

This is not a “do it yourself” kit.  
It’s for the experienced, professional Trans mechanic only.

# TFOD-HD2 Reprogramming Kit™

**Fits:** 1988-2007 Chrysler Torqueflite and Loadlite rear drive 4 speed.  
**Diesel and Gas, V6, V8 & V10; A500-518-618--42-44-46-47RH & RE.**

**Does Not Fit 2003 & later 48RE** (see next page)

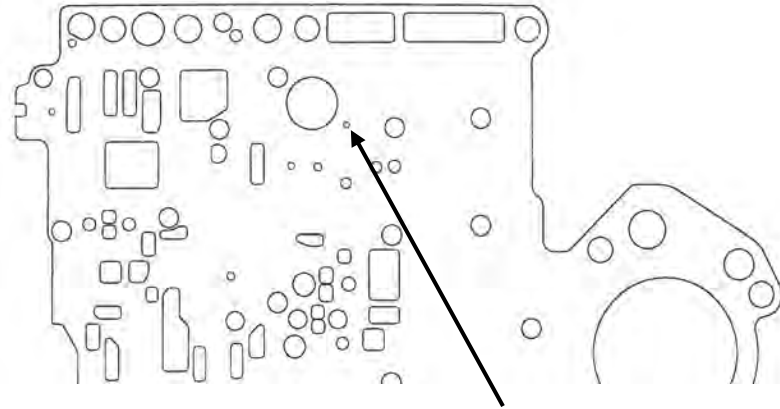
**Short, Firm Shifts with Performance, Durability and “CLASS”.**  
**Holds 1st, 2nd and 3rd to any engine speed.**

**COMMAND CONTROL Option: Backshift to ANY gear you want.**

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

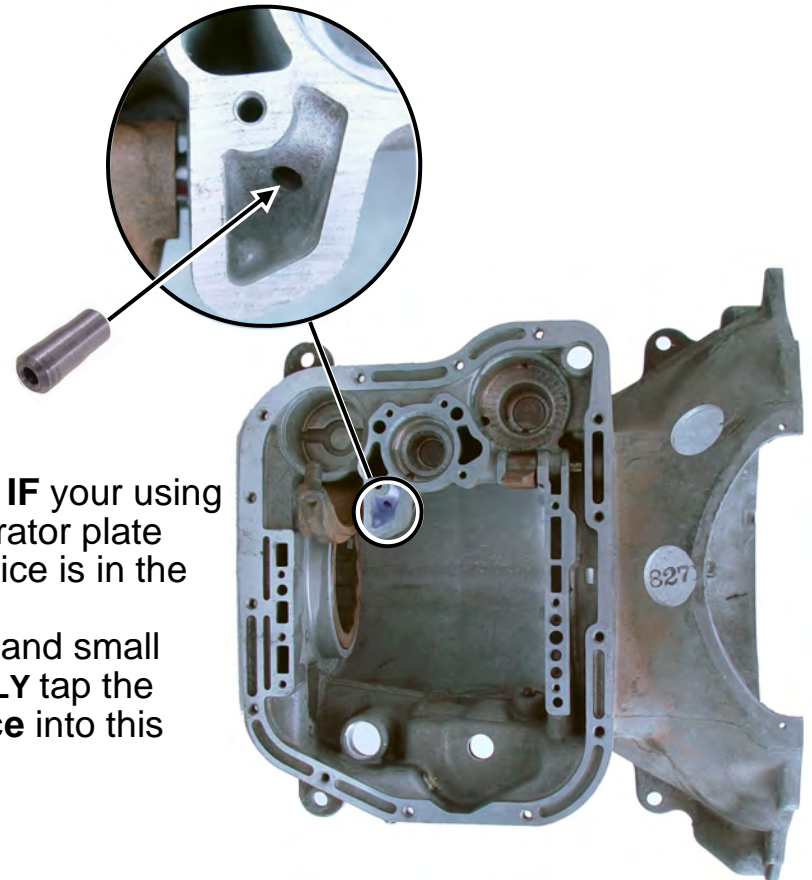
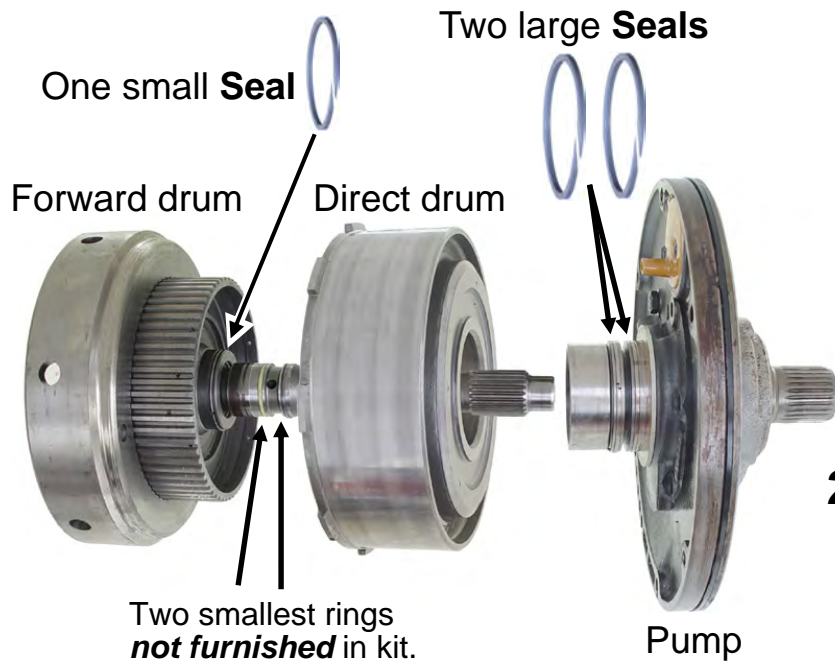


**Stop! Check VB type before proceeding.**



**This Kit only fits VB's WITHOUT this balance hole. If your original plate HAS this balance hole USE SK 48RE kit.**

**1.** If trans is apart, install Seal Rings.



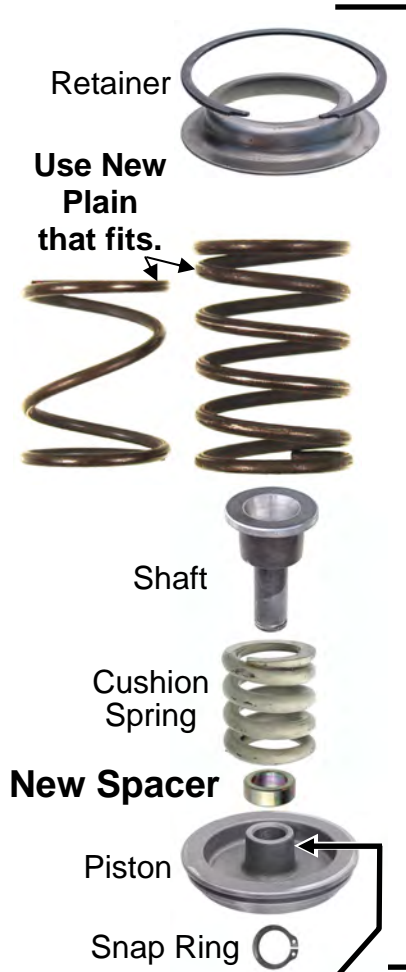
**2.** Skip this step **IF** your using the **NEW** separator plate provided. (Orifice is in the new plate.) With a VB bolt and small hammer **GENTLY** tap the **Tapered Orifice** into this hole.

# 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.

## 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.

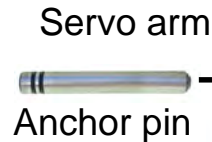


Replace piston if cracked here.

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.

## 3. Install New 1-2 Accum spring.

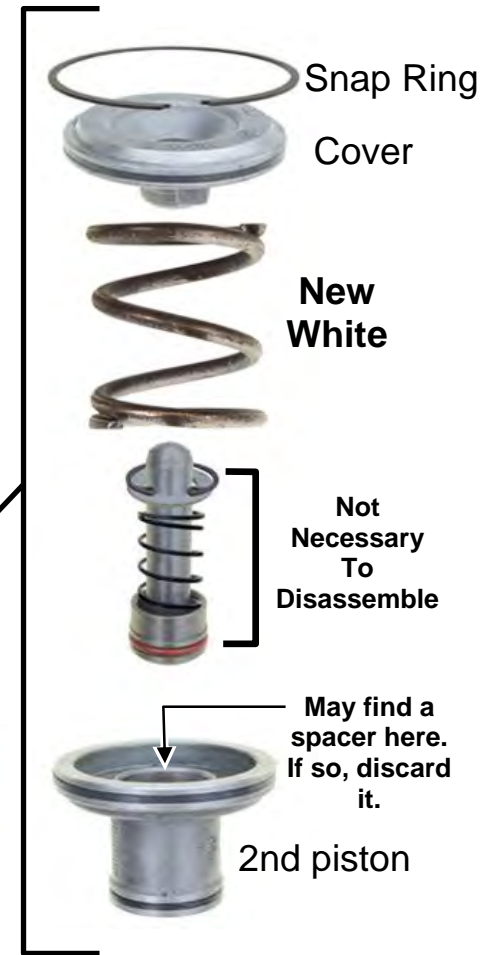
Some models also have a spring here reuse it.



**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.

## 2. 2nd Servo

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



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

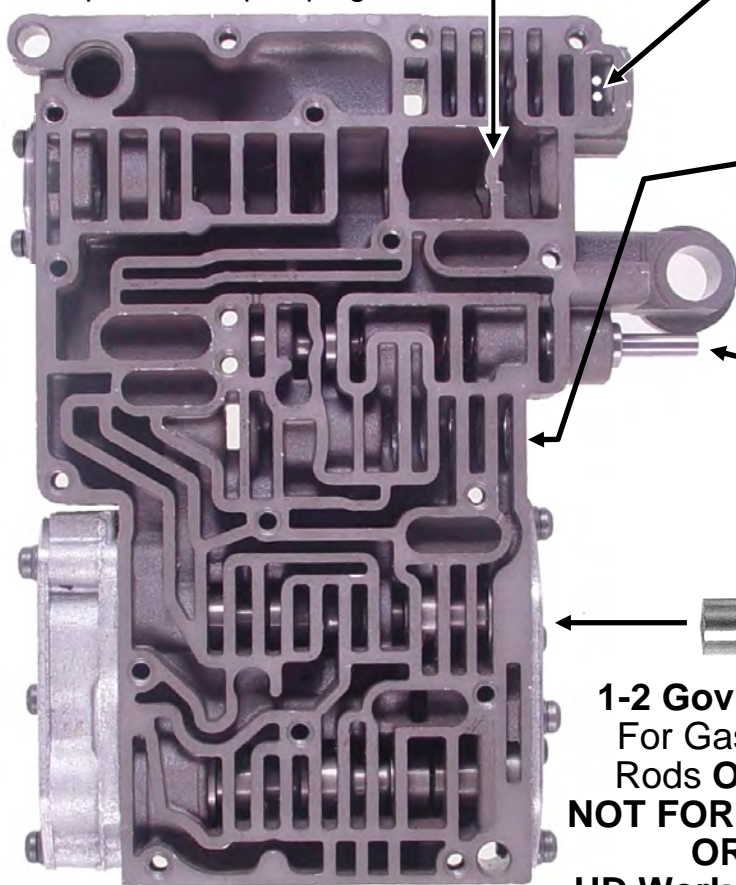


**Installing converter with multiple clutches or working on non lockup transmission SKIP step one.**

**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

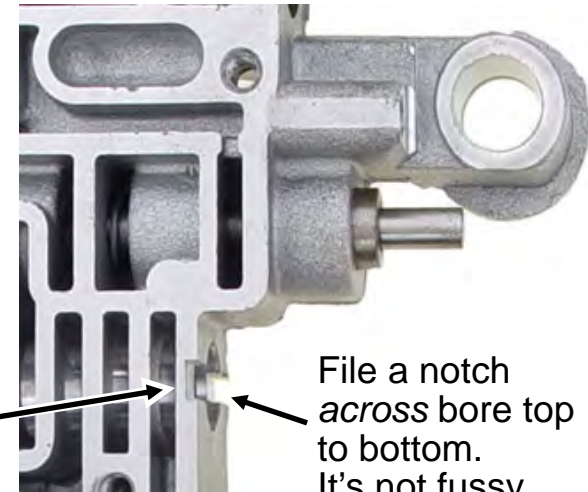


No cross drilling required. If VB has cross drilled hole through this partition from previous repair plug it.



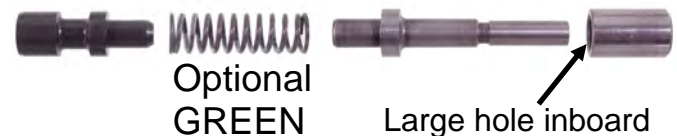
**1-2 Gov Valve**  
 For Gas Hot Rods **ONLY!**  
**NOT FOR DIESEL**  
**OR**  
**HD Work Trucks!**

**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.

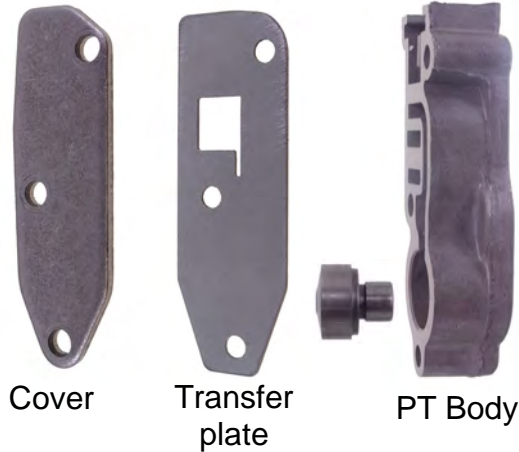
**3.** For later throttle on up-shifts install new GREEN TV spring, otherwise **skip** this step for **normal** use. No need to grind TV valve.



**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.**

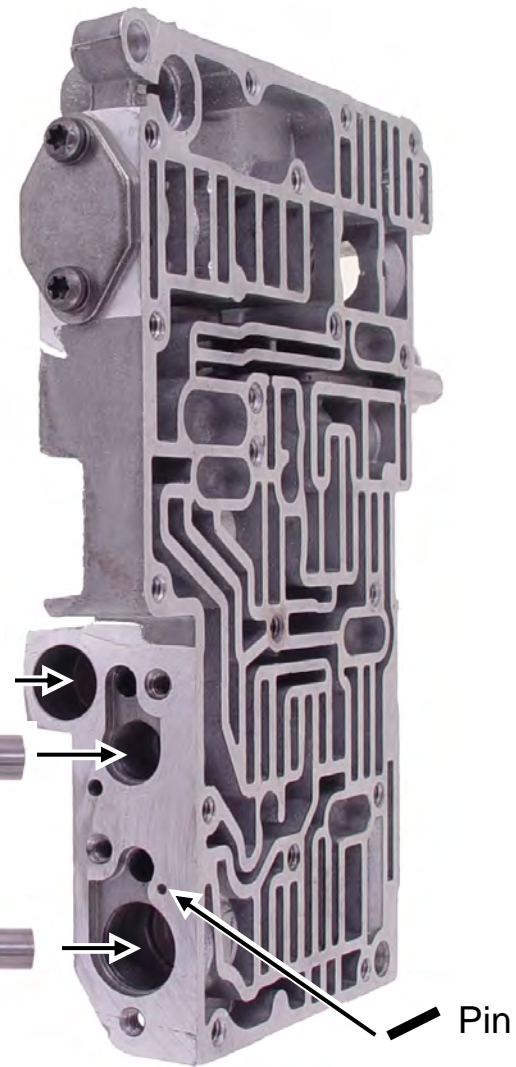


**1. Install New Spring**  
**Yellow** 12 Valve Engine  
**White** 24 valve Engine  
**White** Gas Engine



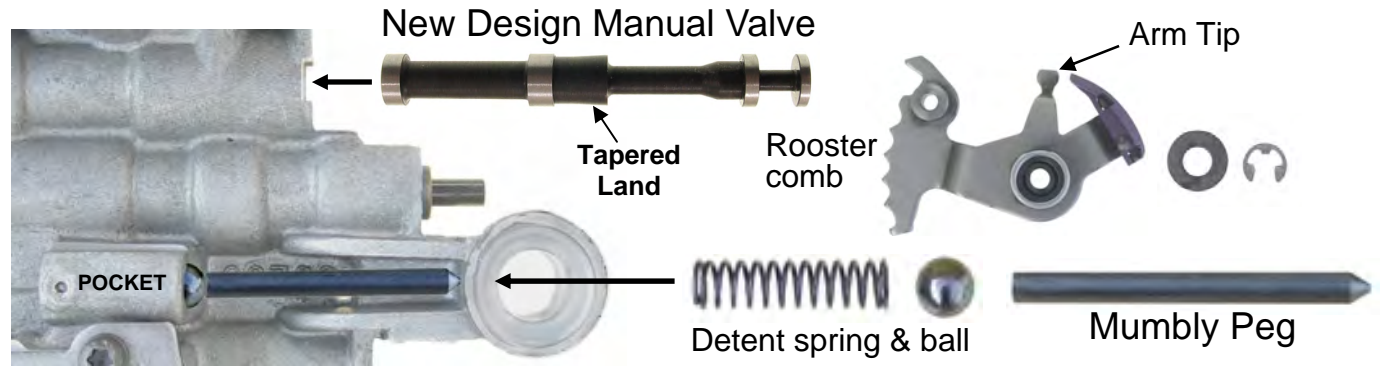
**LISTEN UP!**  
**New Transfer Plate DOES NOT install on this side of PT body!**

**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.

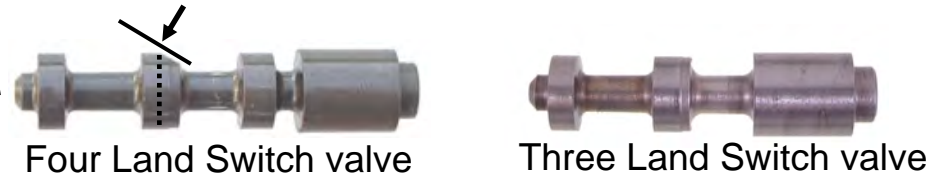
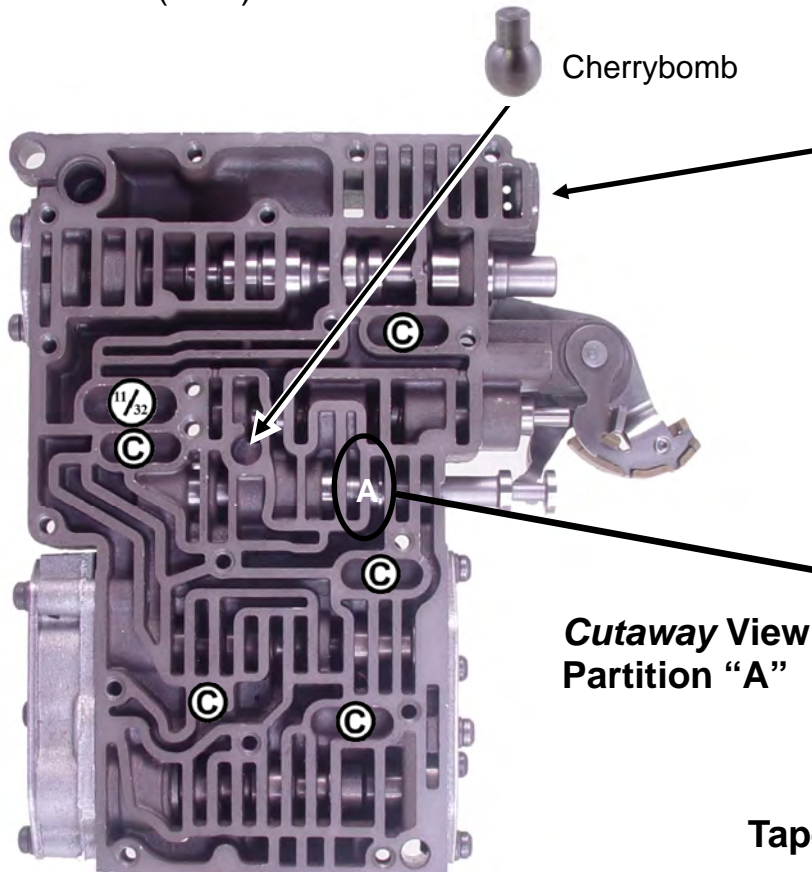


**Six Check-balls  
One Cherrybomb**

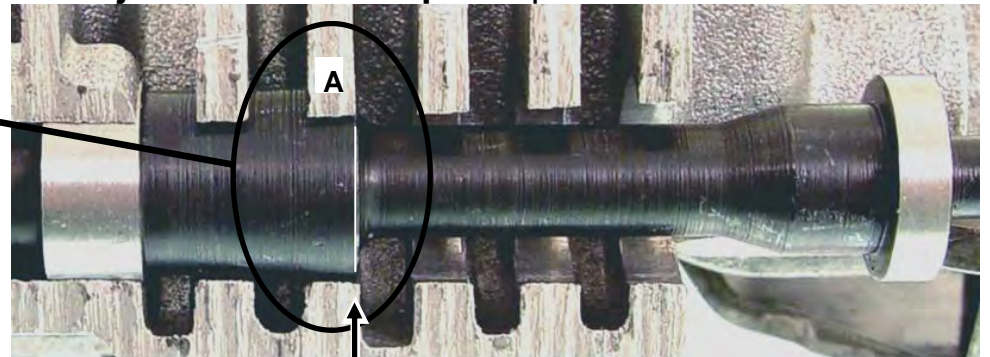
2. Discard this check-ball install Cherrybomb here: Careful to align stem of Cherrybomb through hole in plate when putting VB half's together.

- © 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.

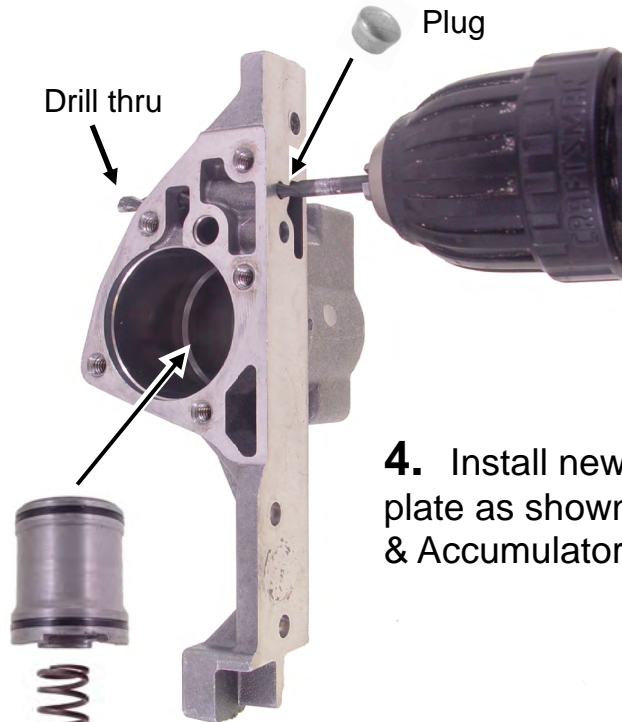


4. **Manual Valve position.** With valve all the way inboard (Park position) the *right edge* of the Tapered land must be flush with *right edge* of partition "A". (.030" from flush either way is ok.)  
**To Adjust:** Bend **Arm tip** with pliers.



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.



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

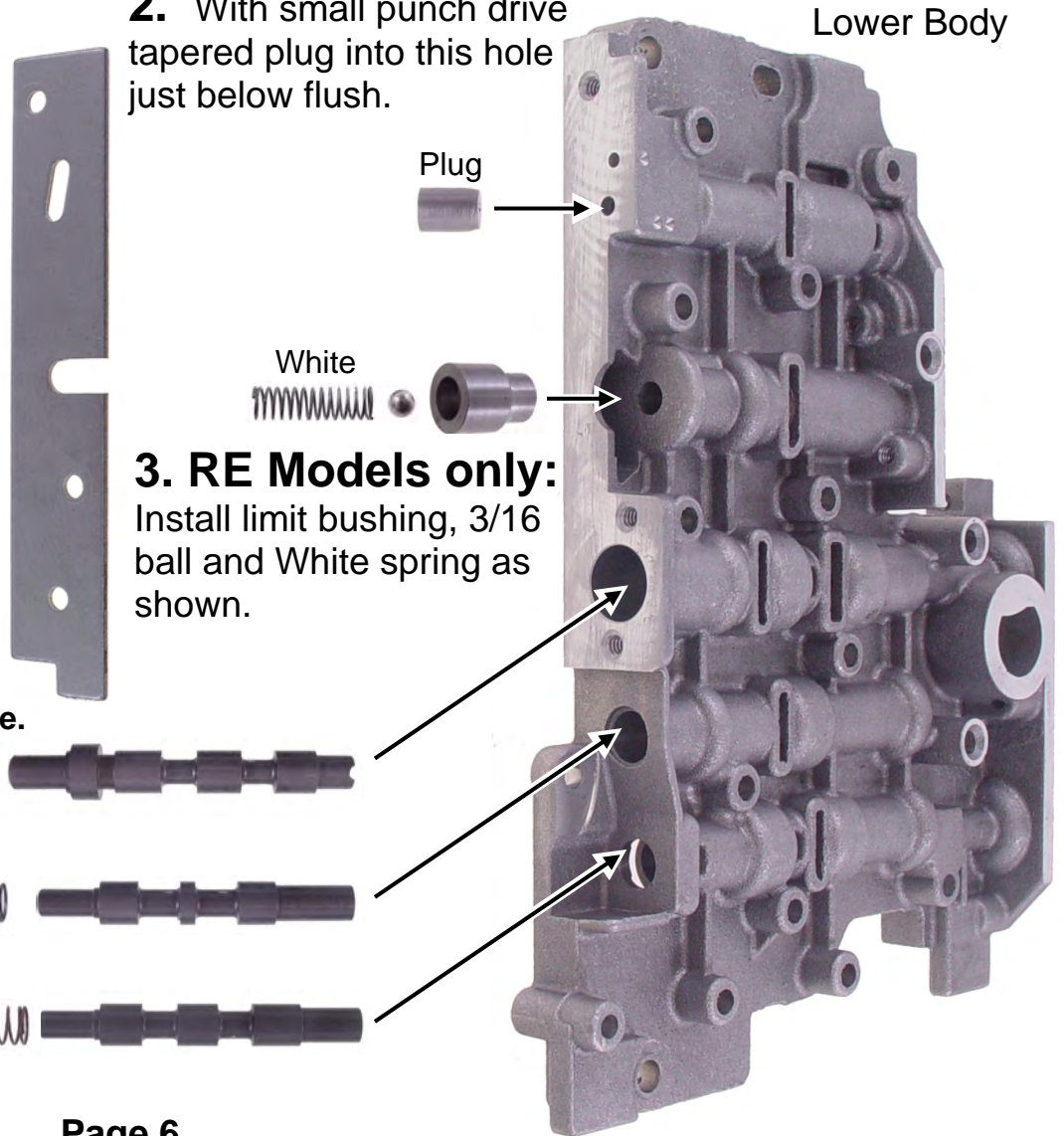


**5.** Discard original spring  
Install new **Red** Springs.

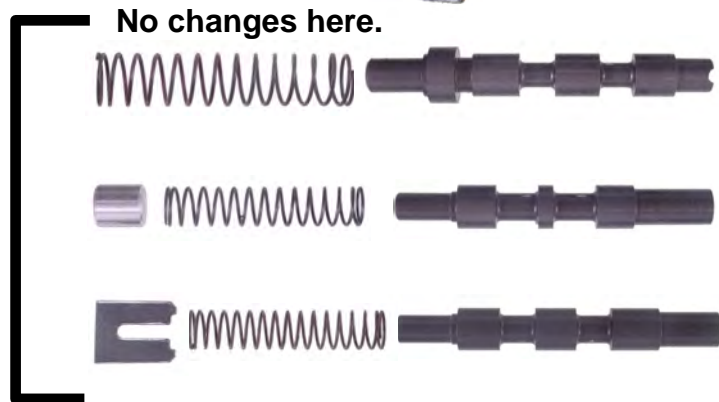


**If working on RH model with Governor  
on output-shaft Skip Step 3**

**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.



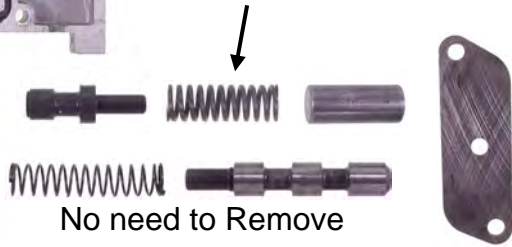


If working on RH model with Governor on output-shaft Skip Steps 1, 2 & 3.

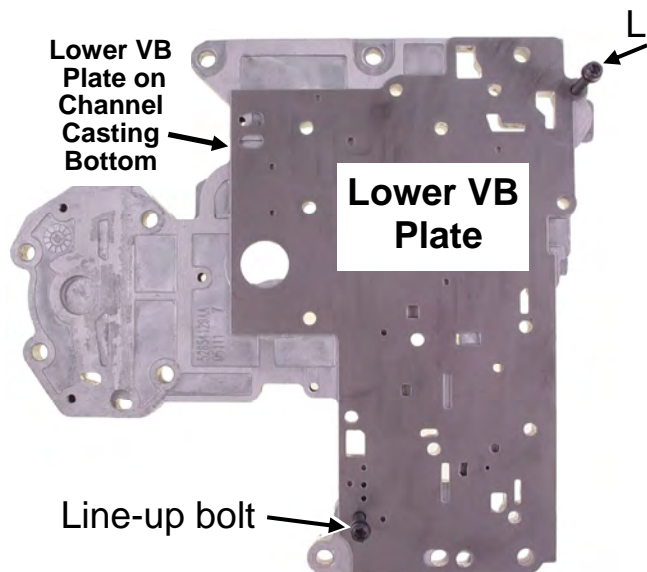


**1. RE Models only:**

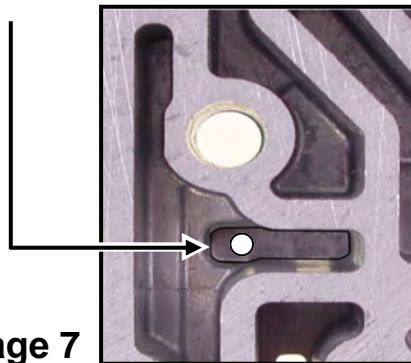
Install new spring here.  
**White** 12 Valve Engine  
**Orange** 24 Valve Engine  
**Orange** Gas Engine



**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 .103 hole through lower plate as shown.



**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

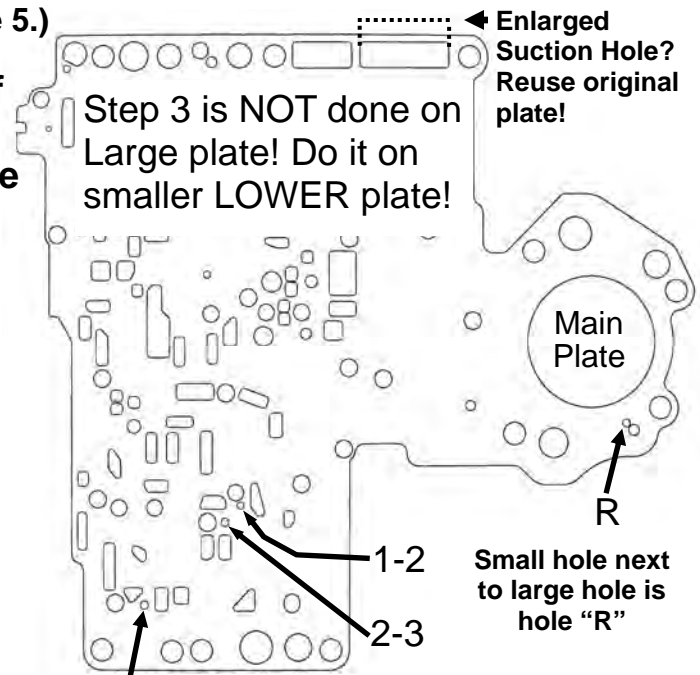
2-3 holes .125 to .135

Bigger hole = Firmer

For Snow Plow ONLY:

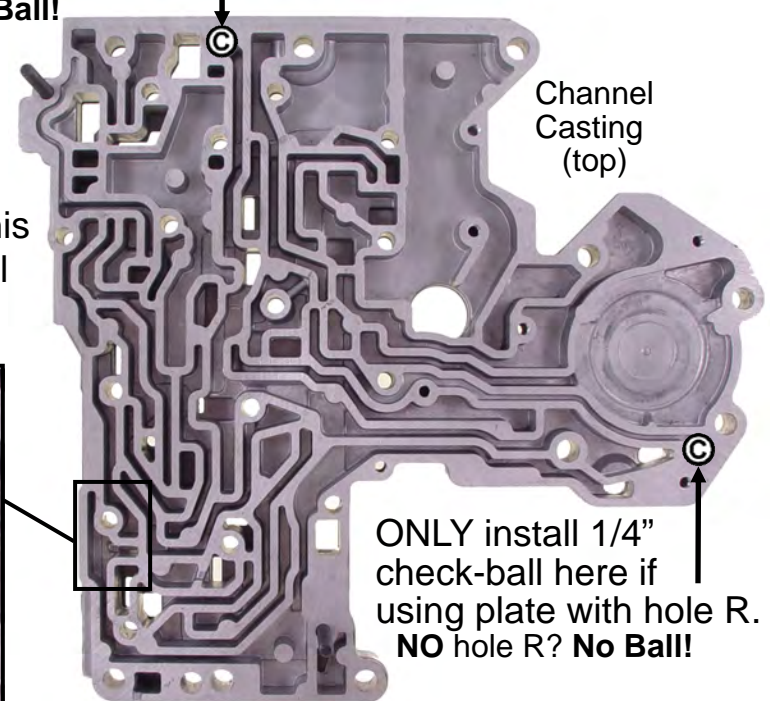
Make hole R .093 and install ball.

**NO hole R? No Ball!**



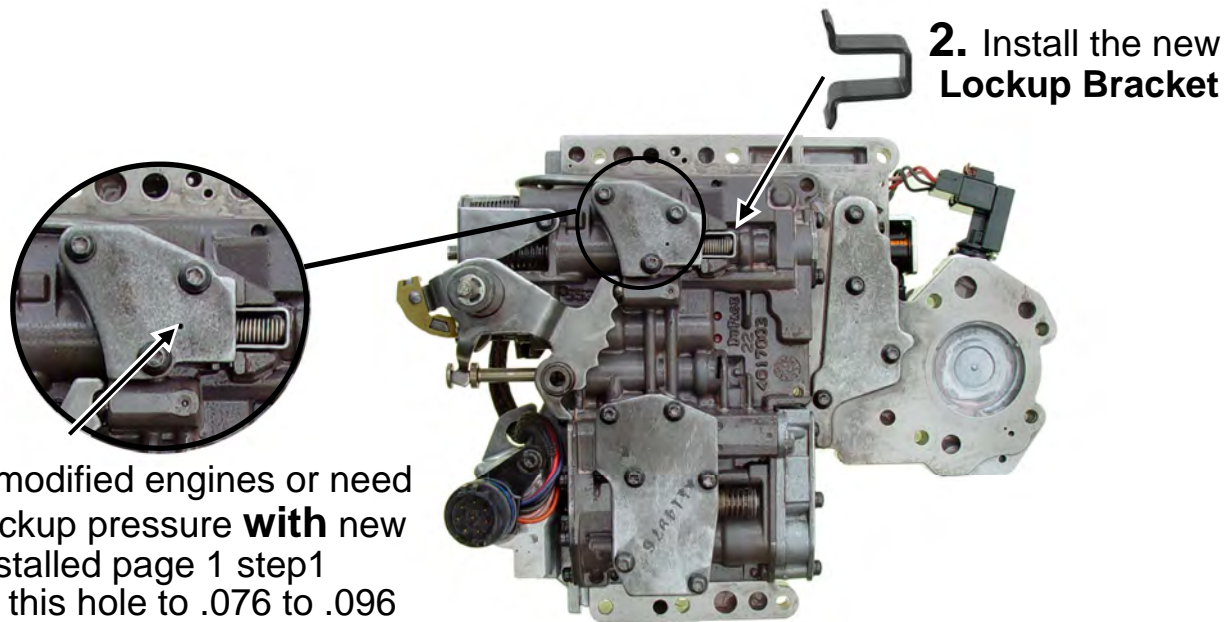
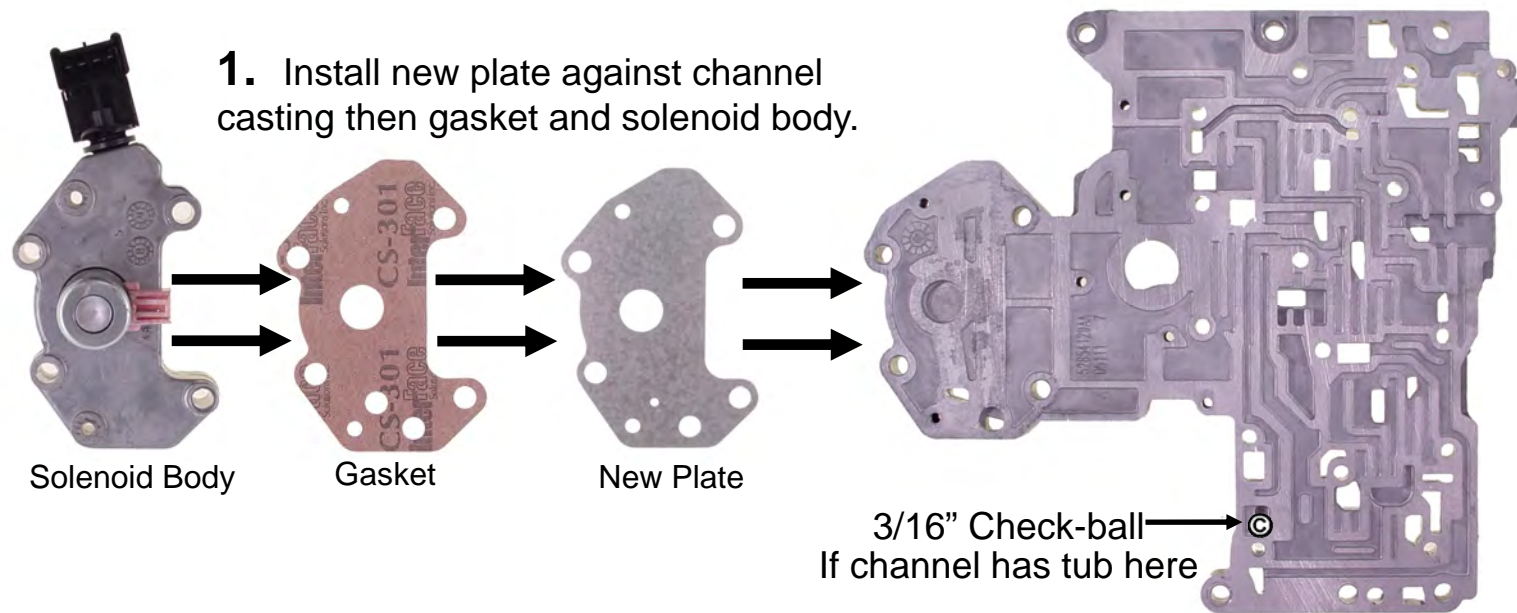
2-3

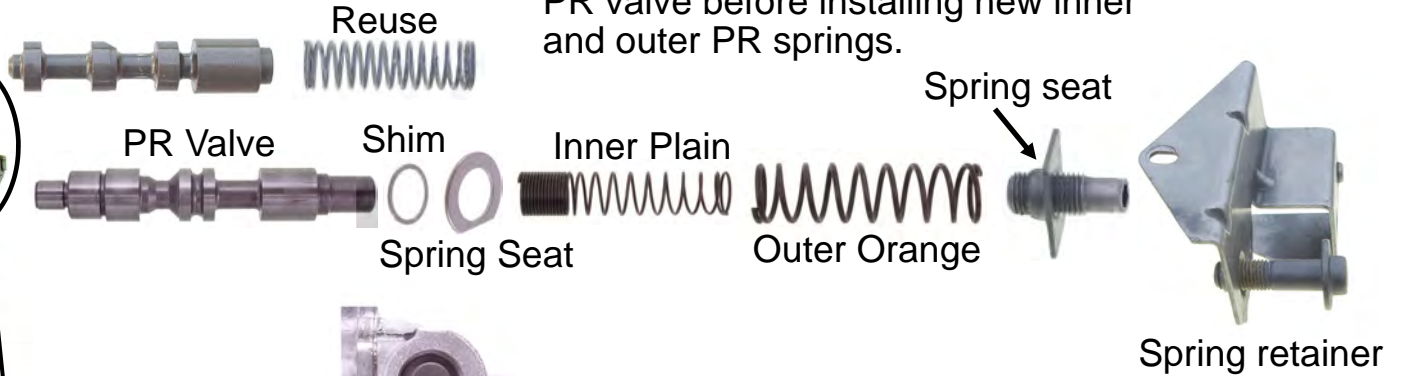
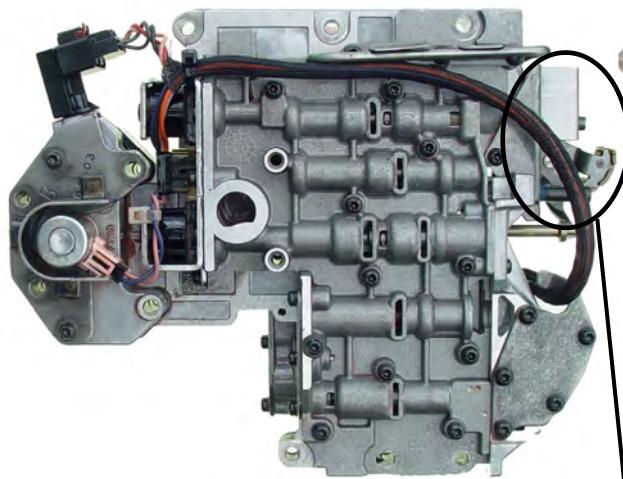
1/4" Check-ball



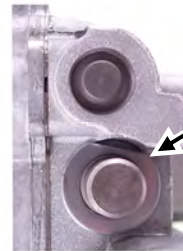


## RH Models without Solenoid Body, Skip Step 1.

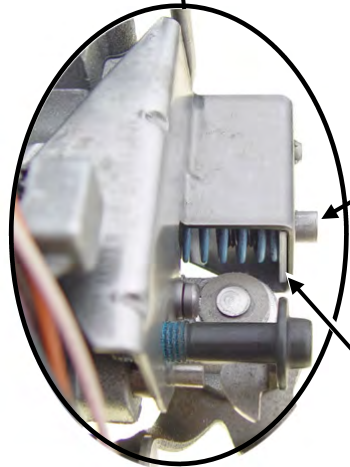




**1.** Install New shim and spring seat on PR valve before installing new inner and outer PR springs.



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.