



# SILVER SPORT Transmissions

## GENERAL INSTALLATION (MANUAL TRANS)

### TR-4050 5-SPEED MANUAL TO MANUAL TRANSMISSION CONVERSION INSTALLATION MANUAL

FOLLOW FACTORY SERVICE MANUAL (FSM) RECOMMENDED SAFETY PRECAUTIONS. TRANSMISSION REMOVAL AND INSTALLATION IS A LABOR INTENSIVE JOB, WHICH CAN RESULT IN SERIOUS INJURY OR DEATH IF CAUTION IS NOT TAKEN. PLEASE BE CAREFUL PERFORMING THIS JOB, OR HAVE A PROFESSIONAL PERFORM THE JOB FOR YOU. REFER TO FACTORY SERVICE MANUAL FOR ADDITIONAL DETAILS OF THE PROCEDURES BELOW, AS REQUIRED.

FOR BOLT TORQUE SPECIFICATIONS, REFER TO YOUR FACTORY SERVICE MANUAL.

*The material herein is the intellectual property of Silver Sport Transmissions ("SST") and is to be used by SST customers or their authorized installers for the sole purpose of installing SST-supplied transmissions and related parts. Under no circumstances shall the manual or any portion thereof be copied, duplicated, distributed or incorporated in any written or printed document without the express written approval of Silver Sport Transmissions.*

Before you start:

Test drive the vehicle, if possible, before you begin. Pay attention to noise and vibration and record your observations. At the end of the installation, perform another test drive to compare.

In addition to this manual, you should have received instructions for checking your bellhousing runout. **The bellhousing runout must be checked (and corrected if necessary) for Tremec's warranty coverage.**

You should also verify the parts you received. Compare the received items to the detailed invoice provided in your shipment.

## **PLEASE READ ALL INSTRUCTIONS BEFORE INSTALLATION**

In addition to these instructions, you should receive the following instructions based on your order, **if applicable:**

1. All kits – MAA-00101 Inspection and Correction of Bellhousing to Crankshaft Runout
2. Hydraulic Kit Instructions

Your invoice lists the individual hardware packs and where they are used.

**NOTE:** Transmission **must** be test shifted before installation. Due to jostling during shipping, some transmissions will not shift properly when removed from the box. Please make sure that the gear selector will move into each of the (6) possible positions while rotating the input shaft and checking for output shaft rotation. If the input shaft will not turn, slide the clutch disc over the input shaft and jerk the clutch disc left and right to break it free. If this does not correct the issue, call Silver Sport Transmissions' Technical Support at **888-609-0094** for assistance.

**THIS CANNOT BE CORRECTED WITH THE TRANSMISSION INSTALLED IN THE CAR!**  
**TEST SHIFT FIRST!**

### **A. REMOVE EXISTING EQUIPMENT**

1. Disconnect negative (-) battery cable.
2. Remove shifter knob and boot. Place shifter in neutral.
3. Remove console, if equipped.
4. Raise car securely on lift or jack stands. 6 ton stands are taller and will give you more working room under the car.
5. Make a reference angle measurement on the frame of the vehicle, marking the spot the measurement was taken. Measure the transmission angle for use in determining the correct elevation and driveline angle of the new transmission. The most reliable place to get the measurement is from the machined vertical face that the rear seal goes into at the back of the tailhousing. Record this measurement for future reference. Also record the front and rear driveshaft angles as well as the pinion angles for both the front and rear.
6. Remove clutch linkage at torque arm to clutch fork.
7. Remove bellhousing dust cover and starter.
8. Remove driveshaft at rear differential and remove from transfer case.
9. Remove driveshaft at front differential and remove from transfer case.
10. Remove shift lever and shifter assembly components from both the transmission and transfer case.
11. Remove breather assembly and distributor cap from engine. Big block vehicles may need the fan shroud loosened as fan blades may contact it as the engine is lowered in the back during transmission removal.

12. Disconnect throttle linkage.
13. Remove speedometer cable.
14. Disconnect reverse lamp wiring.
15. Secure rear of engine with hydraulic jack.
16. Remove exhaust, as required, for working clearance and to permit the engine to drop.
17. Unbolt crossmember and remove crossmember.
18. Secure transmission and transfer case (jack recommended) and unbolt from bellhousing, then move rearward and remove from vehicle.
19. Unbolt and separate transfer case from transmission.
20. Remove bellhousing, clutch pressure plate and clutch disc.
21. Remove clutch fork and release bearing from bellhousing. Inspect release bearing, fork, and pivot ball stud for wear. Contact Silver Sport Transmissions or your local parts supplier if replacements are needed.
22. Inspect flywheel ring gear teeth (no cracks, chips, wear), and friction surface (no cracks). Silver Sport Transmissions strongly suggests removing flywheel and having it resurfaced, then dynamically balanced at a reputable automotive machine shop **unless** the engine was externally balanced with the flywheel installed.
23. Remove pilot bushing using removal tool (not supplied).
24. Clean mounting surface of engine and dowel pins.

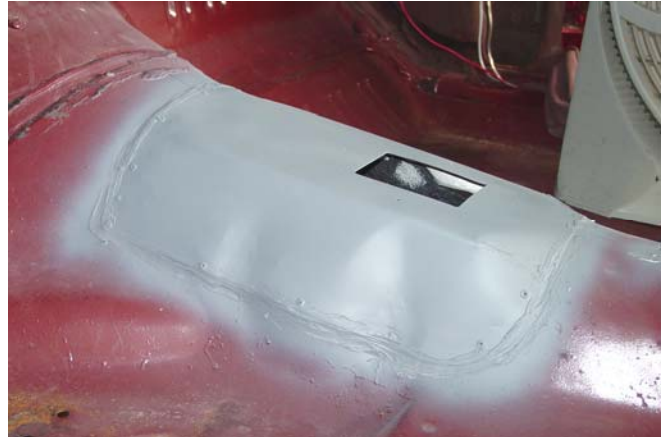
## B. VEHICLE PREPARATION

1. If you are converting from an automatic transmission or from a column-shift vehicle, first you must cut the shifter hole. To locate the shifter hole, use the following procedure:
  - (a) Measure the transmission from the bellhousing mounting face to the center of the shift lever, including offset from the centerline (if any).
  - (b) Temporarily install the bellhousing to the engine (clutch unit not required) and raise the engine to approximate final elevation.
  - (c) Transfer the shifter location to the underside of the transmission tunnel by measuring from the transmission mounting face of the bellhousing rearward down the underside of the transmission tunnel, and mark the shift lever location, including any offset.
  - (d) Measure the rectangular section of the shift tower, and transfer this to the underside of the transmission tunnel. Drill pilot holes and cut out the required area.

**NOTE: Confirm that nothing is in the way inside or under the vehicle during cutting.**
2. Some vehicles will require additional tunnel modification or a body lift in order to get the transmission high enough in the tunnel. If modification is required, the top of the tunnel will typically need to be squared off somewhat and possibly raised higher. To determine if modification is needed, temporarily install the bellhousing (clutch unit not required) and transmission on to the engine and begin to raise into place. When the transmission contacts the underside of the tunnel, measure the transmission angle as you did in Step A-5 above. You want the new transmission to be very close to the same angle as the original one to preserve the driveline geometry.
3. If the new transmission (jacked all the way up) is higher than your original, lower the new transmission to the same angle as your old transmission, and check for clearance around the transmission case. You should have at least 1/4 inch of clearance everywhere. If your new transmission is not high enough, then some modification is necessary. You may be able to create enough clearance by dimpling the tunnel in the spots that the transmission touches. If

you need to raise the transmission significantly, then it may be necessary to cut out a portion of the tunnel and raise it to create clearance.

4. Using a paint marker, mark the tunnel around the area of the transmission needing removal and remove the material. Raise the transmission into place and measure again from the center of the output shaft straight up to the top center of the tunnel. Several attempts may be required to fully determine the area to be removed and permit the transmission to sit at the proper height.
5. Once the opening is made, a cardboard (or other stiff material) template can be made to cover and overlap the area. The template will be used to cut a repair patch from 20 gauge sheet metal to cover the opening. Additional slits in the sheet metal at the appropriate locations will assist in folding and shaping the sheet metal. Remove the transmission and bell housing.
6. Install the sheet metal, seam seal with LORD® Fuser 803DTM Metal Sealer or equivalent and paint. Below are photos of a typical tunnel modification with new sheet metal installed:



7. If your vehicle uses a crossmember to support the transmission, you will now need to modify the crossmember and/or its mounting points on the frame. In some vehicles, you will only need to slide the crossmember backwards or forwards on the frame rails and drill new holes in the frame. Some vehicles may require that you modify the crossmember perch, and others will require that you section the crossmember and move the center portion in one or more directions.
8. Temporarily reinstall the transmission in the car (no clutch assembly necessary). Install the isolator mount onto the transmission, and test-fit the crossmember to determine what modifications are necessary. Return to these instructions when the crossmember has been modified for proper fitment with the new transmission at the correct angle.

## C. TRANSMISSION INSTALLATION

1. Install new pilot bearing assembly using a socket of similar diameter to the bearing and a hard rubber mallet. Make sure the bearing is installed facing the right direction (see photo below). Gently tap bearing fully into crankshaft until bearing face is flush with crankshaft face.  
**NOTE:** The pilot bearing holes in some crankshafts are not sized consistently. The pilot bearing is designed to be a slight press fit in the bore. Your pilot bearing OD should be between one-half of a thousandth and two thousandths of an inch (0.0005" - 0.002") larger than the ID of the hole in your crankshaft. If outside of this range, a different pilot bearing is required, or your crankshaft or pilot bearing may be modified to fit. Contact your local parts store or machine shop for a suitable replacement or to modify your existing parts.



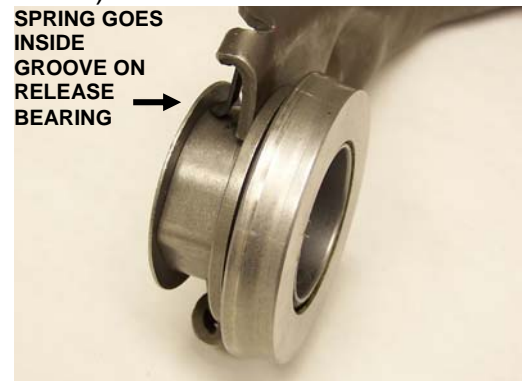
CHEVROLET PILOT BRG.      PONTIAC PILOT BRG.  
(TRANSMISSION SIDE SHOWN)

2. Check bellhousing face parallelism using height gauge (not supplied; your local machine shop can inspect this). Faces should be within 0.002" parallel. If out of specification, bellhousing should be surfaced (milling) – SST or your local machine shop can perform this service. If a bellhousing problem exists (i.e. cracks, excessive runout, worn/damaged bore, etc.) several styles of new bellhousings are available from SST.
3. Install the bellhousing and inspect for proper alignment to crankshaft using dial indicator or test indicator (SST can provide these tools at extra cost). See MAA-00101 provided with your literature package. Make sure to send your runout data to Silver Sport Transmissions in order for your warranty to be valid. Mark offset dowel pins position, if used, using paint marker and carefully remove bellhousing.
4. Use the provided alignment tool to center the clutch disk when applying torque to Center the clutch disk when applying torque to the pressure plate bolts. Install the bolts with medium strength thread locking compound per clutch installation instruction sheet and tighten in a star pattern, one turn at a time to prevent distorting the pressure plate fingers, until the cover is snug against the flywheel. Torque the bolts to 35 lb.-ft. in a star pattern.

**NOTE:** When installing the pressure plate and clutch disk onto the flywheel, NEVER use power or air tools. Using power or air tools will cause the flanges of the pressure plate to distort. This will in turn cause uneven pressure plate finger heights, which will lead to inconsistent or unsuccessful clutch releases. See MAA-05000 clutch installation instructions for more details.

**NOTE:** If using a diaphragm-style pressure plate, it will be necessary to remove the large over-center spring from the clutch pedal. The over-center spring can hold the clutch disengaged or cause unusual fluctuations at the clutch engagement and release points. If using a three-finger style pressure plate, the over-center spring will be retained.

5. Lower rear of engine (required for new transmission installation).
6. With the bellhousing still removed from the engine, install clutch fork and release bearing in the bellhousing if using mechanical clutch linkage. *The tips of the clutch fork and the spring fingers on the rear side of the clutch fork **both fit inside** the same groove on the release bearing.* If you purchased the SST hydraulic system with your transmission, the hydraulic release bearing will already be installed and you will not be using a clutch fork.



7. Install bellhousing to engine, while making sure that there are no hoses, cables, or wires caught between the bellhousing and engine block. Torque the fasteners to the specification found in the Factory Service Manual.

**IMPORTANT !!! Refer to MAA-00101 Inspection and Correction of Bellhousing to Crankshaft Runout**

It is an absolute **requirement** that **runout** is **checked** and **corrected** **PRIOR** to installing the transmission. The runout specification for all of Silver Sport's kits is **0.005" (5 thousandths of an inch) MAXIMUM**. You **MUST** document the results **PRIOR** to installation of transmission and keep these measurements recorded in a safe place for your transmission warranty. Silver Sport's Customer Service will need this information if a warranty issue arises.

8. Install transmission, using caution when inserting the input shaft into the clutch disc and pilot bearing. Do not allow weight of transmission to rest on assembly until fully engaged (doing so can misalign disc or damage pilot bearing). **DO NOT** use the transmission to bellhousing bolts to draw the transmission up to the bellhousing!

NOTE: If the transmission stops approximately 1/2 - 3/4 inch away from seating fully against the bellhousing, install and **finger-tighten** bellhousing to transmission bolts (HWG-PACK A). Connect clutch linkage and depress pedal lightly while pushing transmission forward to facilitate alignment of clutch disk to input shaft and pilot bearing. **DO NOT** force the transmission into engagement – damage to the pilot bearing may result. Tighten bellhousing to engine bolts once the transmission is seated against the bellhousing.

9. Once the transmission is fully seated by hand against the bellhousing, fasten with 1/2" x 1 1/2" bolts and washers provided (HWA-PACK W) and torque to 50 lb.-ft.

**WARNING: THE FOLLOWING CAN CAUSE THE EARS OF THE TRANSMISSION CASE TO BREAK AND IS NOT COVERED UNDER WARRANTY (SEE PHOTO):**

- a) **DRAWING THE TRANSMISSION UP TO THE BELLHOUSING BY THE BOLTS.**
- b) **NOT TORQUING THE TRANSMISSION-TO-BELLHOUSING BOLTS TO 50 lb.-ft.**
- c) **NOT HAVING THE TRANSMISSION FULLY SEATED AGAINST THE BELLHOUSING WHEN TORQUING THE TRANSMISSION-TO-BELLHOUSING BOLTS.**



- 10. Install transfer case to the rear of the transmission. Torque the fasteners to the specification found in the Factory Service Manual.
- 11. Raise up engine/transmission until transmission contacts the top of the tunnel.
- 12. Attach rubber isolator mount to transmission.
- 13. Install new crossmember using your original hardware to attach to the frame. Lower transmission fully onto crossmember, and attach to mount with hardware pack HWG-PACK B. Confirm no interference to car body or noise will occur as the driveline moves under load. Confirm transmission is centered in floor tunnel.
- 14. Install front and rear driveshafts. Then position the rear U-joint in the differential U-joint saddles. It may be helpful to be able to turn the rear wheels. Install rear straps and torque to factory specs. 17 lb.-ft. for 1310/1330 U-bolts; 24 lb.-ft. for 1350 U-bolts. (excessive torque can distort bearing cap leading to premature failure)
- 15. Double check your assembly.
- 16. Reinstall bellhousing inspection cover and starter.
- 17. Connect clutch linkage - do not preload mechanical release bearing. Adjust linkage as required, following the method laid out in your Factory Service Manual. If using a SST hydraulic system (available separately), follow instructions provided.
- 18. The reverse light switch is located on the top side of the main case and is a white-bodied switch. The switch is a normally open, non-directional switch that will complete the lighting circuit when the transmission is in reverse. SST has provided a two-wire harness with your kit that will attach to the 5-speed reverse light switch. It can be spliced into your car's wiring harness in place of your original switch.
- 19. Tighten exhaust.
- 20. Bolt on shifter handle with 3/8"-24 x 1" bolts and washers provided (HWA-PACK L). Use medium strength threadlock compound. Torque to 25 lb.-ft. Confirm shifter motion through all gears.
- 21. Install shifter boot and retainer ring, and/or console if so equipped.
- 22. Connect throttle linkage to carburetor.
- 23. Install distributor cap and breather.
- 24. Reconnect the negative (-) battery cable.

## **FINAL INSTALLATION STEPS**

1. If you did not fill the transmission with fluid before installation, remove the fill plug on the passenger's side of the transmission and fill with 2 quarts, 20 ounces of transmission fluid, or until fluid runs out of the fill hole with the vehicle level. Reinstall the fill plug after adding fluid.
2. Start engine and allow engine to idle for a few minutes.
3. Check for leaks while warming up.
4. Slowly rev engine in neutral and listen for any unusual sounds or vibration.
5. Shift through all forward gears with the clutch disengaged (clutch pedal depressed).
6. Test drive at low speeds and low RPM.
7. Gradually increase engine RPM and vehicle speed.
8. Compare this test drive to the pre-installation test drive.
9. Drive conservatively for the first 500-1000 miles for transmission break-in.
10. If you experience vibration at highway speeds, verify that there is no body contact with the new transmission. If there is no contact, it may be necessary to adjust your driveline angle. Much has been written about driveline angles and how to determine them, and there is a lot of great information available online from multiple websites. If you need further help with your driveline angle, call Silver Sport Transmissions' Customer Service at 865-609-8187.



## **SPECIFICATIONS AND MAINTENANCE**

**TREMEC HighPerformance ManualTransmission Fluid** is endorsed by Tremec for use in all Tremec brand aftermarket performance transmissions. **GM Synchronesh (part #88900333; formerly part #12345349) or Pennzoil (part #3501), DEXRON/MERCON ATF (non-synthetic), and Mobil 1 ATF are the ONLY other fluids approved by Tremec.**

**The use of ANY other fluid will void your warranty.** Silver Sport Transmissions recommends that the fluid be replaced after the first 500-1000 miles of normal driving, and then every 30,000 miles thereafter. It is acceptable to use the less-expensive DEXRON/MERCON fluid for the break-in period and then replace it with the Tremec HP MTF or GM Synchronesh.

### **Warranty**

See Silver Sport Transmissions' warranty policy for specific information on the TR-4050 transmission warranty.

FLUID CAPACITY: 3.7 QUARTS, (3.5 liters)

DO NOT EXCEED MAXIMUM  
INPUT TORQUE:

- TR-4050: 425 lb.-ft. in 4<sup>th</sup> gear

GEAR RATIOS:

- 1<sup>ST</sup> 6.16
- 2<sup>ND</sup> 3.11
- 3<sup>RD</sup> 1.71
- 4<sup>TH</sup> 1.00
- 5<sup>TH</sup> 0.76
- REV. 6.03

### **CONTACT INFORMATION**

SILVER SPORT TRANSMISSIONS  
2250 STOCK CREEK BOULEVARD  
ROCKFORD, TENNESSEE 37853-3043

Phone: (865) 609-8187  
Toll Free: (888) 609-0094  
Fax: (865) 609-8287

[WWW.SHIFTSST.COM](http://WWW.SHIFTSST.COM)

*SILVER SPORT TRANSMISSIONS IS DEDICATED TO YOUR SATISFACTION AND ENJOYMENT OF THIS PRODUCT. PLEASE SEND US PICTURES OF YOUR CAR ALONG WITH A TESTIMONIAL OF HOW YOU RATE THIS PRODUCT. WE WILL BE POSTING MANY CUSTOMER FEEDBACK LETTERS AND PICTURES ON OUR WEBSITE AND BROCHURES.*

**ENJOY YOUR SILVER SPORT  
TRANSMISSION SYSTEM!**