



QUALITY... PLAIN & SIMPLE®

## AxiShift Pro Shift Lever Adapter Installation Instructions

### General Installation Notes:

Please read these instructions completely before beginning the installation. If you have any questions, please call.

Before beginning the installation, disconnect the negative battery cable and use wheel chocks to block the vehicle's wheels.

Make sure the engine, transmission, body and frame are properly grounded. We recommend using anti-seize lubricant on all aluminum threads.

### Refer to Fig. 1 for the component names.

The AxiShift Pro is designed to fit an original Tremec shifter that has a one piece, cast aluminum shifter turret plate. It will not fit the older two piece, machined billet aluminum TKO shifter.

The AxiShift Pro may be installed without removing the shifter turret plate from the transmission, but care must be taken to not drop anything into the transmission while parts are removed.

**Step 1:** Using a 3/32" Allen wrench, remove both of the #10-32 x 3/8" set screws from the holes in the back plate, and set them aside. Then, back out the #10-32 x 1/2" set screws in the main cap so that they protrude about 3/16" - 1/4", but do not remove. **Fig. 2 and Fig. 3**

**Step 2:** If you are using the AxiShift Pro in the centered position, remove the four #10-32 x 1-1/4" socket head machine screws and lock washers from the main cap. Remove the main cap, the adapter shaft, and the main block from the back plate. **Fig. 4**

If you are using the AxiShift Pro in the offset position, use a 3/16" Allen wrench to remove the two 1/4"-28 x 3/4" socket head bolts and lock washers from the underside of the indexable base. Separate the top and bottom halves of the assembly. Place the top half of the assembly onto the indexable base rotated a half turn from the original position. Install the two 1/4"-28 x 3/4" socket head bolts and lock washers using a 3/16" Allen wrench. **Fig. 5**

**Step 3:** Remove the 5/16"-24 flat head bolt from the AxiShift assembly using a 3/16" Allen wrench. Remove the adapter washer, and slide the indexable base off of the indexable shaft. **Fig. 6**

# AxiShift Pro™ Shift Lever Adapter (Patent Pending) Installation Instructions

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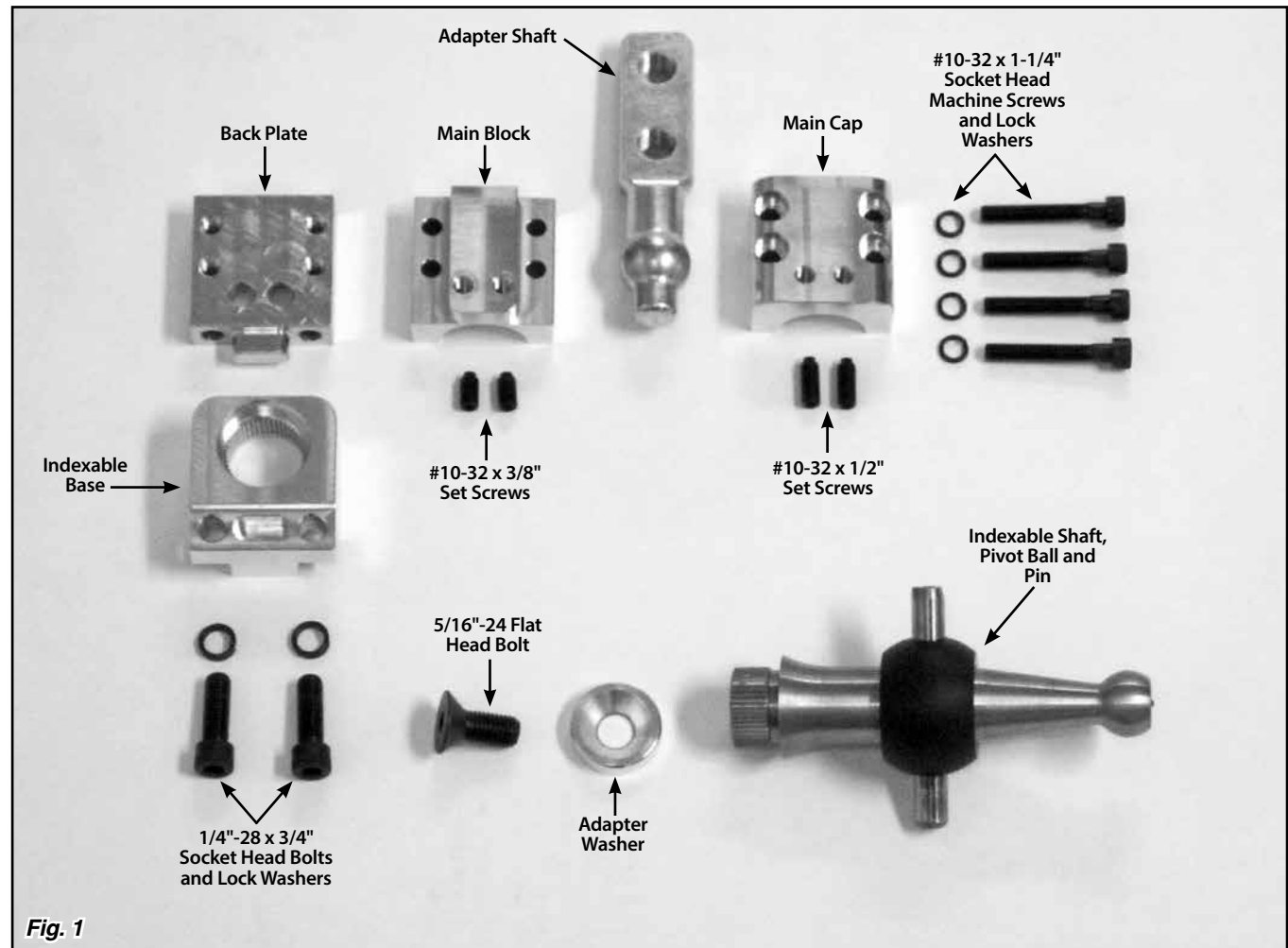


Fig. 1

**Step 4:** Make sure that the transmission is in Neutral. Remove the existing shifter lever (if installed). Remove the rubber dust boot from the top of the shifter turret plate on the transmission, and from the Tremec shifter stub lever. Set the boot aside. **Fig. 7**

**Step 5:** Using a 6mm Allen wrench, carefully remove the two threaded plugs from the shifter turret plate. **Make sure the corners on your Allen wrench are not worn!** The tool will have very little engagement depth in the threaded plug, making it easy for the tool to slip out. **Fig. 8 and Fig. 9**

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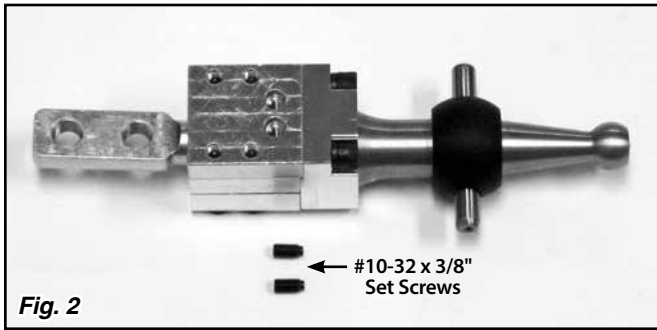


Fig. 2

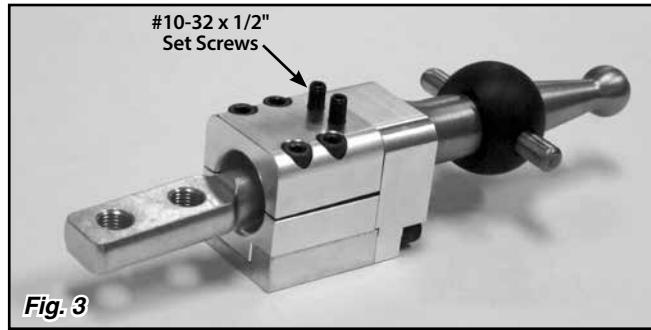


Fig. 3

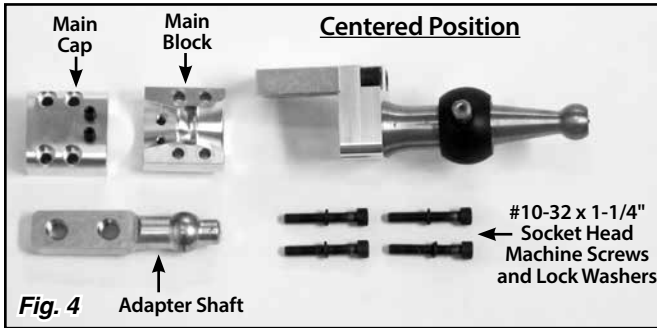


Fig. 4

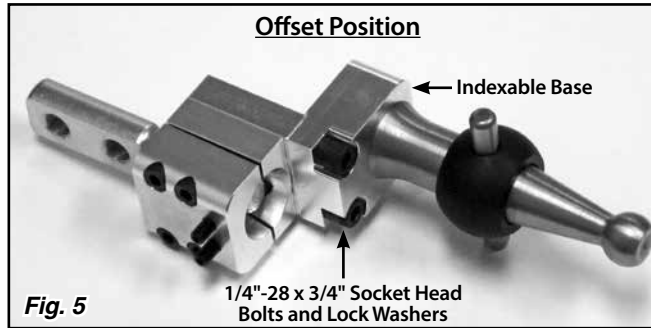


Fig. 5

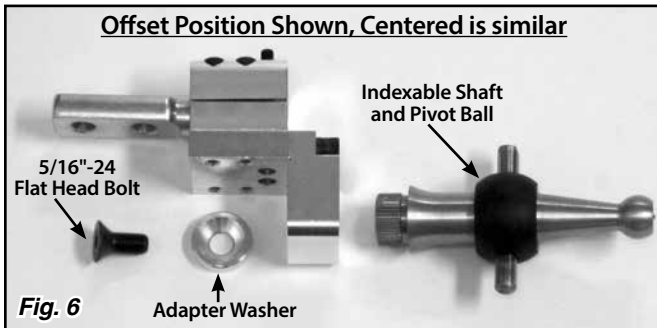


Fig. 6

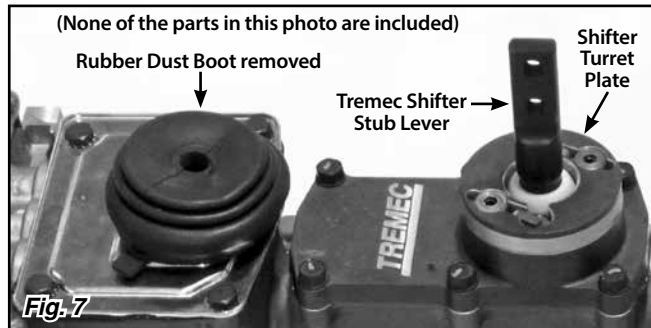


Fig. 7

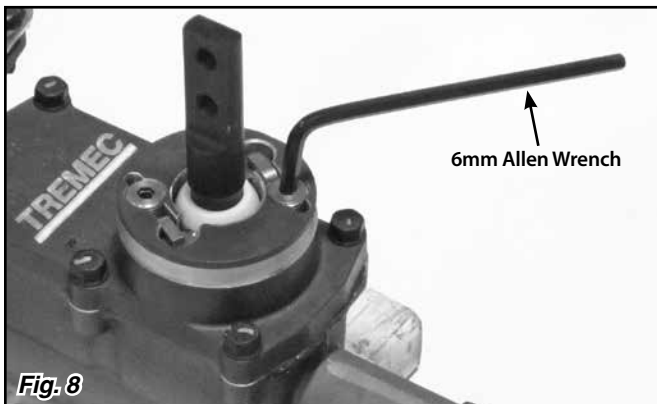


Fig. 8

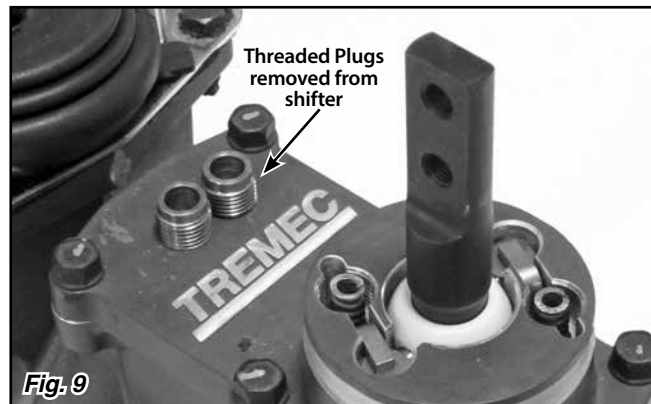


Fig. 9

**Step 6:** Lift the two springs and the two spring levers out of the shifter turret plate, and set aside. **Fig. 10**

**Step 7:** Lift the original Tremec shifter stub lever and pivot ball out of the shifter turret plate. The retainer caps will come out with the stub lever. Remove them and set aside. **Fig. 11 and Fig. 12** Check to make sure that the white plastic shift lever socket bushing from the transmission is not stuck onto the ball at the bottom end of the Tremec shifter stub lever. If it is, remove it and place it to the side for the moment. **Fig. 13** shows the parts removed.

**Step 8:** If the shift lever socket bushing doesn't have sufficient grease in it, apply a coat of automatic transmission assembly lube to the ball at the bottom of the indexable shaft. Apply a light coat of wheel bearing grease to the pivot ball and pin in the center of the indexable shaft. If the shift lever socket bushing came out of the transmission earlier, place it onto the ball at the bottom end of the indexable shaft.

Hold the indexable shaft in the vertical position, and install it into the shifter turret plate. Make sure that the ball on the bottom end of the indexable shaft goes into the shift lever socket bushing in the shifter rail. **Fig. 14**

**Step 9:** Place the two retainer caps you removed earlier into the non-threaded holes they came from in the shifter turret plate, with the flat side up. **Fig. 15**

**Step 10:** Place the two spring levers you removed earlier back into the slots in the shifter turret plate. The longer leg with a point will rest on the bottom of the threaded hole, and the shorter leg will rest on top of the retainer cap. **Fig. 16**

**Step 11:** Place the two springs you removed earlier back into the threaded holes in the shifter turret plate. **Fig. 17** Then, reinstall each of the threaded plugs back into the shifter turret plate. Tighten the threaded plugs with a 6mm Allen wrench. **Fig. 18 and Fig. 19**

**Step 12:** Install the rubber dust boot over the indexable shaft and onto the shifter turret plate. **Fig. 20**

**Step 13:** Place the indexable base onto the indexable shaft in the position that will place the shifter lever where you want it. Place the adapter washer onto the indexable base, and install the 5/16"-24 flat head bolt. Tighten using a 3/16" Allen wrench. **Fig. 21 and Fig. 22**

**Step 14:** If you are using the AxiShift Pro in the centered position, reassemble the main block, the adapter shaft, and the main cap. Use a 5/32" Allen wrench to install the four #10-32 x 1-1/4" socket head machine screws and lock washers. DO not fully tighten them, as the adapter shaft needs to move freely in the next step. **Fig. 23**

If you are using the AxiShift Pro in the offset position, use a 5/32" Allen wrench to loosen the #10-32 x 1-1/4" socket head machine screws just enough to be able to move the adapter shaft freely.

**Step 15:** Install your shifter lever (not included) using the 3/8"-24 bolts and lock washers that came with the shifter lever. **Fig. 24**

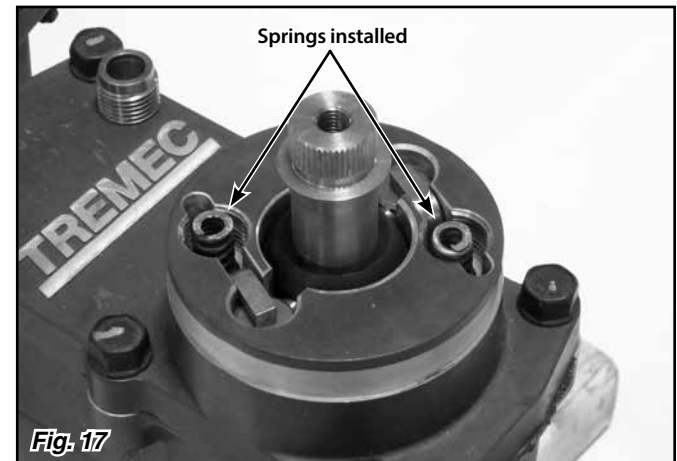
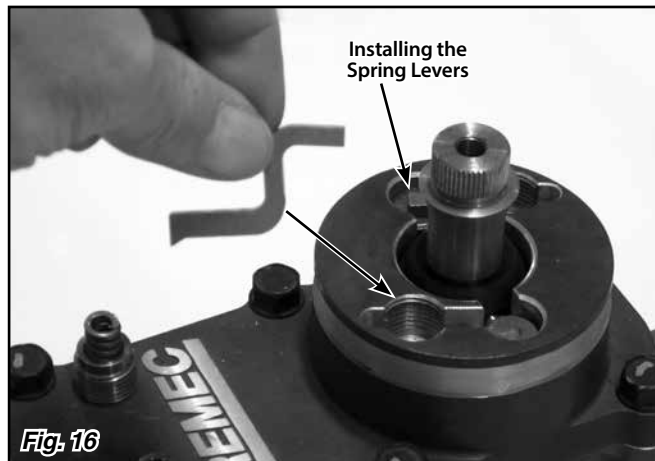
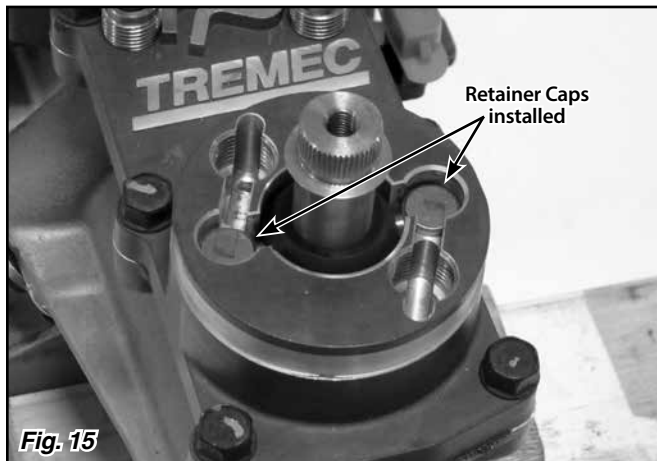
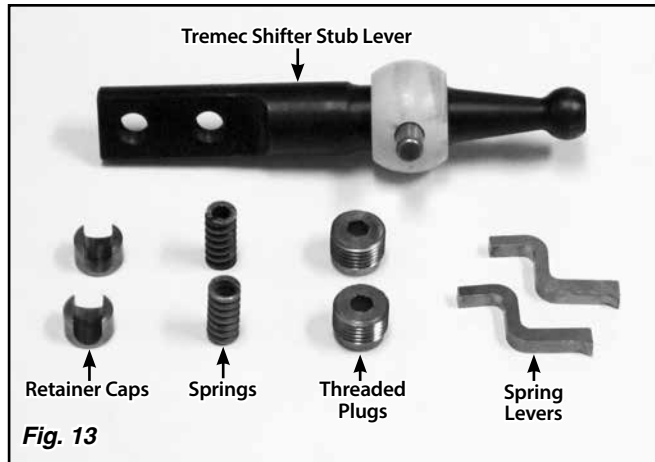
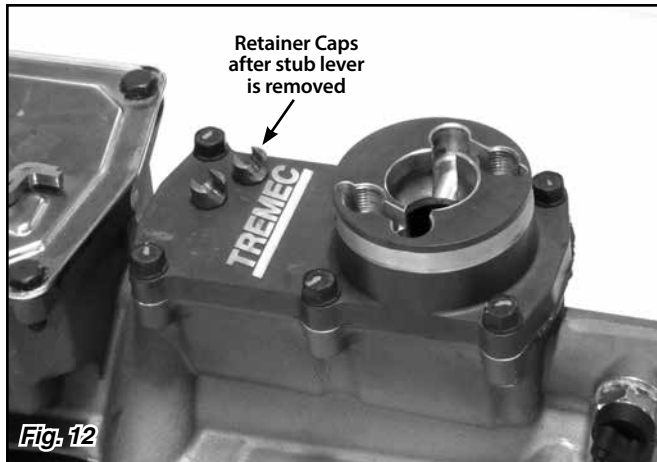
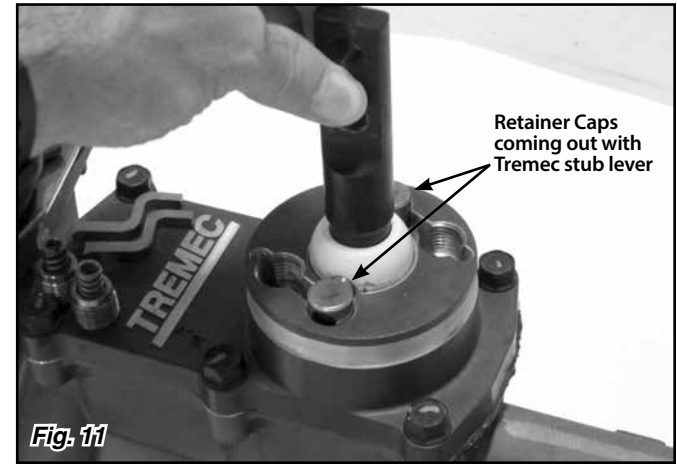
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**Step 16:** Adjust the vertical angle and the rotation of the shifter lever to your liking. Fully tighten all four of the #10-32 x 1-1/4" socket head machine screws while holding the shifter lever in that position.

**Step 17:** Gently test shift the transmission into all gears, including reverse, to make sure that there isn't any interference with the dash or seats. If there is any interference, loosen the four #10-32 x 1-1/4" socket head machine screws and adjust as needed. Then, retighten and test shift the transmission again.

**Step 18:** Once the vertical angle and rotation of the shifter lever is finalized, use a 3/32" Allen wrench to install and tighten the two #10-32 x 3/8" set screws through the back plate, and tighten the two #10-32 x 1/2" set screws in the main cap. **Fig. 25 & 26**

**Step 19:** Test shift the transmission into all gears again to make sure that there isn't any interference with the dash or seats.



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