

ADVANCE ADAPTERS INC.

P.O. Box 247, 4320 Aerotech Center Way
Paso Robles, CA 93447

Telephone: (800) 350-2223 Fax: (805) 238-4201

P/N: 50-6404

Old Part No: 711064

PAGE 1 OF 3

Page Rev. Date: 07-20-05

GM 2WD 32T TH400 AUTOMATIC TO JEEP DANA 300 TRANSFER CASE

KIT CONSISTS OF:

<u>No.</u>	<u>Qty</u>	<u>Part No.</u>	<u>Description</u>
1.	1	51-6400	ADAPTER HOUSING (Ref: 711164)
2.	1	52-0208	NEW DANA 300 32T INPUT SHAFT
3.	1	716308	SHIELEDBEARING
4.	1	716510	GASKET (GM #862-4709)
5.	1	716517	GASKET
6.	1	716749	SEAL (CR #19778)
7.	1	723701	HEXNUT 3/8"-16
8.	12	723704	3/8" LOCKWASHERS
9.	1	723711	STUD BOLT 3/8"-16x2" LG
10.	6	723722	H.H.C.S. 3/8"-16x1-1/4" LG
11.	5	723723	H.H.C.S. 3/8"-16x1-1/2" LG
12.	1	JP001	JEEP INSTRUCTION MANUAL



GM TURBO 400 3 SPEED 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 AMC TH400 case when used with the Chevy engine will require adapter Kit No. 716133. 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 these transmissions have been equipped with. This kit requires the short 2WD 32T version that protrudes 4-1/2" beyond the back of the main case. The stock output shaft will need to be shortened to a length of 3-3/4" as per the illustration. Make sure that the output shaft and the new input gear do not bottom out. **FAILURE TO ACHIEVE THE PROPER CUT OFF LENGTH COULD RESULT IN PRE-LOADING THE TRANSMISSION SHAFT CAUSING SEVERE TRANSMISSION PROBLEMS.** 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.

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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When assembling the adapter housing to the transmission case, we have provided you with a new gasket to prevent fluid leakage. This gasket is a stock GM item that is used on all TH400 installations. The seal in the Dana 300 bearing retainer will prevent fluid from mixing between the transmission and transfer case. A new seal has been provided and should be installed with the open side towards the automatic transmission. We have also included a new sealed bearing that will replace the original Dana 300 bearing. This new sealed bearing will give added protection.

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.

The adapter thickness is 4-3/8" and will normally require the transfer case to be relocated on most conversions. Kit No. 50-6402 uses a thinner adapter plate that is only 1-1/4" thick and can be installed in Jeep Wranglers only. The kit is available in both the 21 & 23 spline TH400 output shaft.

INSTALLATION:

1. Starting at the Dana 300 transfer case, remove the 6 socket head bolts from the aluminum index hub on the front side the transfer case.
2. Using the two slots on the side of this retainer, you will need to pry the retainer out of the transfer case. This retainer assembly does pilot into the rear output shaft of this transfer case, if the retainer assembly seems tight to remove try spinning the rear output shaft.
3. Once the retainer is removed you will need a pair of snap ring pliers to remove the snap ring that retains the drive gear to the input shaft. Remove the snap ring and the drive gear from the input shaft. The aluminum retainer should now have the bearing, input shaft, seal and a snap ring holding the bearing into the retainer. This snap ring must also be removed to allow the bearing and input shaft to be pressed out of the index housing.
4. The seal will also require to be pressed out of the index retainer. The retainer should now be empty.
5. Install the new bearing onto the new input shaft, install both components into the stock retainer and install the stock snap ring.
6. Install the input drive gear onto the input shaft and retain it with the stock snap ring. Make sure the gear is installed so that the cogged side of the gear is facing away from the bearing.
7. Install the new seal provided in the kit. The open side towards the transmission.
8. Apply Loctite 515 or equivalent sealant to the retainer surface and install into the Dana 300 transfer case. Make sure the pocket bearing is installed in the Dana 300 output shaft.
9. Bolt retainer to transfer case using the stock bolts. Torque to 10 ft./lbs.
10. This kit fits the TH400 2WD transmission only. The stock 2WD output shaft must be shortened to a stickout of 3.750" from the rear of the transmission.
11. Install the adapter to the TH400 using the 3/8"-16 x 1 1/4" bolts and lock washers, make sure you install the gasket between the adapter and the transmission.
12. The transfer case should be test fitted to the adapter and to check shaft engagement. Make sure the transfer case fits flush up to the adapter surface. If not check for burrs on the shafts and or output shaft cut off length. Never pull the transfer case to the adapter using the bolts to draw these components together. The adapter also provides an option of two rotation angles for the transfer case (stock rotation is 35 degrees).

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PAGE 3 OF 3

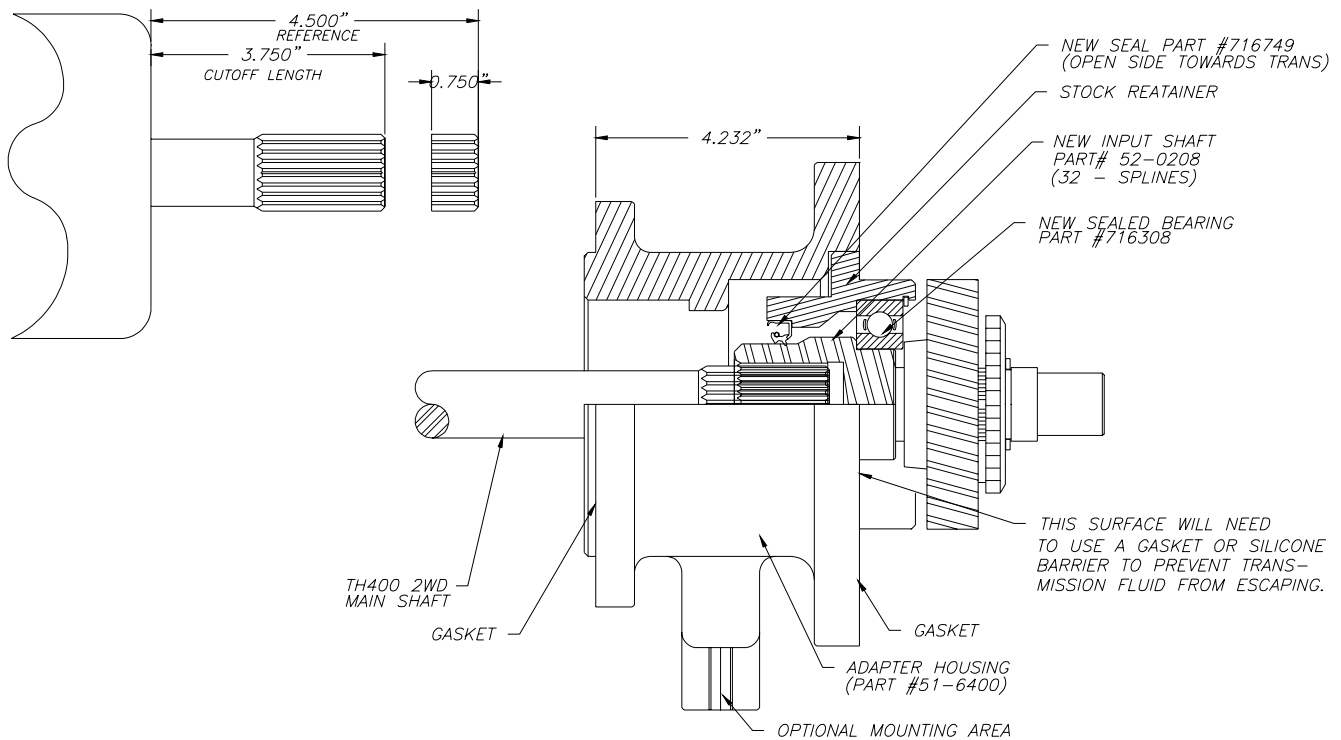
Page Rev. Date: 02-25-02

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13. Install a silicone sealant on both sides of the gasket and install the transfer case to the adapter. Note the gasket will only fit onto the transfer case in one rotation.
14. Install the nuts onto the new stud bolts and locktite to secure.

If for any reason the two bolt surfaces do not slide together, **DO NOT FORCE OR PULL TOGETHER** with the bolts. If you have any questions, please call 1-800-350-2223, for technical assistance.

TRANSMISSION LENGTH = 24.250"



NOTE: This kit will normally require driveline modification.

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