

ADVANCE ADAPTERS INC.

P.O. Box 247, 4320 Aerotech Center Way

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P/N: 50-3204

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GM 2WD TH400 AUTOMATIC TO FORD NP205 TRANSFER CASE

KIT CONSISTS OF:

No.	Qty	Part No.	Description
1.	1	51-3204	ADAPTER HOUSING (#711164 Modified)
2.	1	716165	1-15/16 PLUG
3.	1	716510	GM TH400 GASKET
4.	1	716517	TRANSFER CASE GASKET
5.	6	723701	HEX NUTS 3/8"-16
6.	6	723704	3/8" LOCK WASHERS
7.	6	723711	STUD BOLTS 3/8"-16 X 2" LONG
8.	*1	52-9600	GEAR
9.	*1	52-9602	INPUT SHAFT
10.	*1	716315	SEALED BEARING
11.	*1	716467	SNAP RING
12.	*1	340407	SNAP RING

* These items are to be assembled at Advance Adapters

NOTE:

This adapter kit is for a stock 2WD TH400 output shaft being adapted to a Ford NP205 transfer case. The output shaft of the TH400 has a 32 tooth spline so we are changing the input gear of the transfer case to the Advance Adapter Part No. 716038. This new gear is directly interchangeable with the original Ford gear that only has 31 tooth internal spline. The bearing and seal of the original Ford application will remain the same. You should make sure that the seal in your transfer case matches the new input gear seal area. The adapter housing has been modified for clearance of the transfer case shift controls. You will need to fabricate a new transfer case pivot support for the handle of the transfer case. Most installations will require drive line modifications. The overall assembled length of the adapter and TH400 will be 28-1/2".

SPECIAL NOTE: _____ The components packaged in this kit have been assembled and machined for specific type of conversions. Modifications to any of the components will void any possible warranty or return privileges. If you do not fully understand modifications or changes that will be required to complete your conversion, we strongly recommend that you contact our sales department for more information. This instruction sheet is only to be used for the assembly of Advance Adapter components. We recommend that a service manual pertaining to your vehicle be obtained for specific torque values, wiring diagrams and other related equipment. These manuals are normally available at automotive dealerships and parts stores.

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GM 4L80E AUTOMATIC

The GM TH400 has a case length of 24-3/4", 13 bolts for holding the oil pan in position and is available in 3 different engine to transmission bolt patterns. Make sure you have selected the proper TH400 for your particular engine. The rear side of the transmission case will have a hex shaped bolt pattern that uses 6 bolts. There are several various lengths

of output shafts that the transmission has been equipped with and you will need the standard 2WD output shaft that protrudes 4-1/2" beyond the main case. The speedometer gear is normally located in the tailhousing, but when adapting it to the transfer case the location will change to the backside of the transfer case. The rear transmission support will now be located on the new adapter housing or, in some cases, on the transfer case.

This adapter kit includes a new input gear for the NP205 transfer case. This gear has a 32T internal spline and uses the stock Ford bearing. This gear is a stock GM item that was used on 1-ton vehicles only. Be sure to inspect the seal area provided in the adapter housing to make sure that it has the proper contact on the new sleeve and gear supplied.

When installing the new transfer case adapter, make sure that the new input gear and the output shaft do not bottom out. We have found on occasion that a transmission output shaft may be slightly longer than we have allowed for and when coupling into our new spud shaft, we find a small amount of interference. The adapter housing and spud shaft must be assembled to the back of the transmission without interference. **DO NOT FORCE THE NEW TAILHOUSING ONTO THE TRANSMISSION.** If assistance is needed, please feel free to call the number listed above.

All installations will require the use of a transmission cooler. The cooler can be either installed in the radiator or a remote location is acceptable. The transmission shift control can either be a Hurst floor mounted type shifter or sometimes the existing column shift can be modified on certain applications.

On the side of the TH400 case, you will find a 1-15/16" hole that must be plugged with the soft plug provided in the kit. We recommend that you use a good sealer when installing the soft plug in order to prevent any possible leakage.

The adapter plate bolts directly to the back of the TH400 transmission using 6 stud bolts, nuts and lock washers. The vacuum modulator line will need to be shortened and re-routed to the right front side of the transmission. The original cooler lines and fitting will line up with the TH400 transmission. The original flexplate and converter can be retained. The transmission shift linkage can also be retained. The transmission dipstick must be from the TH400 application.

The 4WD linkage mounting bracket will need to be relocated further forward to allow for the added length of the new transmission. The TH400 kickdown operates off an electric signal. You will be required to purchase a late model gas pedal bracket, GM No. 1242101 and switch, GM No. 39772676.

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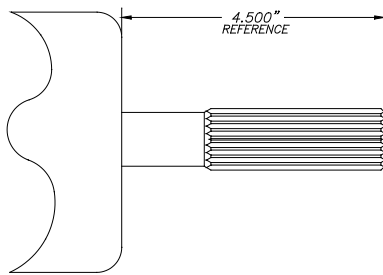
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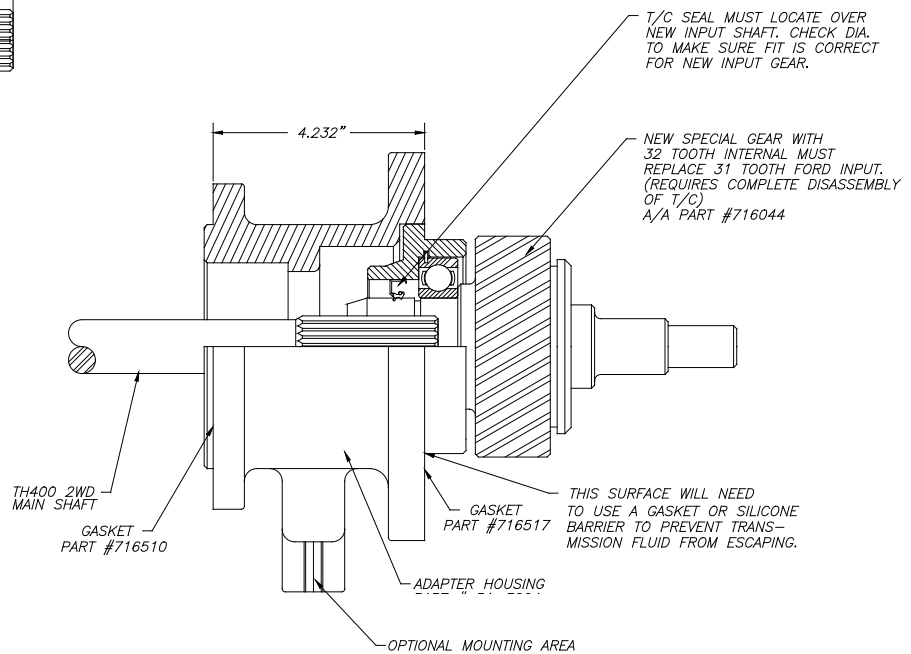
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2WD OUTPUT SHAFT



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