Valve Body Recalibration Kit
DODGE
1990 - 2002
Installation Guide
DISCLAIMER OF LIABILITY

This is a performance product which can be used with increased horsepower above and beyond factory specifications. Additional horsepower creates more stress on the drivetrain components, which could result in drivetrain failure. Legal in California only for racing vehicles which may never be used on the highway.

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**Step 1**
This kit only fits Valve Bodies without this balance whole. If your original plate has this balance whole then you need to use another kit.

**Step 2**
If trans is apart, install Seal Rings.

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**Identify Valve Body.**

Balance Whole

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**One small Seal**

Forward drum

Direct drum

Two smallest rings *not furnished* in kit.

Pump
Step 3
Install new lower 1-2 Accum spring as shown. Some models use upper spring, reuse it.

Step 4
With a Vale Body bolt and small hammer, gently tap the tapered orifice into this whole.

Step 5
Discard original. Install tall white servc return spring. Front band adjust snug with short wrench back off 1-3/4 to 2 turns.
Step 6
Install converter with multiple clutches or working on non lockup transmission then skip this step. Drill one or two .076 to .096 holes down through the bottom of the most outboard passage.

One Hole = Slightly firmer Lockup
Two Holes = Muc firmer Lockup

No cross drilling required. If valve body has cross drilled hole here from previous repair plug it.
**Step 7**
For NORMAL USE skip this step. If later throttle on up-shifts are desired, install new Green TV spring. No need to grind TV valve.

![Green TV spring](image)

**Step 8**
Turn the valve body over. Using the edge of a large file, file a notch about halfway thru the thickness of this partition.

![Valve body with notch](image)

- File a notch across bore top to bottom. It’s not fussy.
Step 9
Install New Spring:
Yellow 12 Valve Engine
White 24 Valve Engine
White Gas Engine

Step 10
Install new transfer plate between cover and part throttle body.

Transfer plate does not go on spring side!
Step 11

Install new transfer plate between cover and part throttle body. Using a pick and small hammer, taper top of this hole to help start the pin. Install pin furnished into this hole, using needlenose pliers and small hammer. File flush if needed. PT body must sit flush against valve body.
Step 12

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

Step 13

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

Six Check-balls
One Cherrybomb

© Five 1/4” (.250)
✓ One 11/32” (.343)
Step 14
Four Land switch valve only grind one notch on slight angle to about the middle of this the land. Do not grind three land switch valves. Valve body with three land switch valve resue original separator plate.

Step 15
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.
Step 16
Place .156 drill into hole shown and rill all the way through the accumulator housing and out the other side. With small punch drive plug into hole just below flush.

![Plug](image1)

Step 17
With small punch drive tapered plug into this hole just below flush.

![Plug](image2)
Step 18
Remodels only. If working on RH model with Governor on output-shaft then skip this step. Install limit brushing, 3/16 ball and White spring as shown.
**Step 19**
Install new transfer plate as shown between valve body and Accumulator housing.

**Step 20**
Discard original spring. Install new Red Springs.
**Step 21**
RH models only. Install new spring here.
White 12 valve engine
Orange 24 valve engine
Orange gas engine

**Step 22**
RH models only. We need to add hole to the Lower Valve Body Plate. Use channel casting as drill guide. Place plate on channel using two valve body bolts to line up as shown, then flip it over.
**Step 23**
RH models only. Use this rectangle passage as guide to drill .103 hole through lower plate as shown.

1/4” Check-ball

ONLY install 1/4” check-ball here if using plate with hole R
Step 24
Use New Plate with 4 land switch valve on the valve body only. Resue original plate if valve body has 3 land switch valve or has a large suction hole!

Now enlarge both 2-3 holes:
Stock engine .089 to .093
Modified engines .103 to .106

For Snow Plow only:
Make R hole .093 and install ball
Step 25
Install new plate against channel casting then gasket and solenoid body.

Step 26
Install the new Lockup Bracket.
Step 27
For modified engines or need more lockup pressure with new rings instal (step2) enlarge this hole to .076 to .096

Bigger whole = more pressure

Step 28
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!
Step 29
With 3/16” allen wrench, turn adjustment 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.

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.