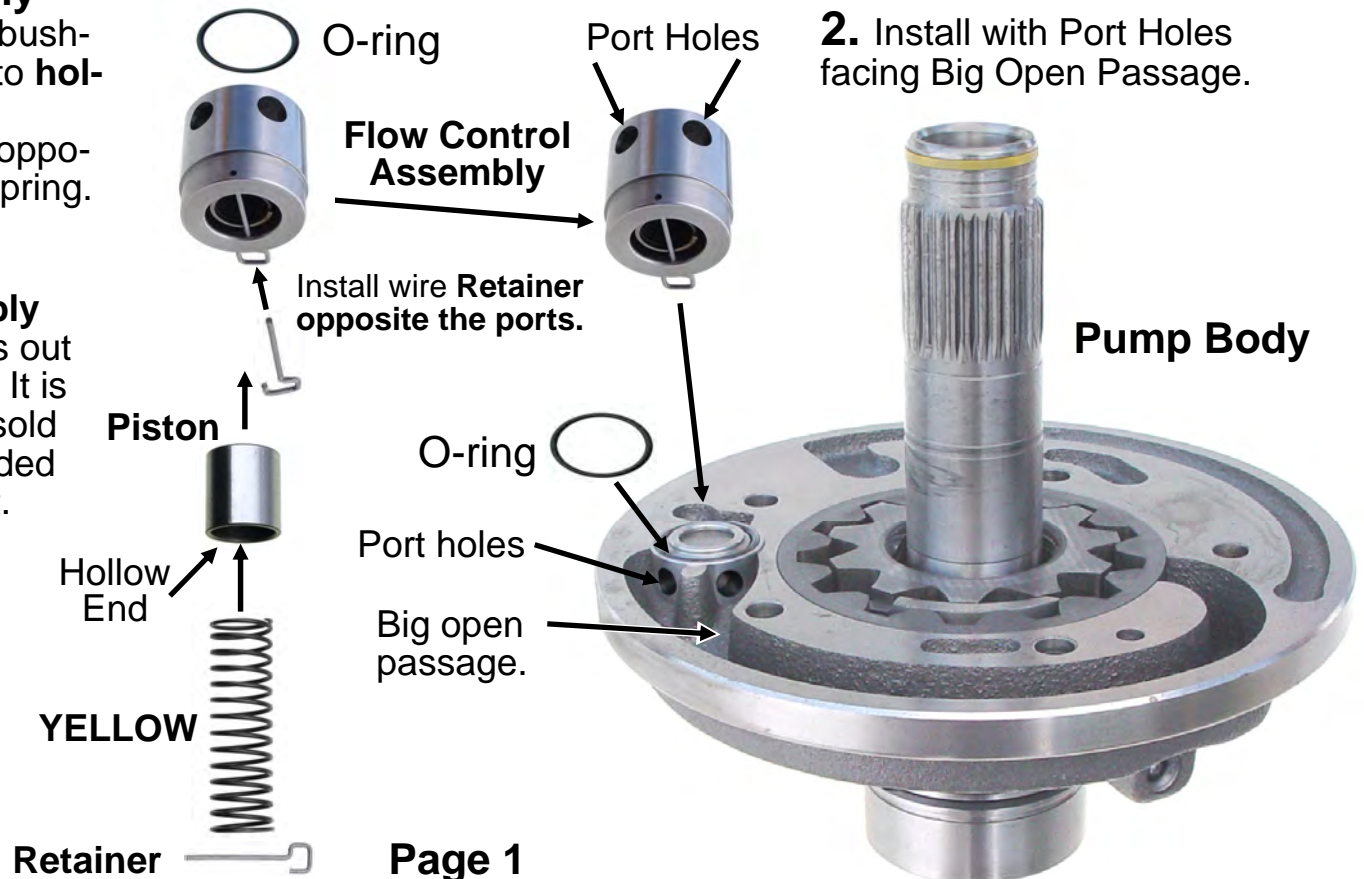
This is not a "do it yourself" kit. It's for experienced, professional Transmission mechanics only.

## 1. Flow Control Assembly

Install **solid** end of piston into bushing. Insert **YELLOW** spring into **hollow** end of the **Piston**.

Install **Retainer** into **Bushing** opposite port holes and under the spring.

**Original Flow Control Assembly**  
Sticks, causing won't move, wears out causing burned friction and noise. It is included in a new pump, and not sold separately. We believe the upgraded design will outlast the original part.



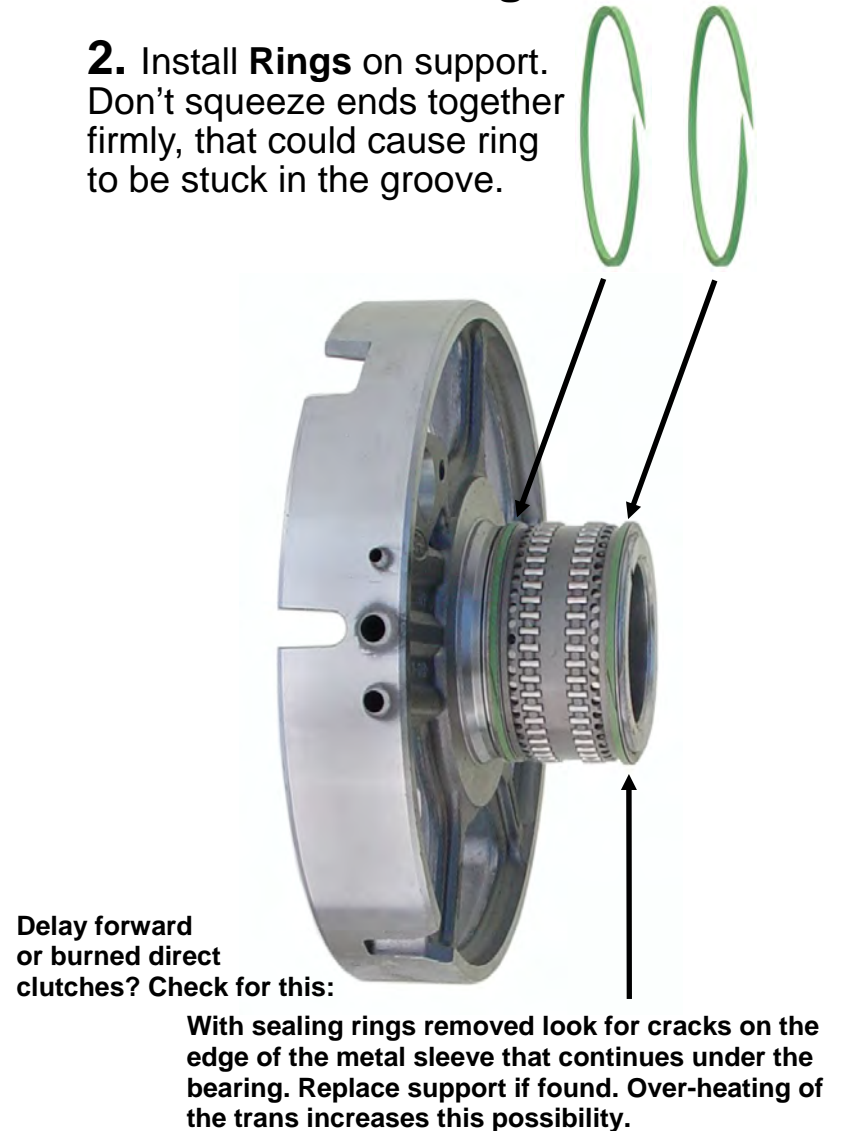
# 1. Assemble & Align Pump

Align pump **BEFORE** installing front seal.  
Start bolts, leave pump halves loose. Slide **Pump Tool**  
over stator spline. Push tool, while wiggling pump body  
making sure tool enters and snugs into the pump bushing.  
Tighten the pump bolts to 18 ft lbs.

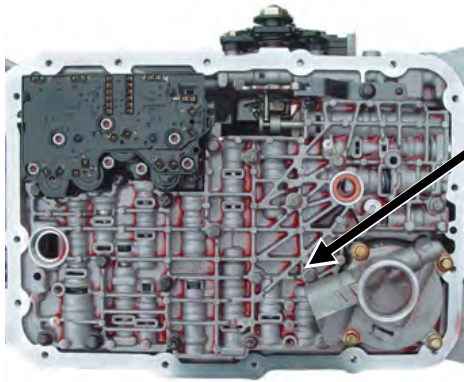


# High Temp Low Shrink Direct Clutch Rings

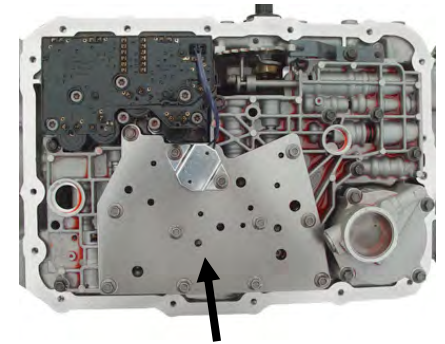
2. Install **Rings** on support.  
Don't squeeze ends together  
firmly, that could cause ring  
to be stuck in the groove.







**5R55-S or W Valve Body**  
Has NO Bottom Plate  
**USE THIS PAGE**

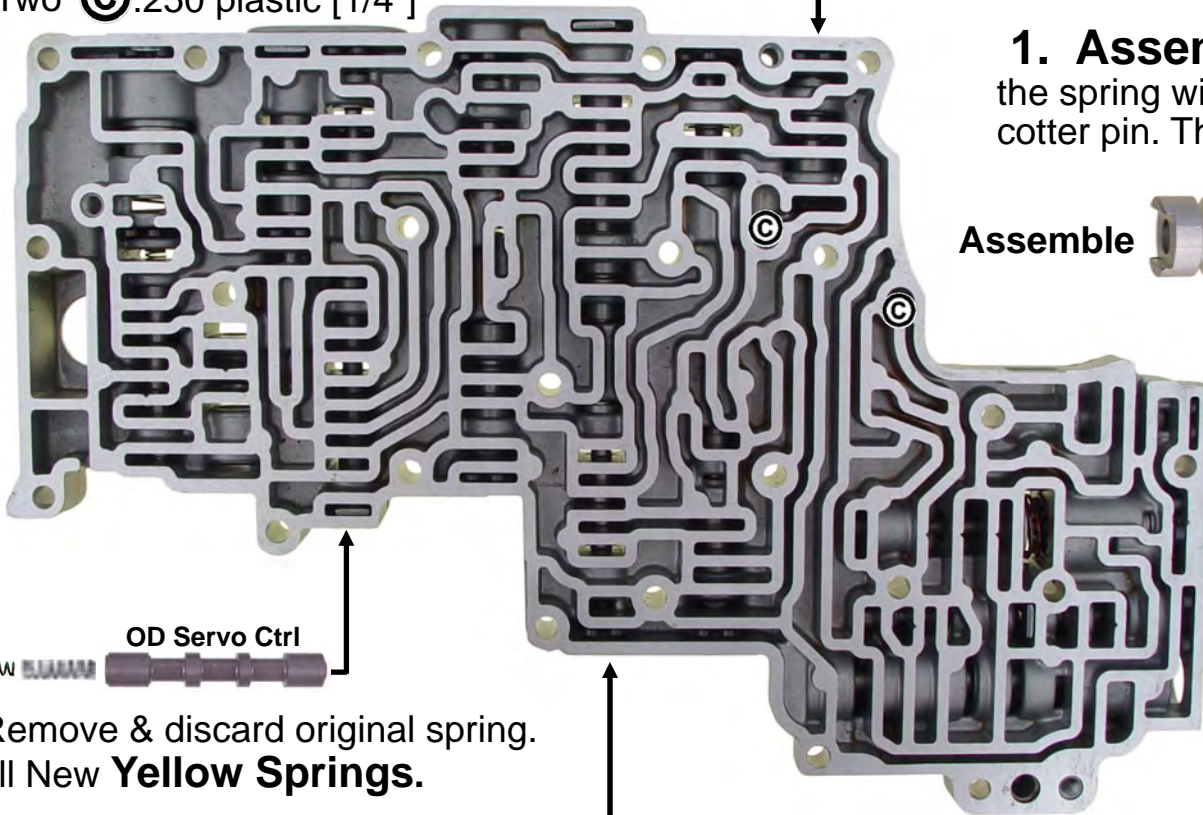


**5R55-N Valve Body**  
Has Bottom Plate See Page 5

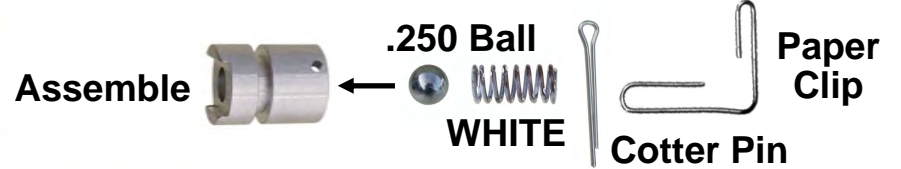


Install  
EPC Relief Retainer

Two © .250 plastic [1/4"]



**1. Assemble EPC Reliefs** Compress the spring with big end of paper clip. Install cotter pin. Then pull paper clip out with pliers.



**2. Remove & discard original end plugs and retainers. Install EPC Reliefs and Retainers in the two locations as shown.**



**3. Remove & discard original spring. Install New Yellow Springs.**



**4. Remove & discard original RS ISA Select spring. Install New Green Spring.**

# 55W or S Valve Body

5R55-N Valve Body: See Page 5

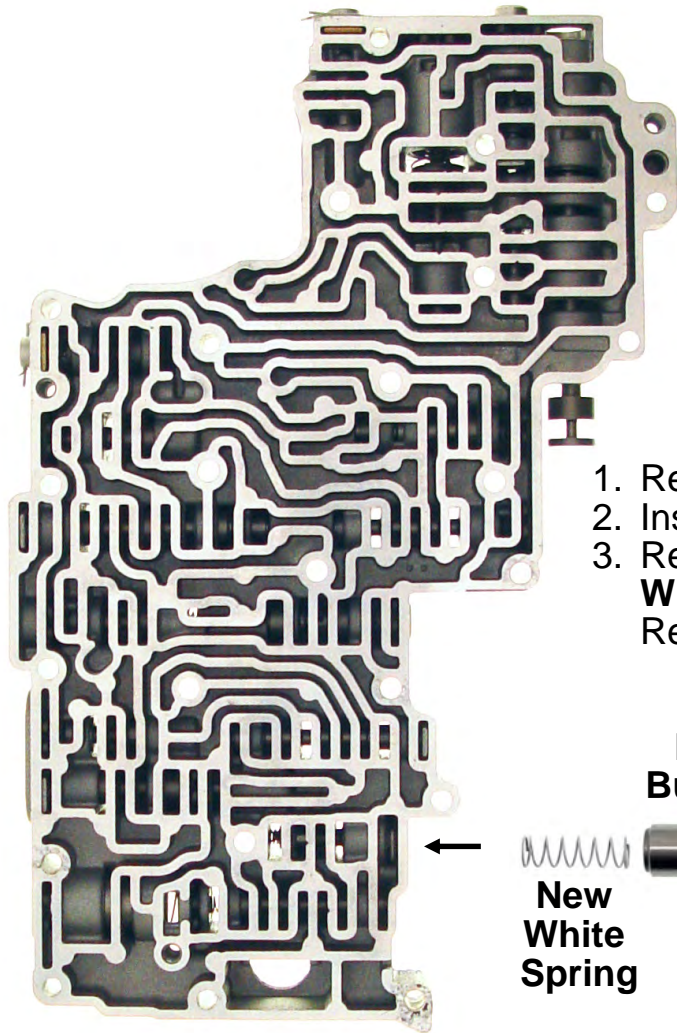
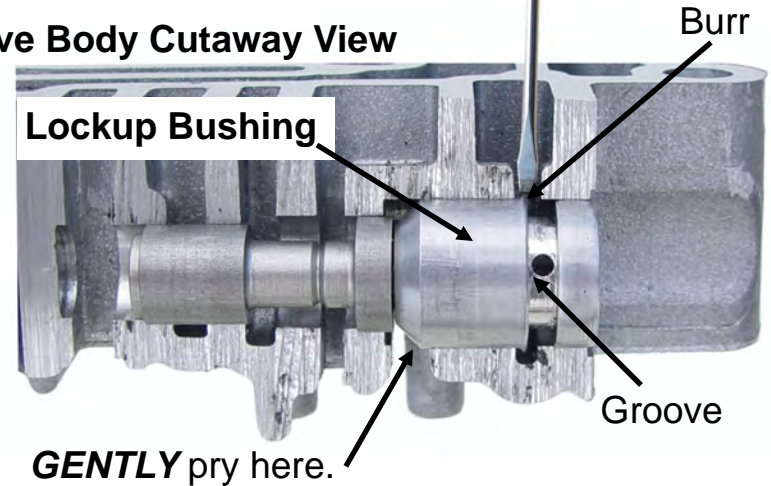
**IMPORTANT:** The retainer makes small burr on the inside edge of bushing groove. Using sharp end of a drill bit or sharpened screwdriver, carefully scrape off burr. Then remove bushing by **GENTLY** prying thru opening in bottom of VB.

**New Lockup Valve**  
No lockup, Shudder,  
Slip, and/or Code 1740.

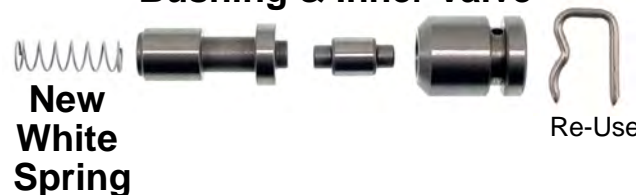
**LISTEN UP:** If the trans has no lockup when hot, but the fluid and filter look OK: Then this page will fix it from the bottom.  
Have Fun, Gil

1. Remove and discard original spring, lockup valve, bushing & inner valve.
2. Install new Lockup Valve. **Make sure valve freely strokes to bottom of bore.**
3. Remove new Lockup Valve and reassemble in the following order: Install **New White spring** and **Lockup Valve**. Install New Bushing and Inner Valve. Install Retainer. Lock-up will have **smoother engagement & more** capacity.

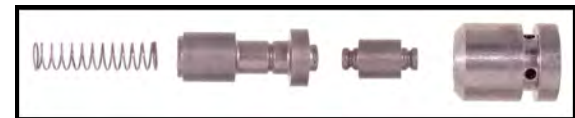
Valve Body Cutaway View



New Lockup Valve,  
Bushing & Inner Valve



Remove & Discard Original Parts



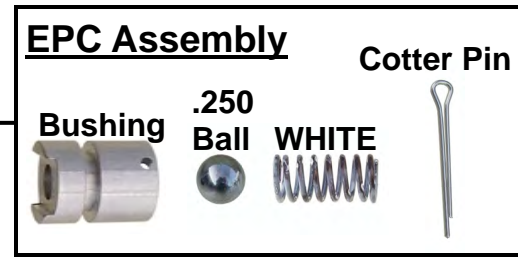
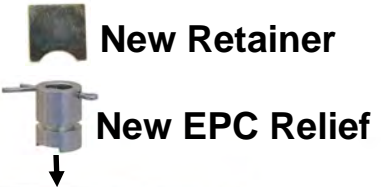
New Lockup Valve increases lockup capacity to reduce-prevent slip, shudder and Codes while retaining a smooth engagement. Works on ALL MODEL CONVERTERS.



# This page is for 5R55N Valve Body Only - Has Bottom Plate.

## 1. 4-3 Valve

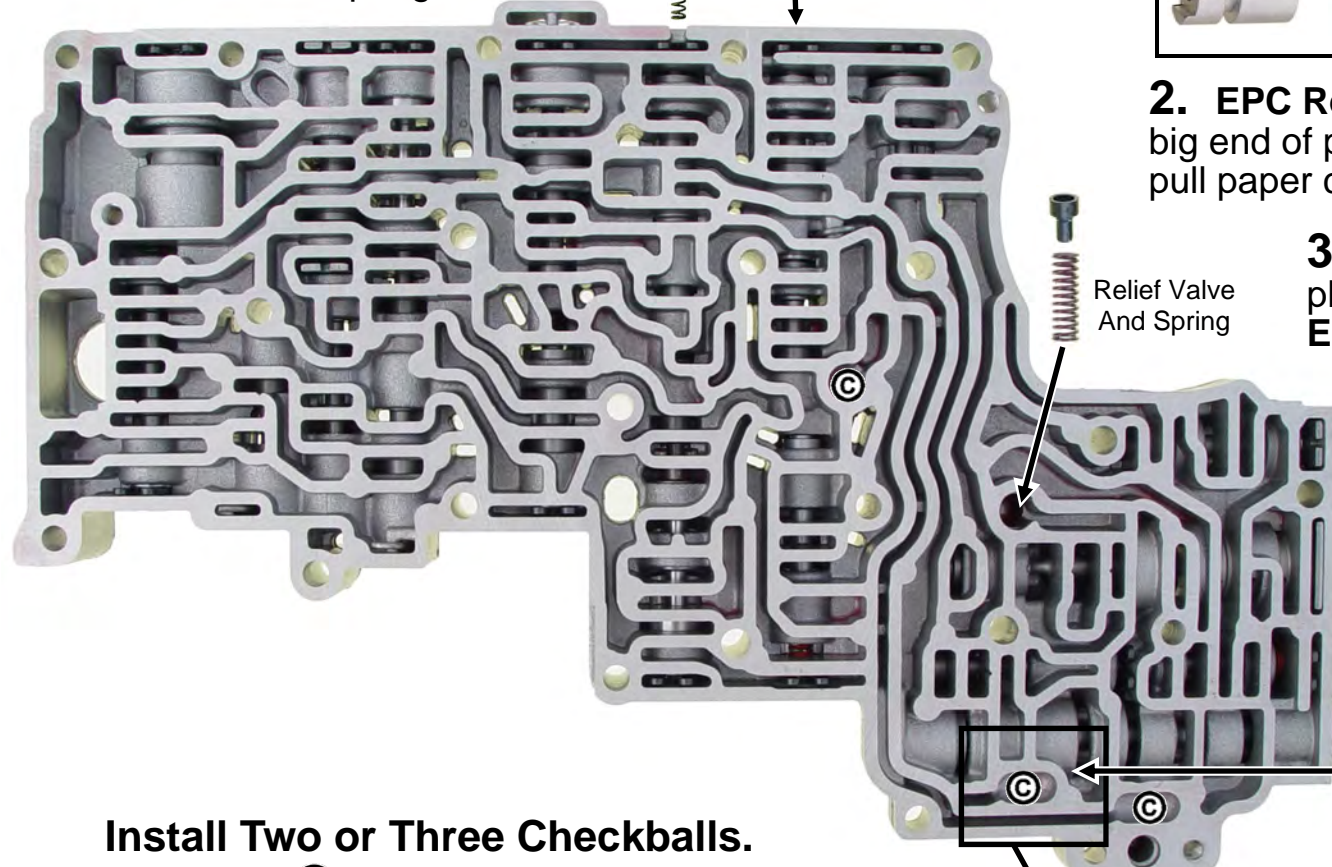
Discard the original spring. Install two **WHITE** springs.



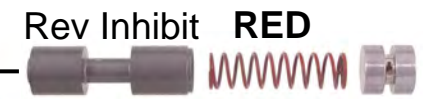
**2. EPC Relief:** Compress the spring with big end of paper clip. Install cotter pin. Then pull paper clip out with pliers.

**3.** Remove & discard original end plug and retainer. Install assembled EPC Relief with the new Retainer.

**4.** Remove & discard original Rev Inhibit spring. Install **New Red Spring**.



Relief Valve And Spring



If VB has **CLOSED Bathtub** like this, install this checkball.

If VB has **OPEN Bathtub** like this, **Do NOT** install checkball.

Install Two or Three Checkballs.

© .250 plastic



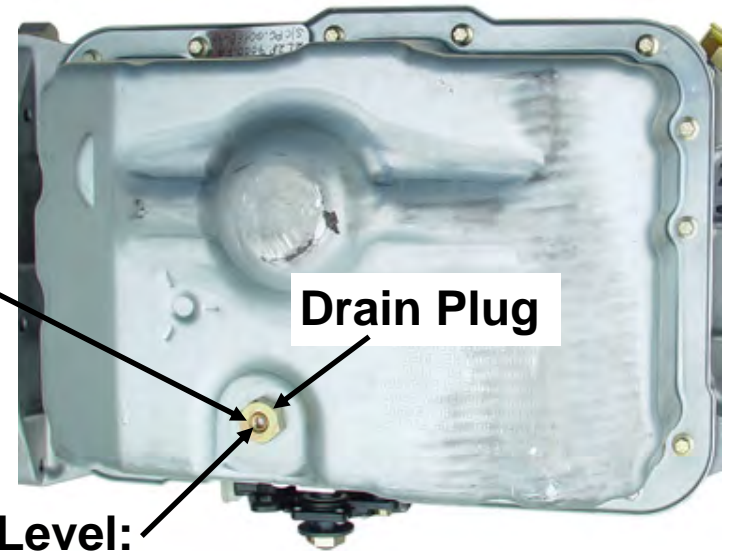
Mr Shift

# Additional information for reducing comebacks.

## Wrong Fluid Level is BIG Problem:

Check/Fill with Vehicle level, Engine running, Selector in Park.  
**TEMPERATURE: NOT HOT or Cold.** Must be 80° to 120°, warm to touch and yet be able to keep your hand on the pan.

Remove *Allen* plug in center of pan drain plug. Install Mercon 5 fluid thru Fill Hole, until fluid flows with **steady stream** out Allen plug hole. Reinstall Allen plug with sealer.



**Check Level:**  
**Must run full stream out this hole.**  
**If just burping out--it is not full.**

**Codes P0732 & P0735, 1-2 Slide Bump, 2-3 Flare, 4-5 Slide Bump or Trans has Burned OD Band.**

**Worn OD Band Servo Pin Bore**  
 Inspect bore in case for wear. If pin bore is worn, BIG leak at OD servo.



Repair kit available [www.servobore.com](http://www.servobore.com)  
 Or call 715-458-2617--FAX 715-458-2611

## Fill Hole

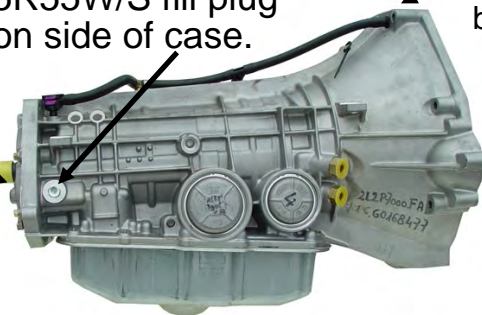
5R55N fill plug on rear housing.

5R55W/S fill plug on side of case.

Overfull: Fluid will burp into bell housing. ☹️



View from Rear



**Check Level:**  
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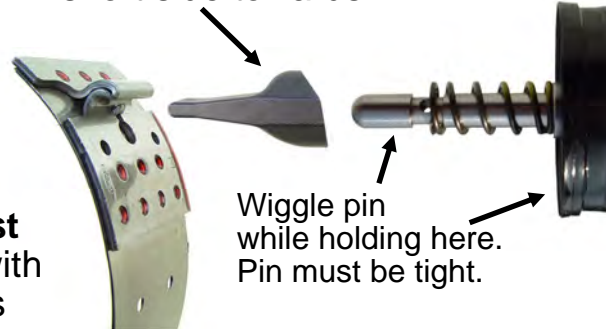
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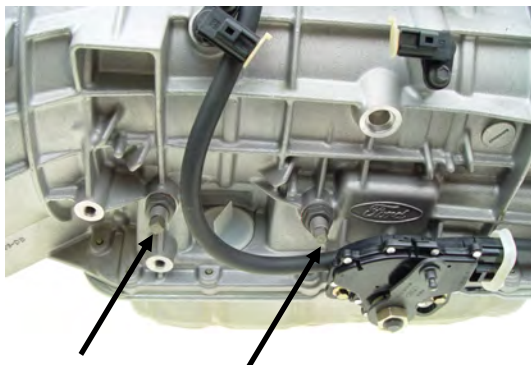
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## LOOK HERE:

Intermediate and Overdrive band servo struts install with short side towards VB.



Wiggle pin while holding here. Pin must be tight.



**OD & Intermediate Band Adjust**  
 Tighten adjusting screws snug with short wrench. Back off two turns and tighten the locknuts.