



INSTALLATION INSTRUCTIONS

1815 Patterson Ave. Deland, FL, 32724 – ftiperformance.com

Tech (386)736-5816 – Fax (386)734-0273

info@ftiperformance.com

F1042

TH350/TH400 SFI certified, bolt on aluminum bellhousing for a modified factory case.

This Kit Includes:

- (1) Bell Housing
- (8) 5/16-18x2" Flange head bolts.
- (1) Bell to Pump Gasket
- (2) 1/8" Plugs
- (1) SFI Cert. Tag
- (8) Sealing Rings

SFI Certification: The F1042 Bellhousing is a 30.1 SFI Certified product. Upon receipt, please make sure the SFI numbers stamped into your product corresponds to the numbers shown on your SFI Certifying sticker. If you find your SFI sticker does not match your stamping, please contact the manufacturer immediately to ensure the issue is properly addressed. Failure to check SFI numbers within 30 days of receiving your bellhousing may result in additional re-certification fees for your bellhousing. The SFI certification is valid for 5 years following the date of purchase. Re-certification is available directly at FTI for fee, please contact the manufacturer for more details. Please note that any alterations performed on the F1042 Bellhousing may result in the voiding of your SFI certification.

Note: If you're transmission case is already cut to receive a bolt-on bellhousing. Please skip Operation #1 and move on to Operation #2 for bellhousing installation.

Case Preparation: If you are having to cut your old bellhousing off as part of this installation, we highly recommend complete disassembly of your transmission before you begin cutting to ensure a clean transmission and its components during assembly. If you choose not to disassemble your transmission, please take the required steps to "seal" and protect your transmission during the cutting and installation process to ensure no metal debris finds its way into your transmission.

Safety: Please make sure you take the proper safety precautions during this installation. Safety glasses, gloves, and close toed shoes should be worn at all times, especially when operating power tools such as a sawz-all, cut off wheel, or plasma torch.

Operation #1: Removal of the OEM Bellhousing.

1. Using a sawz-all, cut off wheel, or plasma torch, begin by performing a rough cut around the bellhousing. As shown in [figure 1](#), make sure to leave plenty of material surrounding the pump mounting area.
2. Using a grinder or mill, remove the 3 casting tabs located around the pump are of the case. These tables are located at 12, 4, and 8 o'clock on the case. **Note:** Be careful not to grind into the section of the case that holds the front pump.
3. Continuing with the grinder or mill, remove the excess material along the outer edge of the case. Take your time during this step to slowly remove material, checking periodically to ensure you have not ground into the pump section of the case or removed too much material

from the pan rail. Upon completion your transmission case should look like what is shown in [figure 2](#).

4. If you took the precaution of disassembling your transmission, before re-assembly take extra time to ensure your case is clean and free of any debris created during the bell removal process. If you did not take your transmission apart, take this time to clean your work area and the transmission to prevent debris getting into your transmission.

Operation #2: Mounting the new SFI Certified Bellhousing

1. Beginning with the transmission assembled at least up to the point that the front pump is in the transmission, test fit your new bellhousing to ensure it is sitting flat against the front pump. use a flashlight or a set of feeler gauges to locate any areas of the case that may prevent the bellhousing from sitting flat. Address any high spots now before moving on.
2. Next determine if your transmission is a 6 or 8 bolt pump configuration by counting the number of holes used to hold the pump in the transmission. If you have a 6 bolt transmission and pump, use the supplied 1/8 pipe plugs to plug the 2 extra holes in the bellhousing that will not be used as shown in [figure 3](#).
3. Using the provided bolts, sealing washers, and gasket, carefully bolt the bellhousing to the transmission with the gasket placed in between the bellhousing and the pump, and the sealing washers placed in between the bolts and the bellhousing.
4. Lightly hand tighten each bell bolt evenly before tightening so that is flat against the pump.
5. Torque each bell housing bolt to 18 ft/lbs. in a star pattern going around the bell to insure it is tightened down flat.



Figure 1
Op #1 Step #1



Figure 2
Op #1 Step #3



Figure 3
Op #2 Step #2

