

TURBO ACTION

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Part #24146 - Turbo Hydro "375" & "400" 1965-Up CHEETAH Manual Valve Body - **PRN321** Stock Pattern

(No Engine Braking First Gear, Not Recommended for Street)

Installation Instructions

FIRST, READ INSTRUCTIONS CAREFULLY, THEN PROCEED TO INSTALL VALVE BODY BY FOLLOWING EACH STEP INDIVIDUALLY.

Valve Body	1 - 24146	Valve Body 1965-Up (Includes Late 2-3 Accumulator Piston Installed)
Kit Includes:	1 - 24115	Special Valve Body Spacer Plate
	1 - 24117	Expansion Plug (See STEP #7)
	1 - 24148C	Pan Gasket
	1 - 24149	Spacer to Valve Body Gasket (Small) OEM#8623561
	1 - 24150	Spacer to Case Gasket (Large) OEM#8623563
	1 - 24122	Modulator Replacement Plug
	1 - 24982	2-3 Accum. Piston 1965-70

STEP #1: Transmission should be cool before installing. Be sure vehicle is secure to prevent rolling. Drain oil by carefully removing transmission pan bolts. Recommend leaving a couple of bolts partially attached until some of the oil has drained.

STEP #2: Remove transmission filter. If 1968 or newer model, remove retaining bolt, hold pipe that filter is connected to and then pull filter off.

STEP #3: Before loosening valve body, note how the gear selector lever connects to the manual control valve in the valve body. Fig. #2.

STEP #4: Remove bolts from valve body and then **carefully** remove governor tubes and valve body together. **Avoid** bending governor tubes. If 1970 or newer model, disconnect white wire from the valve body. Also, **be sure** the manual control valve **doesn't slide out**.

Note: **Sometimes the Intermediate Servo will fall out when removing the valve body, Fig. #3.**

STEP #5: Remove the two bolts holding the downshift solenoid and valve body spacer plate. Make sure you support the spacer plate with your hand. Lower the plate with steel balls **carefully**.

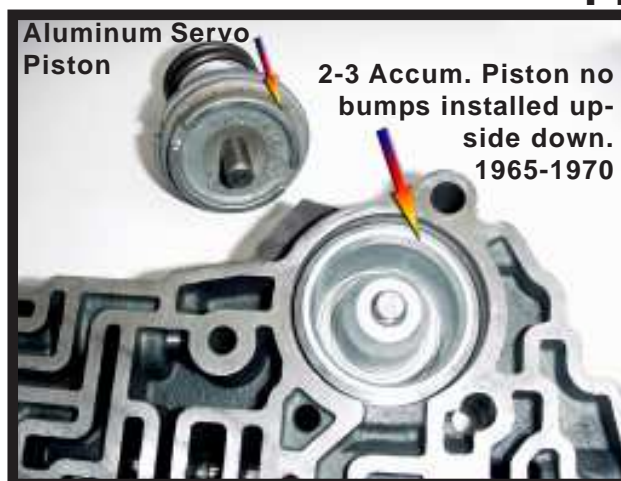
STEP #6: If transmission is being overhauled when installing the valve body, the following steps will enhance the 2-3 shift. However, if unit is not being overhauled, DO NOT DO STEP #7.

STEP #7: Remove center seal from direct clutch drum, Fig. #2A. Install expansion plug #24117 as shown in Fig. #2A. This expansion plug must be driven in until it is flush with case or deeper.

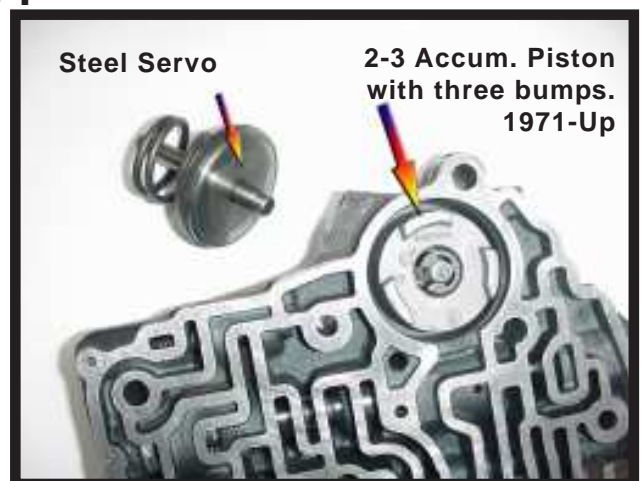
- STEP #8:** Install into the Turbo Action valve body, the piston that matches the type intermediate servo in your transmission. **Do not** install spring from old valve body Fig. #1.
- STEP #9:** Using Special Valve Body Spacer Plate #24115, lay one of the new Valve Body Gaskets at a time behind plate and be sure all holes are open. Place petroleum jelly on **case side** of Valve Body Spacer Plate and place larger gasket on that side being sure all holes line up. Then put smaller gasket on the **valve body side** of the plate.
- STEP #10:** Install Ball #1 only on new plate #24115 with petroleum jelly, Fig. #4. Balls #2, #3, #4, #5, #6; the governor tubes; and the white wire may be discarded. **Note:** If 1987-Up, transmission will have seven balls. Discard #7 ball.
- STEP #11:** Remove manual control valve from old valve body and place into your new valve body.
- STEP #12:** Sometimes the intermediate front servo will have fallen out when removing the old valve body. See Fig. #3 for proper reinstallation.
- STEP #13:** If transmission is still in vehicle, carefully place Special Valve Body Spacer Plate #24115 with gaskets and Ball #1 onto the valve body. Take two valve body bolts and guide them up through the valve body, plate and gaskets.
- STEP #14:** Install valve body with gaskets and plate into transmission. **CAUTION:** Before tightening bolts in valve body, be sure to line up the manual control valve as mentioned in STEP #3, to prevent bending the valve, Fig. #2. Torque all bolts 8-10 ft/lbs.
- STEP #15:** Install new transmission oil filter being sure of a good fit. **CAUTION:** If filter is not properly installed, a loss of oil pressure will occur. Recommend using our filter #24006 (1965-67) models and #24011 (1968-Up) models. If 1968 or newer models, reinstall retaining bolt.
- STEP #16:** Disconnect vacuum line to modulator and be sure to block off line! Install #24122 Modulator Replacement Plug in place of the modulator. **Do Not remove the valve which was in the case behind the modulator!**
- STEP #17:** Replace old pan gasket with #24148C and bolt up transmission oil pan. Refill transmission with a good brand of Dexron Mercon or Type F transmission fluid. Warm transmission up and **select all gears with foot on brake.** Place gear selector in park. Then check to make sure transmission level is on the add mark. Take vehicle out and drive 2 or 3 miles. Then **recheck** oil level. Add oil if necessary to bring to the full mark. **DO NOT OVERFILL!**

Special Note: Governor can be removed from case.

Fig. #1



1965-1970 Inter. Servo & 2-3 Acc



1971-Up Inter. Servo & 2-3 Acc

CAUTION

Be sure that Manual Control Valve lines up with selector pin on the selector lever!

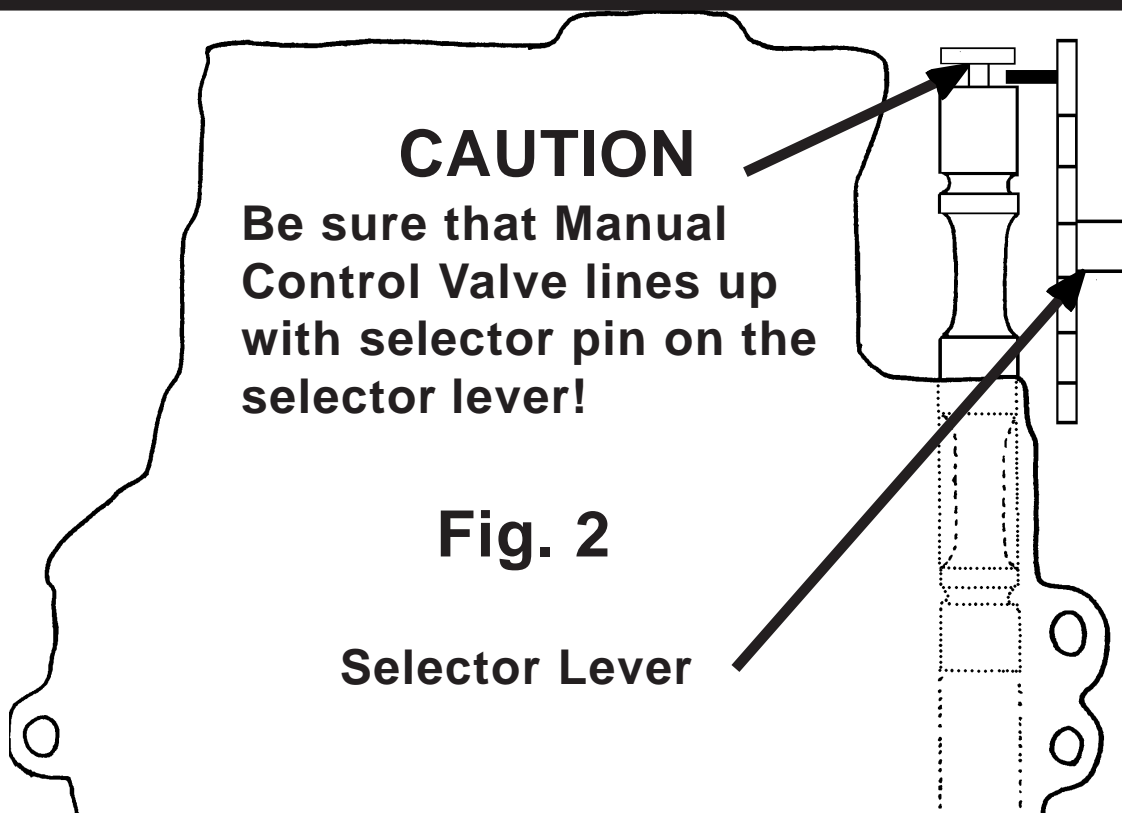


Fig. 2

Selector Lever

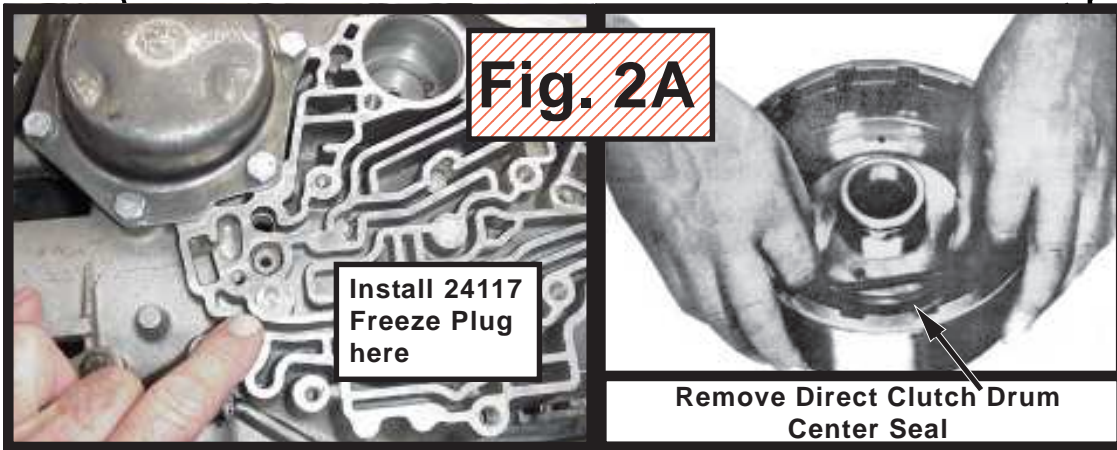


Fig. 2A

Install 24117 Freeze Plug here

Remove Direct Clutch Drum Center Seal

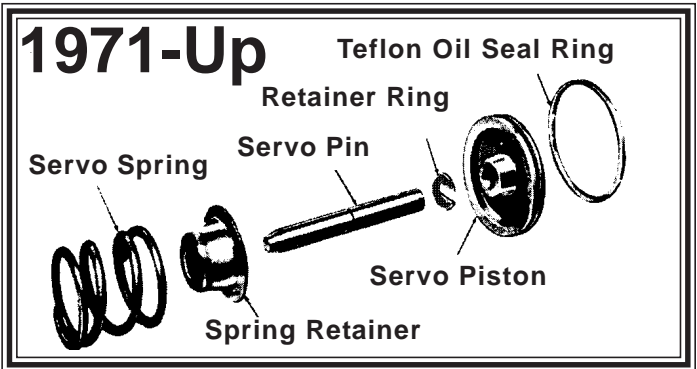
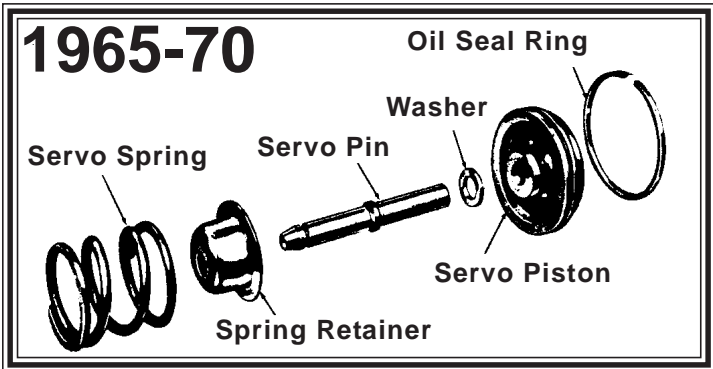


Fig. #3

SPECIAL INTERMEDIATE FRONT SERVO NOTE

Sometimes the Intermediate Front Servo will fall out when lowering the spacer plate. If so, be sure to reinstall per drawing.

Steel Ball Locations

Discard #7 Ball
if your unit has
one.

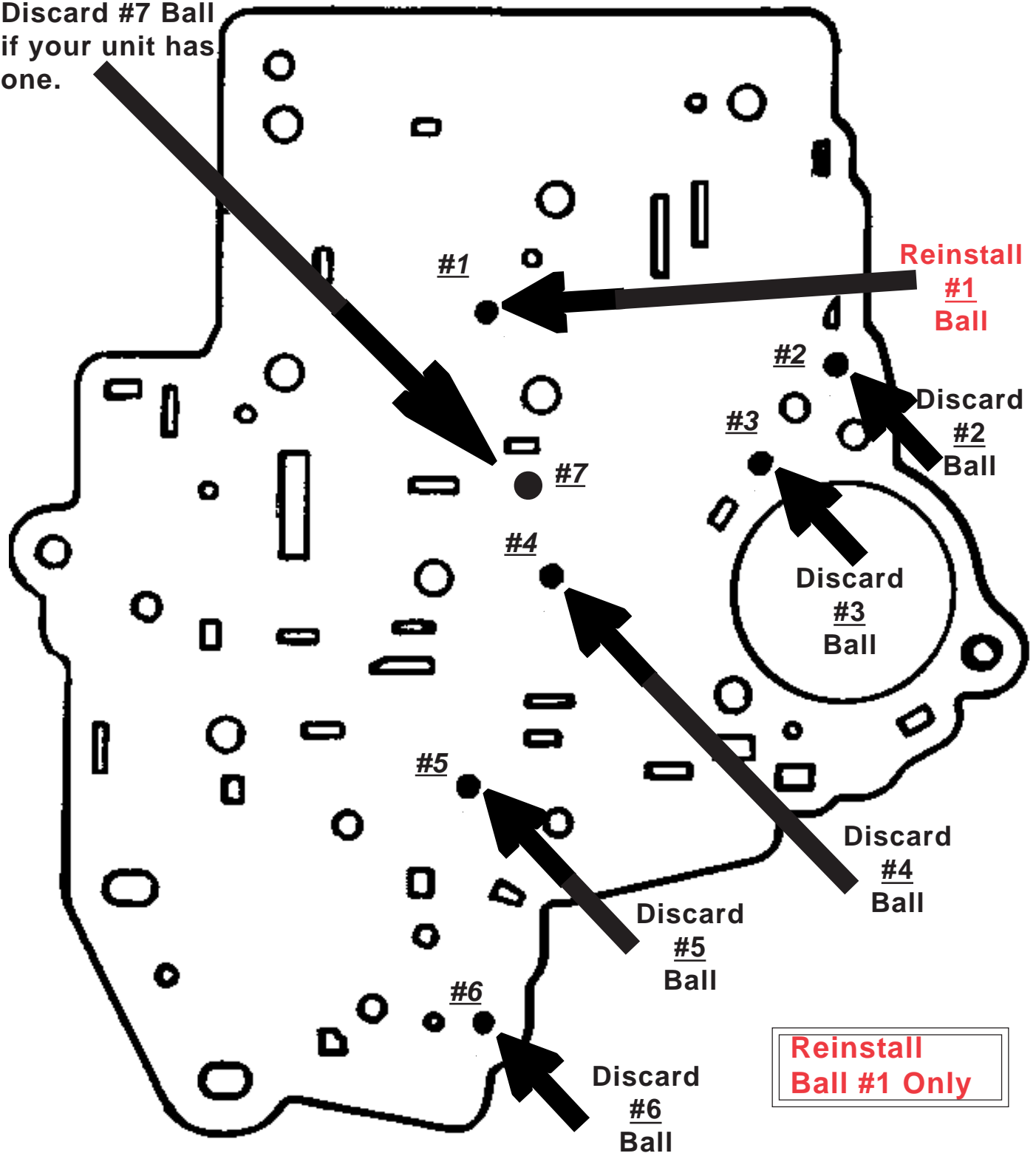


Figure #4