



Mid-Shift Conversion Kit
For TR-3550

*Disassembly and Assembly
Instructions*

Bulletin No. LDMIDSHIFT
Part #2671127

December 2006



MID-SHIFT CONVERSION KIT FOR TR-3550 2671127

KIT CONTENT:

1	2605930	CONTROL TURRET ASSEMBLY
1	2605932	SHIFT LEVER SUB-ASSEMBLY
1	2605997	DUST COVER
4	2603968	BOLTS, CONTROL TURRET
1	12F000015	EXPANSION PLUG
1	2671126	EXTENSION COVER PLATE
1	2606154	OIL DEFLECTOR

DISASSEMBLY:

1. Remove for shift turret dust cover bolts. Ref to illustration S1001-A.
2. Remove dust cover. Straighten locking tabs holding shift lever pivot bolts. Remove two shift pivot bolts. Ref to S1002-A.
3. Remove shift lever assembly. Ref to S1003-A.
4. Remove six shift turret housing bolts. Remove shift turret. Ref to S1004-A.
5. Remove four shifting lug inspection cover bolts and star washers. Remove shifting lug inspection cover. Ref to S1005-A.
6. Remove roll pins from shifting lugs. Note - insert magnet into area under shifting lug to catch roll pin when pushed free. Ref to S1006-A.
7. Using a punch, remove roll pin securing the fifth and revers shifting lug to the fifth and reverse shifting rail. Ref to S1007-A.
8. Using a punch, remove the first and second shift lug roll pin. Remove first and second shifting lug. Ref to S1008-A.
9. Rotate shifting selector rail moving selector finger away from the third and fourth shifting lug. Using a punch, remove the third and fourth shifting lug roll pin. Remove the third and fourth shifting lug. Ref to S1009-A.

DISASSEMBLY - CONTINUED

10. Remove selector finger Allen screw. Slide selector finger off the end of shift selector rail and remove shift selector finger. Ref to S1030-A.
11. Remove shift lever socket Allen screw. Hold shift lever socket assembly and slide push shift selector rail out of back of extension housing assembly and remove the shift lever socket. Ref to S1031-A

NOTE: The expansion plug will pop out at the time the selector rail is being pushed back. Discard the expansion plug. A new one is included in the conversion kit.

12. Remove the shift lever socket assembly from the extension housing.

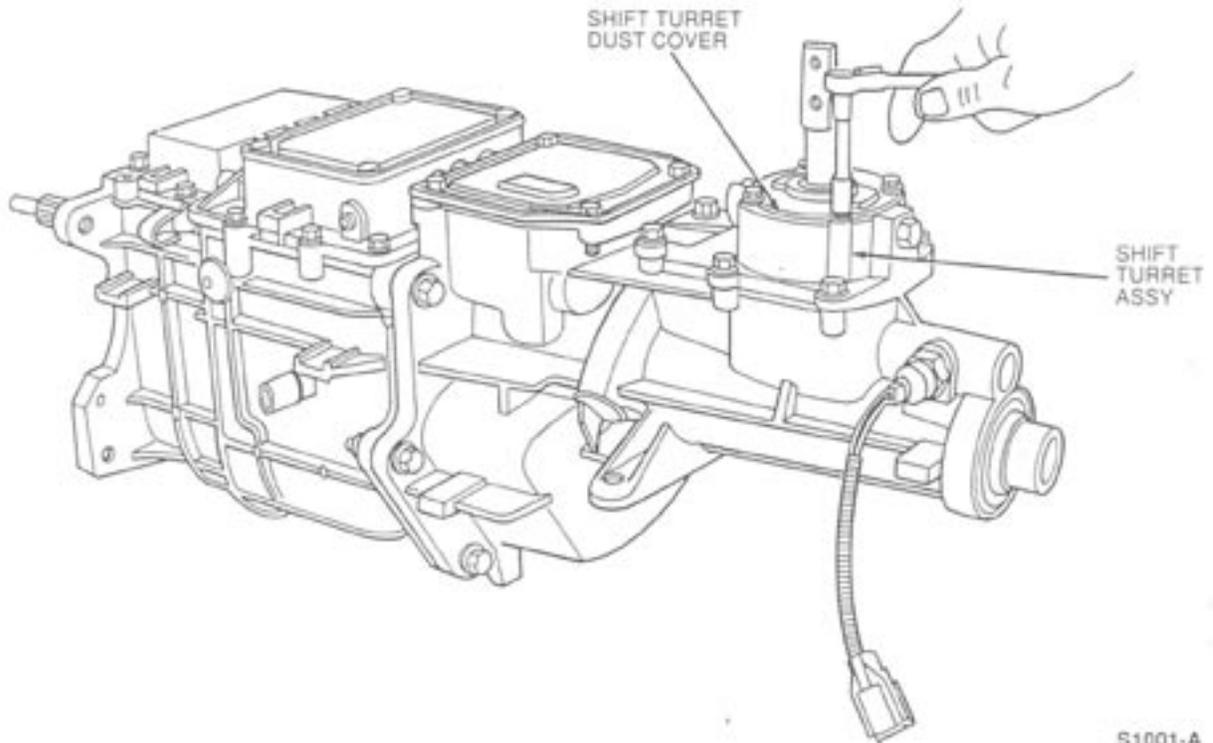
ASSEMBLY:

13. Install the expansion plug. Apply the RTV onto the expansion plug and drive it back into the extension housing.
14. Install turret cover on extension housing. Use RTV sealant and torque bolt to 18-22 ft-lb. ref S1004-A.
15. Install the third and fourth shifting lug and secure with roll pin. Make sure that the opening on shifting lug is up. Ref to S1009-A.
16. Install the first and second shifting lug and secure with roll pin. Ref to S1008-A.
17. Install the fifth and reverse shifting lug and secure with roll pin. Ref to S1007-A.
18. Install shift turret. Use RTV Sealant and torque bolts to 18-22 ft-lb. Install the shift lever assembly. Install the shift lever pivot bolts and locking tab torque bolt to 28-30 ft-lb. Install dust cover part # 2671126.

NOTE: The referenced drawings may be found in the TR-3550 Transmission installation and service manual. However, some have been modified specifically for this conversion.

DISASSEMBLY-TRANSMISSION

Remove four shift turret dust cover bolts.

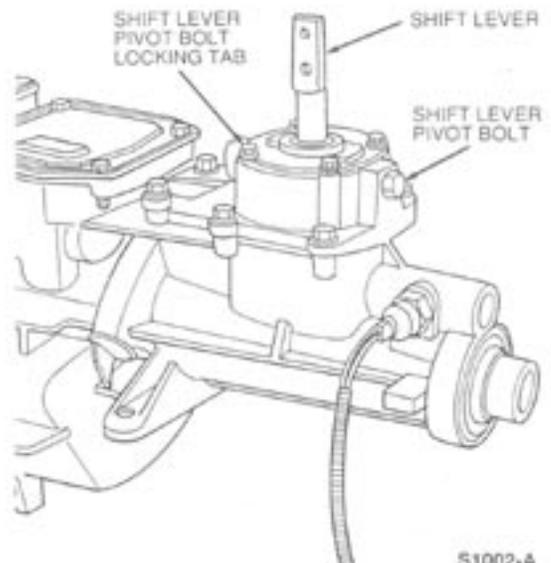


S1001-A

Remove dust cover.

Straighten locking tabs holding shift lever pivot bolts

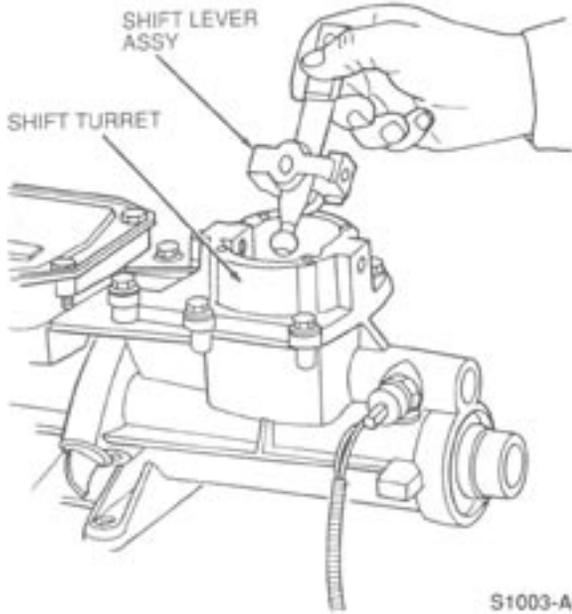
Remove two shift lever pivot bolts.



S1002-A

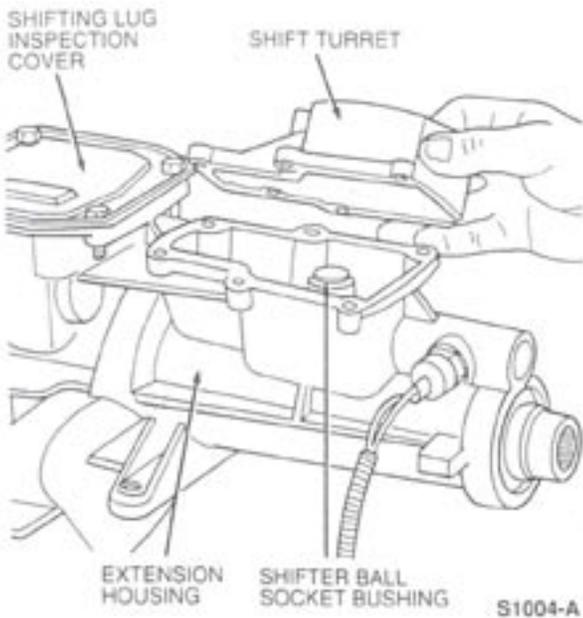
DISASSEMBLY-TRANSMISSION (CONTINUED)

Remove shift lever assembly.



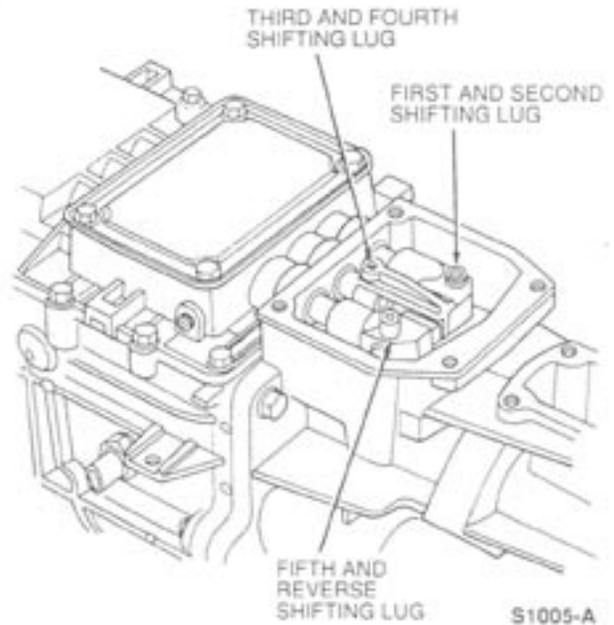
Remove six shift turret housing bolts.

Remove shift turret.

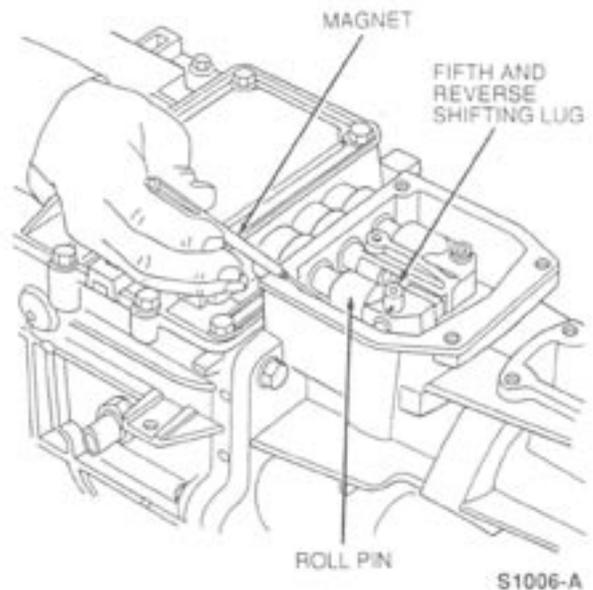


Remove fur shifting lug inspection cover bolts and star washers.

Remove shifting lug inspection cover.



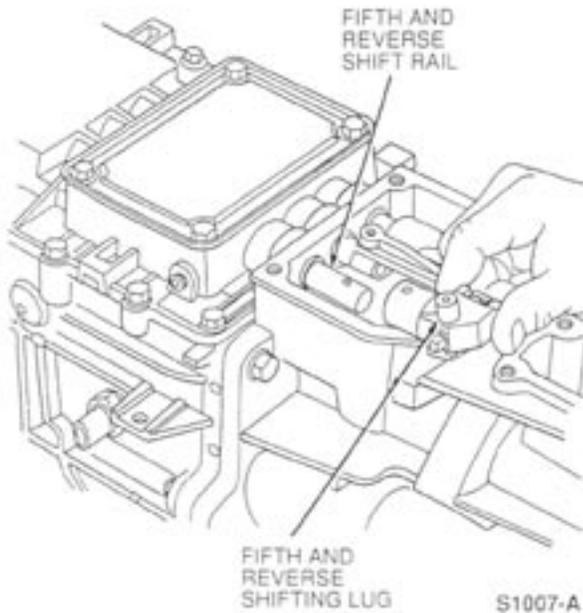
Note: Insert a magnet into area under shifting lugs to catch roll pins when pushed free.



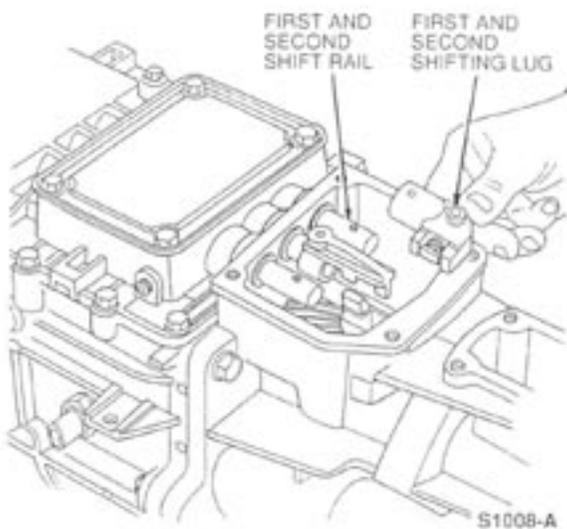
DISASSEMBLY-TRANSMISSION (CONTINUED)

Using a pin punch, remove roll pin securing the fifth and reverse shifting lug to the fifth and reverse shift rail.

Remove fifth and reverse shifting lug and roll pin.



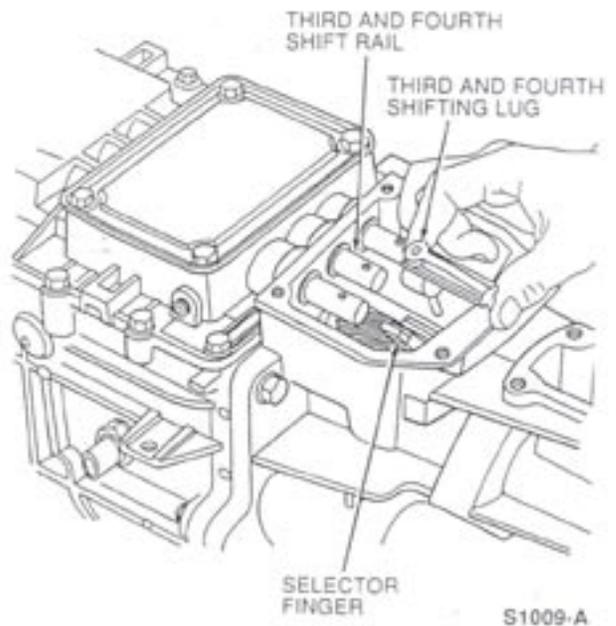
Using a pin punch, remove the third and fourth shifting lug.



Rotate shifting selector rail moving selector finger away from the third and fourth shifting lug.

Using a pin punch, remove the third and fourth shifting lug roll pin.

Remove third and fourth shifting lug.

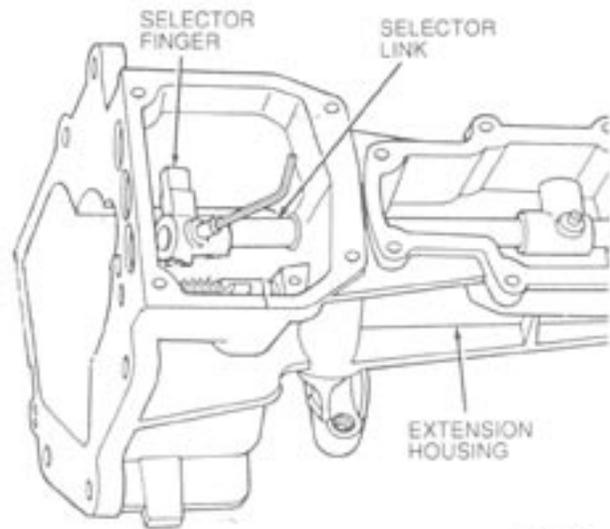


DISASSEMBLY AND ASSEMBLY - SUBASSEMBLIES (CONTINUED)

Shift Selector Rail Assembly

Remove shift selector finger Allen screw.

Slide shift selector finger off end of shift selector rail and remove shift selector finger.



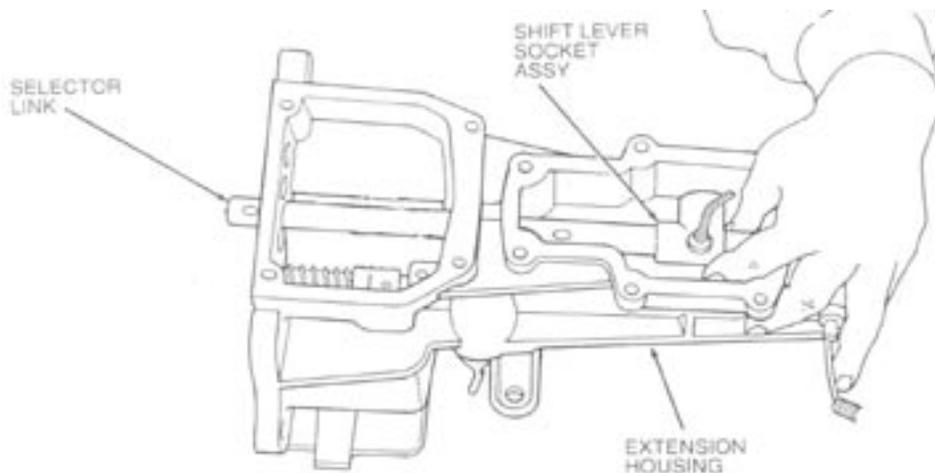
S1030-A

Remove shift lever socket assembly Allen screw.

Hold shift lever socket assembly and slide shift selector rail out of back of extension housing assembly and shift lever socket assembly.

Note that the extension plug will pop out at the time the selector rail is being pushed back. Discard this extension plug. A new one is included in the conversion kit.

Remove shift lever socket assembly from extension housing.

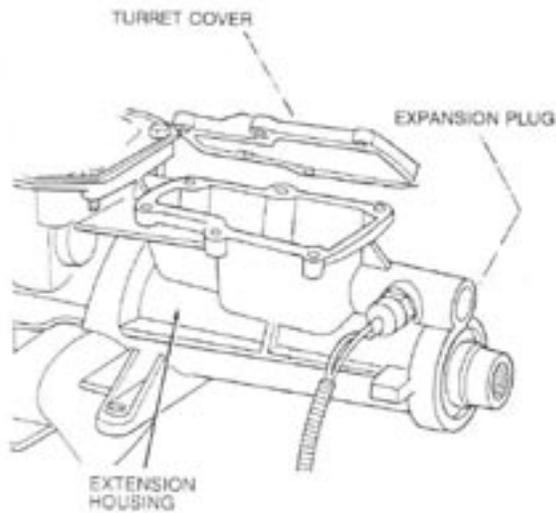


S1031-A

ASSEMBLY-TRANSMISSION (CONTINUED)

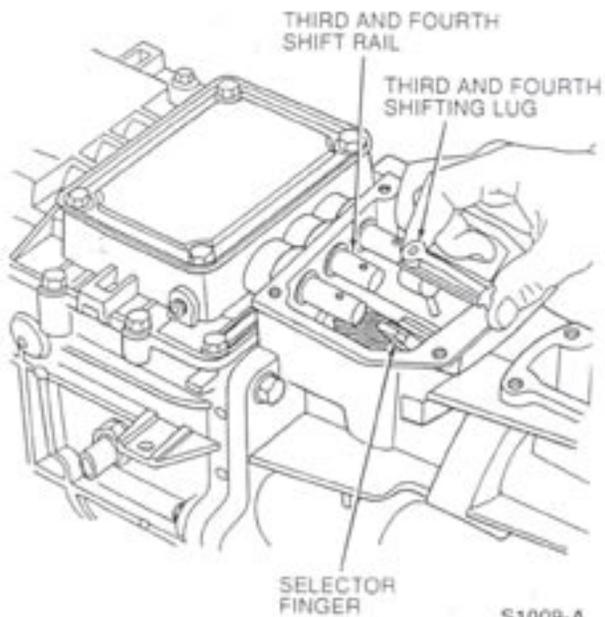
Install the expansion plug. Apply the RTV on to the expansion plug and drive it back into the extension housing.

Install inspection cover on the extension housing. Use rtv sealant and torque bolt to 18-22 ft-lb.



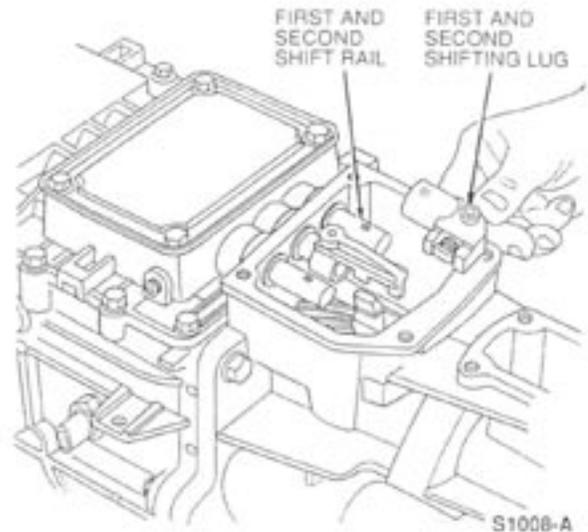
S1004-A

Install third and fourth shifting lug and secure with roll pin.



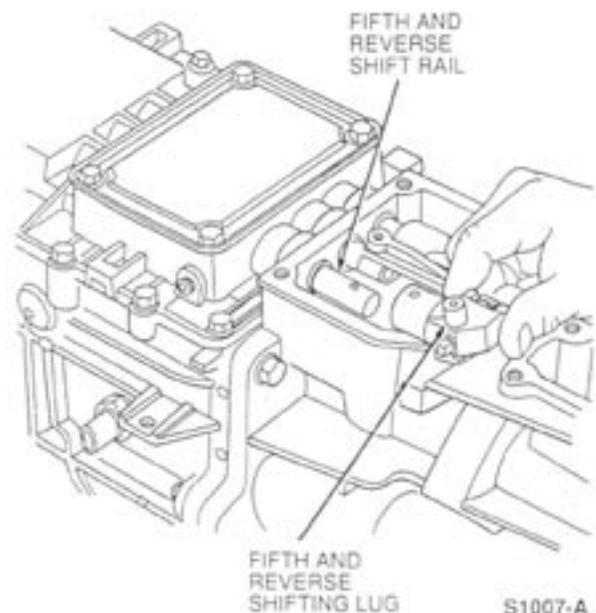
S1009-A

Install first and second shifting lug and secure with roll pin.



S1008-A

Install Fifth and reverse shifting lug. Secure with roll pin.



S1007-A

ASSEMBLY - TRANSMISSION

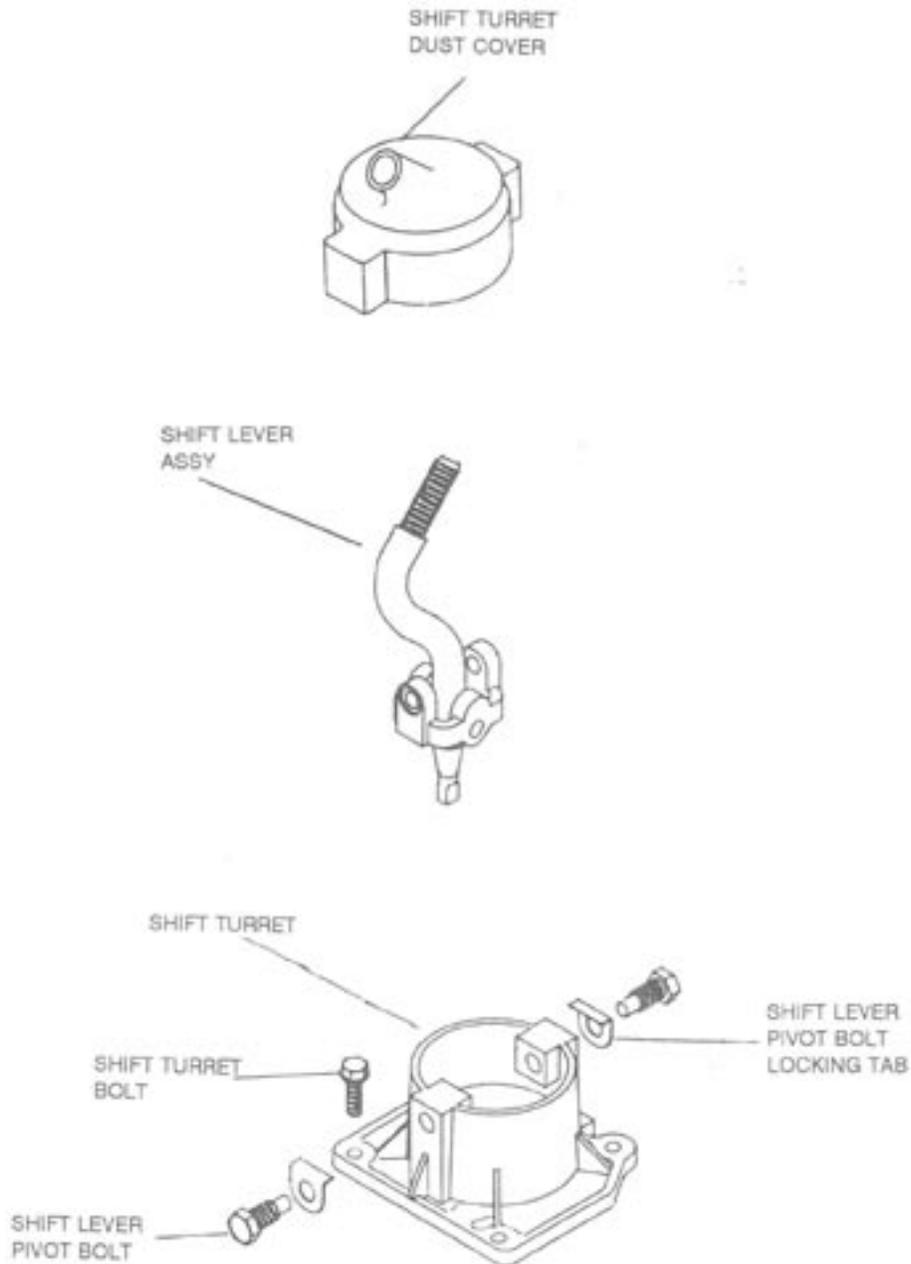
Install shifting turret.

Use rtv sealant and torque bolt to 18-22 ft-lb.

Install shift lever assembly.

Install shift lever pivot bolts and locking tabs; torque pivot bolts 28-30 ft-lb.

Install dust cover.





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