

F404561 & F404581

TH400 FRONT PUMP – TH400 6 or 8 Bolt Pump – High Volume – Fits Turbo Spline Input Shafts

This Kit Includes:

- (1) Front Pump
- (1) Pump to Case Gasket
- (1) Pump to Case O-Ring
- (1) Stator Support Bushing
- (1) Conv. Charge Jet

Disclaimer: Included in the following documents are detailed instructions on how to install your new FTI High Volume Pump. Please keep in mind that racing is dangerous, and a product such as this one is crucial to a properly functioning racecar. Failure to properly install this product can lead to catastrophic failure. If you are unsure about any of the steps in this instruction sheet, please consult a professional immediately for assistance or contact FTI's tech support line at 386-736-5816.

Warranty: Each FTI TH400 High Volume Pump is covered by our standard 1-year warranty against any manufacturing defect. If you suspect there to be a warranty issue with your pump, please contact us immediately for trouble shooting and testing if necessary. Please note, any warranty claims that are submitted due to improper installation or operation are subject to denial of claims solely at the discretion of the manufacturer.

Note: Before installing your new TH400 High Volume Pump, please review the information below to choose the correct installation procedure for your new pump.

Which style Input shaft do you have?

With the variety of TH400 input shafts available, FTI has taken the time to design our TH400 Pumps into a kit to include everything you need to tailor your pump installation to fit your transmissions input shaft configuration perfectly. Please note that there are 2 distinct configurations for your new pump based on the input shaft you are using. If your input shaft has an OEM or stock style input shaft Figure 1, you will use *Option #1* for the proper installation instructions. If you have an aftermarket input shaft that has the front stator support bushing land removed Figure 2, you will use *Option #2* for the proper installation instructions.

Figure #1



Figure #2



Option #1 Instructions:

1. Before installing your new TH400 pump, you will need to install the front stator support bushing. Using the correctly sized bushing driver, Install the front stator bushing into the machined pocket at the front of the stator tube Figure 3.
2. Using the provided pump gasket and O-ring, install your new high-volume pump into the case with the 6 or 8 pump bolts. **Note: It is the installers' responsibility to maintain proper transmission in-clearance when installing the new pump.**

Option #2 Instructions:

Note: This configuration requires your torque converter to have bushing installed in the cover supporting the turbine and input shaft when installed. If you are unsure if your converter has the correct configuration, please contact your converter manufacturer to confirm.

1. Before installing your new TH400 pump, you will need to "jet" your pump. This restricts the feeding of oil into your converter, effectively reducing charge pressure which is commonly high when installing a high-volume pump that the front stator bushing has been removed on.
2. Unbolt the 2 halves of your TH400 front pump and locate pre-drilled & tapped hole Figure #4.
3. Install the supplied 0.110in jetted cap into the pump which will regulate charge pressure.
4. Re-align the 2 pump halves using an alignment tool, large hose clamp, or the transmission case and bolt the 2 pump halves back together at 18ft/lbs for the bolts.
5. Using the provided pump gasket and O-ring, install your new high-volume pump into the case with the 6 or 8 pump bolts. **Note: It is the installers' responsibility to maintain proper transmission in-clearance when installing the new pump.**

Figure #3



Figure #4

