

### Trim Valve & Spring Kit



#### Part No.

**37000-12K**

- A-Trim Valve & Spring
- B-Trim Valve & Spring
- F-Trim Spring

**NOTE:** A- and B-trim valves and springs fit '00-'09 castings only. The F-trim spring is only applicable to '00-'05 castings.

### Tool Kit

#### Part No.

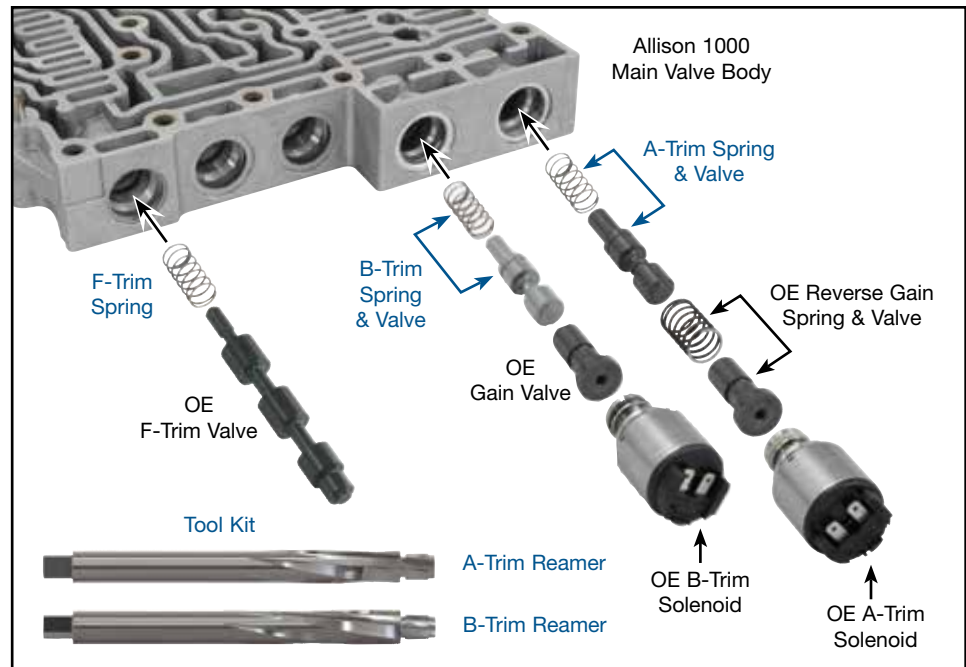
**37000-TL12**

- A-Trim Reamer
- B-Trim Reamer

#### Also Available

**F-Trim Valve Sleeve**  
**37000-03**

## Allison® 1000/2000/2400



### 1. Disassembly

- Remove A-trim solenoid, reverse gain valve and spring, and A-trim valve and spring. Discard trim valve and spring; save other removed components for reuse.
- Remove B-trim solenoid, gain valve and B-trim valve and spring. Discard trim valve and spring; save other components for reuse.
- In '00-'05 units only, remove the TCC solenoid, F-trim sleeve, F-trim valve and spring. Discard spring, save other components for reuse.

### 2. Bore & Reaming Preparation

- Clean the bore thoroughly in a solvent tank.
- Securely clamp the housing to a bench or vise, making sure not to clamp directly over the bore to be reamed.

### 3. Reaming

Ream A-trim and B-trim bores (for reaming instructions/reamer care, please visit [www.sonnax.com](http://www.sonnax.com)). Sonnax reaming tool kit **37000-TL12** is required for these operations.



**NOTE:** Reamers are clearly marked, ensure correct reamer is used in appropriate bore.

#### 4. Installation & Assembly

Ensure all debris has been removed from valve bore and valve body.

##### A-Trim Bore

**NOTE:** The A-trim valve has an ID band on it to differentiate it from the B-trim valve (main photo). The A- and B-trim springs are identical, but differ from the F-trim spring.

- Install Sonnax A-trim spring and valve.
- Reinstall OE reverse gain spring and valve.
- Reinstall OE A-trim solenoid.

##### B-Trim Bore

- Install Sonnax B-trim spring and valve.
- Reinstall OE gain valve.
- Reinstall OE B-trim solenoid.

##### F-Trim Bore ('00-'05)

- Install Sonnax F-trim spring.
- Reinstall OE F-trim valve.
- Inspect OE F-trim sleeve. If worn, replace with Sonnax sleeve 37000-03, available separately (Figure 1). Otherwise, reinstall OE sleeve.
- Reinstall OE solenoid.

**NOTE:** Recommend updating solenoid to OE part no. 24212690. Updated solenoid can be identified by its plastic snout.

#### 5. Separator Plate Modification

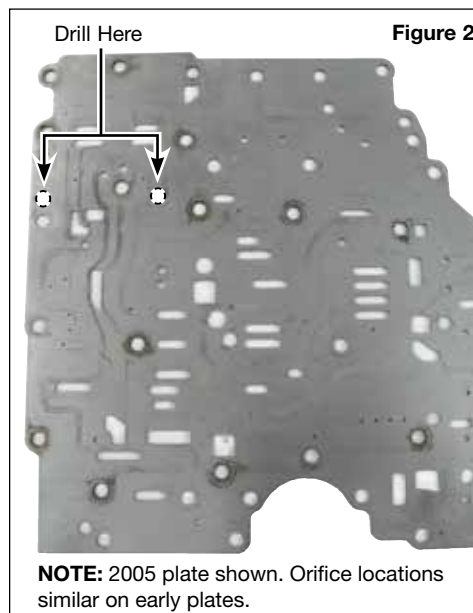
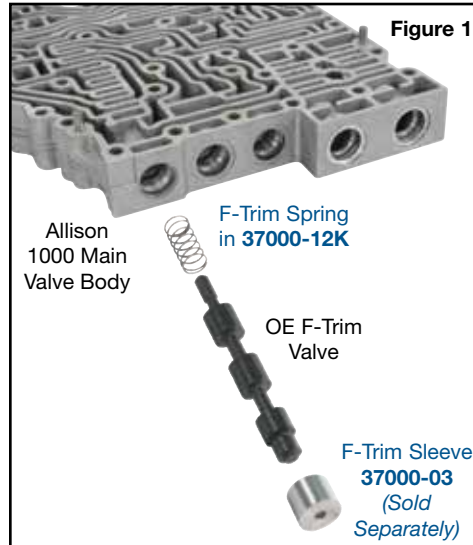
Drill the trim exhaust holes to .062" (Figure 2). Going larger than that can result in upshifts and downshifts shorter to harsh.

#### 6. Reset Adaptives

After installation, all adapt cells and garage shift adapts must be reset with capable OE or aftermarket scanner. Fast adapt mode will then start with new trim valves and springs. Engagements will be very short and firm until relearned. Do not have a plow, trailer or truck doors open during the initial fill, engagement or relearning process. This relearn should include:

- 10 Cycles: Park through Reverse to Drive, then back to Park etc. at idle speed engagements.
- 10 Light throttle cycles of city-type driving from 0–50 mph upshifts and coastdown shifts at light throttle.
- 10 Cycles of heavy throttle upshifts and forced downshifts to include 5th and TCC apply.
- 10 Tow-haul mode heavy throttle upshifts and forced downshifts to allow TCC to apply. Use both coast engine braking and brake pedal affected coastdown.

Recheck and correct fluid level after adaptation is complete.



#### Allison® 1000/2000/2400 Valve Body Identification

##### 2000-2003



##### 2004-2005



##### 2006-2009



##### 2010-2015

