

GM Powerglide, 350, 400, 10"

Unit Size: 10" • Core: GM 245mm • Dampened: No • Turbine Hub Input Spline Count: 30

10" Performance Converter Mounting Ring Kit

Part No.

GM-RK-14

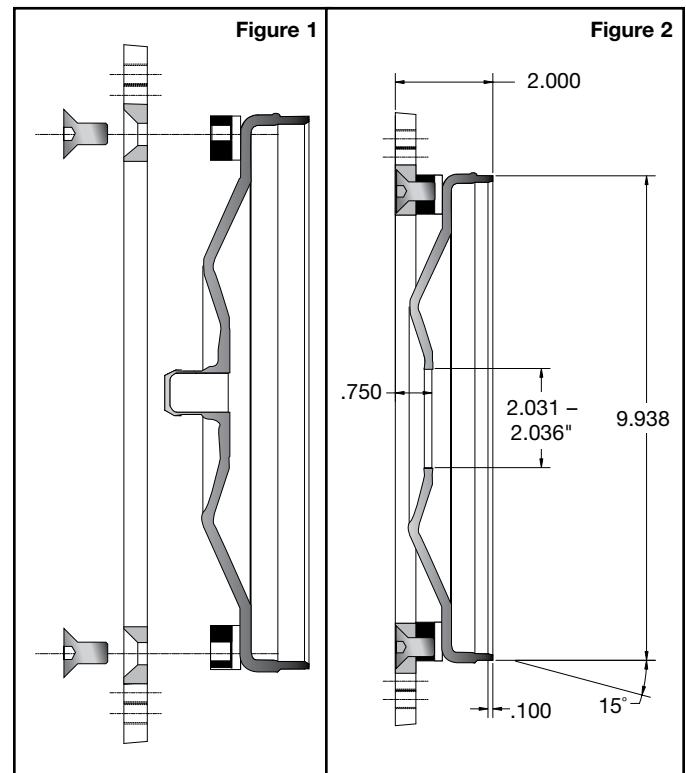
- Impeller Hub Butt-mount
- Turbine Hub 30-Tooth
- Conversion Pilot
- Front Cover Bushing with 10¾" and 11½" bolt patterns
- Thrust Washer
- Countersunk Bolts (3)



NOTE: When using in a Powerglide application the impeller hub must mount .070" taller. Either leave a .070" boss on the impeller to extend the height when using the impeller hub included in the kits or use a **GM-90-300G** impeller hub and cut it down to 3.695" length.



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**). Bolt Sonnax mounting ring (**GM-BM-4**) to the front cover (**Figure 1**).
3. Mount cover assembly into a lathe using the mounting ring bolt holes to fixture. Using the outer diameter of the cover as a reference, bore a 2.031 – 2.036" hole to remove the OE pilot. Face off the inside surface (just outside the 2.031 – 2.036" hole) so that it is .750" from the face of the mounting ring (**Figure 2**).





NOTE: Cover will sit deeper into impeller than it did on OE application.

4. 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 outside diameter of lip to 9.938" (**Figure 2**).
5. Remove cover assembly from lathe. The pilot will install from inside of the cover. Weld around inside seam and then around outside seam (**Figure 3**).
6. Install Sonnax front cover bushing (**CH-B-2-CP**) (**Figure 4**).
7. Mount turbine into the lathe. Remove OE turbine hub and bore the turbine out to 2.350 – 2.355".
8. Install Sonnax turbine hub from cover side of the turbine. Weld cover side seam (**Figure 5**).
9. Continue assembly per normal shop procedure. Suggested endplay is between .005" and .010".

