

GM Powerglide, TH350, TH400

Pilot

Part No.
GM-PI-16

Application

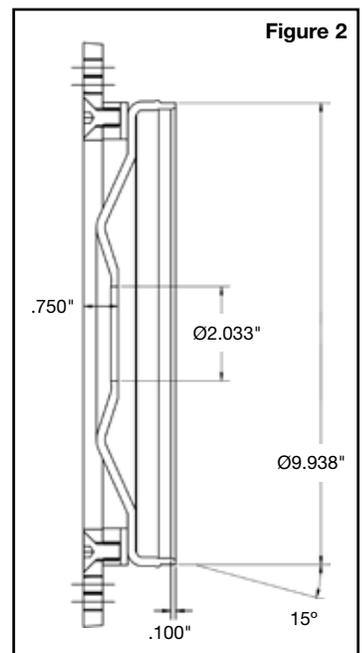
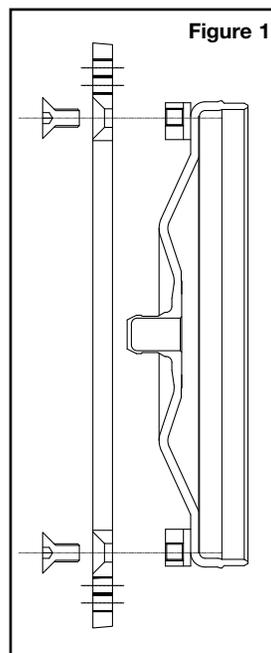
For use with 10" performance converter (mounting ring).



NOTE: These instructions detail how to install **GM-PI-16** and set up the OE front cover for use with **GM-90-3G** impeller hub, **GM-HTCM-28** turbine hub (or **GM-HTCM-29**), **FD-WP15-OE** thrust washer, **CH-B-2X** bushing (or **CH-B-2-CP**), **GM-BM-4** mounting ring (or **GM-WS-22** or **GM-WS-32**) and **MI-FN-3** mounting bolts.

Instructions

1. Use an OE GM 245mm front cover from a front wheel drive application. If needed, take a skim cut off the OE mounting pads of the front cover.
2. Apply Loctite[®] to the three mounting bolts (**MI-FN-3**). Then bolt the mounting ring (**GM-BM-4**, **GM-WS-22** or **GM-WS-32**) to the front cover (**Figure 1**).
3. Mount the cover assembly into a lathe, using the mounting ring to fixture it. Using the outer diameter of the cover as a reference, bore a 2.033" dia. hole to remove the OE pilot. Then face off the inside surface (just outside the 2.033" dia. hole) so that it is .750" from the face of the mounting ring (**Figure 2**).



Instructions (continued)

4. The cover will sit deeper in the impeller than it did on the stock lockup applications. Turn the mating lip of the cover down to 2.00" from the mounting pads and turn a 15° chamfer, .100" deep on the inside lip. Machine the outside of lip to 9.938" dia. (Figure 2).
5. Remove the cover assembly from the lathe. The pilot will install from the inside of the cover. Weld around the inside seam and then around the outside seam (Figure 3).
6. Install Sonnax bushing, either Sonnax CH-B-2X or CH-B-2-CP (Figure 4).
7. If using the CH-B-2X, put the cover assembly back into the lathe. Center on the 1.703" dia. pilot. Bore the bushing out to 1.377–1.378" dia. (Figure 4).
8. Mount the turbine into the lathe. Remove the OE turbine hub and bore the turbine out to 2.350–2.355" dia.
9. Install the turbine hub from the cover-side of the turbine. Weld on the cover-side seam (Figure 5).
10. From this point on, use standard installation technique.

