sonnax® PERFORMANCE

HIGH PERFORMANCE **TORQUE CONVERTER** PARTS

Instructions

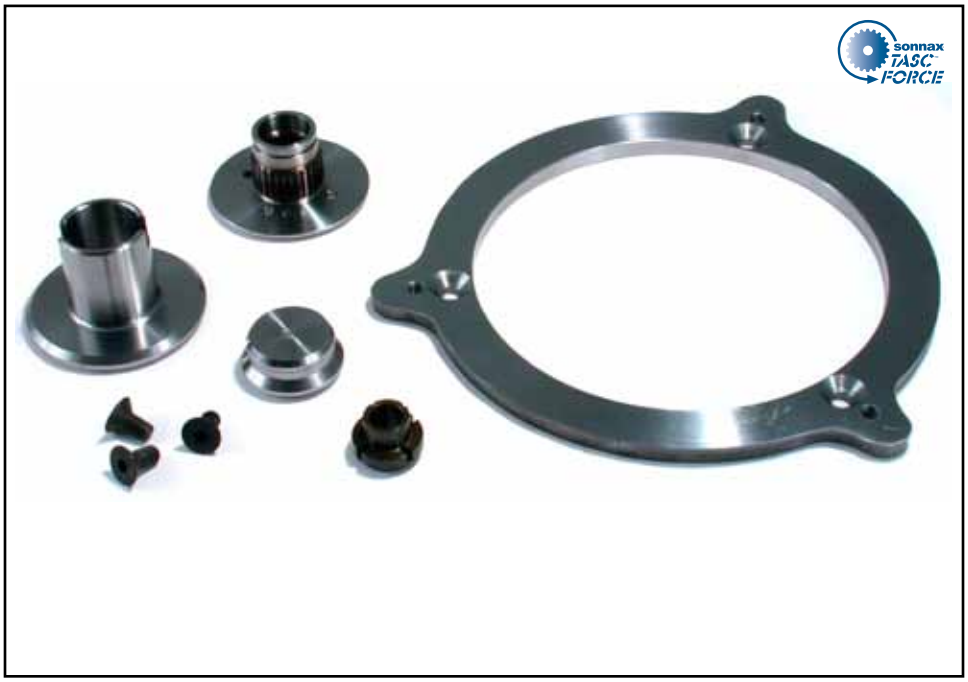
GM 200-4R, 4L60, 4L60-E

10" Racekit with Mounting Ring

Part No.
GM-RK-12

- **GM-90CM-43G** Impeller Hub
- **GM-HTCM-37** Turbine Hub
- **GM-WA-23** Thrust Washer
- **GM-WS-32** Mounting Ring
- **MI-FN-3** Flat Head Bolt (3)
- **GM-PI-13** Pilot

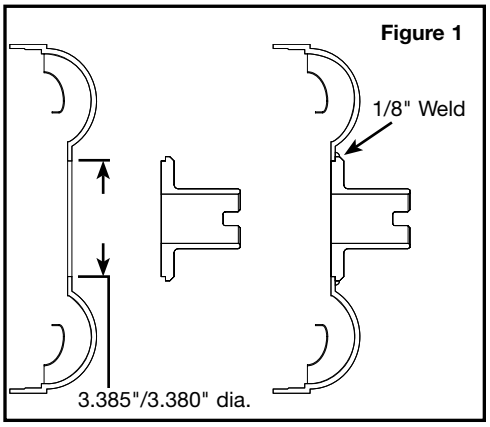
NOTE: Kit adapts front-wheel-drive GM 245mm cores to GM 298mm applications with 27-tooth input splines.



1. Impeller Assembly (see figure 1)

a. Remove the stock GM 245mm impeller hub by boring a 3.380"/3.385" diameter hole on center in the stock GM 245mm impeller.

b. Install the Sonnax impeller hub from the outside. Weld around the O.D. of the impeller hub, making sure it is centered on the impeller.



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2. Turbine Assembly (see figure 2)

a. Bore a 3.200"/3.205" diameter on center in the stock GM 245mm turbine. This will remove the OE turbine hub.

NOTE: The mounting diameter is different than non-lockup racekit turbine hubs. Also different from other racekits is that both flanges of the OE turbine hub assembly are removed.

b. Install the Sonnax turbine hub into the turbine from the front cover side and then weld around the O.D. of the turbine hub.

c. Press the Sonnax aluminum thrust washer into the end of the turbine hub, the same way the OE C-washer is installed.

3. Front Cover Assembly (see figure 3)

a. Remove the OE pilot of the stock GM 245mm front cover (FWD) and, from the outside of the cover, bore a 1.750"/1.752" diameter hole.

b. Install the Sonnax pilot from the outside of the cover and then weld around the O.D. of the pilot.

c. Use the three Sonnax flat head bolts to attach the Sonnax mounting ring to the front cover. The use of Loctite® on the bolts is recommended.

4. Clutch Assembly

The kit is designed to work with early-model GM 245mm piston/damper assemblies. It is suggested to use High Thermal Slipping (HTS) material.

5. Final Assembly

From this point, the kit can be assembled as a stock GM 245mm converter.

NOTE: High torque applications can overpower the torque capacity of stock GM 245mm single disc clutch and damper assemblies. The ability of this single disc clutch to handle a specific torque load is dependent on many factors, including the amount of input torque and the strategy that is used in applying the torque converter clutch. Sonnax does not guarantee that the capability of the 245mm damper assembly will be adequate in all applications.

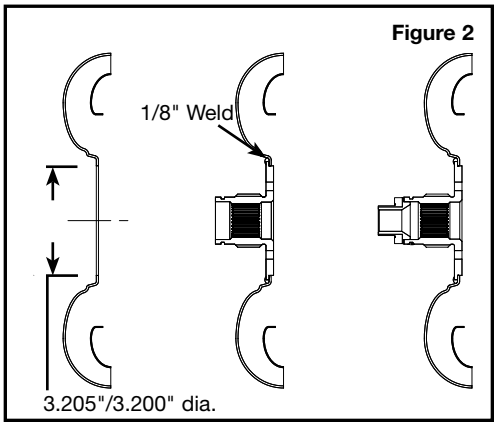

Figure 2

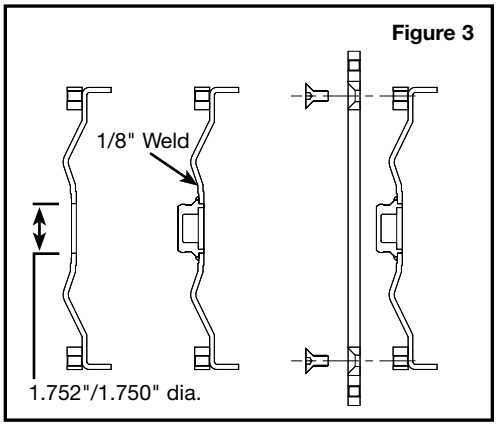

Figure 3

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