

## GM 6L80 (245mm), Single-Plate

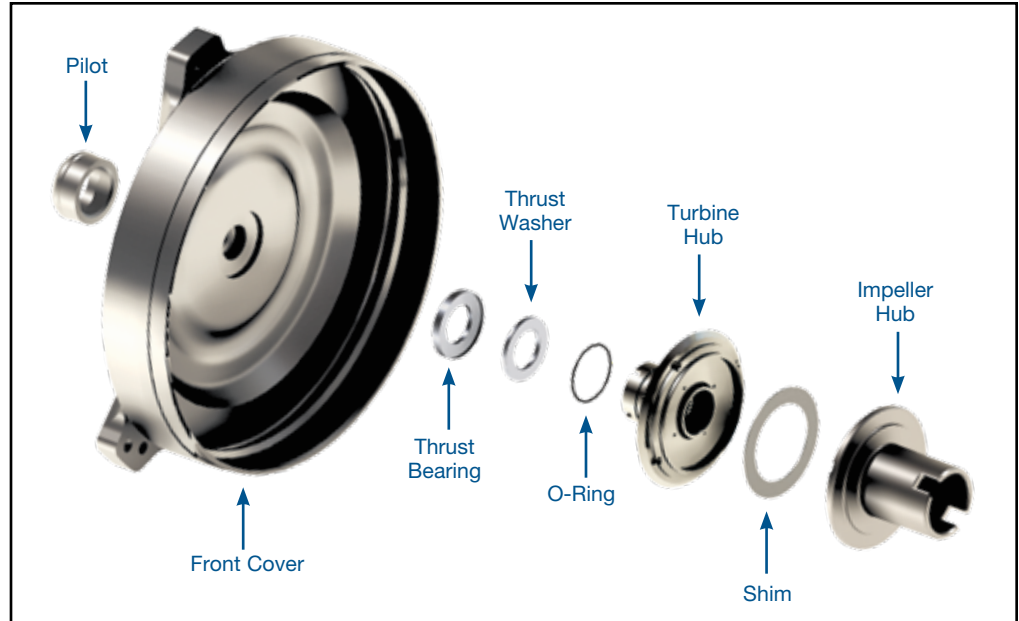
Unit Size: 245mm • Core: GM 245mm • Dampened: Yes • Turbine Hub Input Spline Count: 36

## 300mm Performance Converter Kit

### Part No. GM-RK-16

- Pilot
- Front Cover
- Thrust Bearing
- Thrust Washer
- O-Ring
- Turbine Hub
- Shim
- Impeller Hub

**NOTE:** Street/Strip applications only, not for truck towing. This kit must be completed with the additional required Sonnax or OE parts listed below. Some machining is required.



### Required Piston Damper Assembly Parts

#### OPTION #1:

- GM-DA-6P Piston Plate
- GM-RV-9 Rivets (100/bag)
- S20300WC, B45300HTE or B45070HTE Friction Ring
- GM 258mm Damper Assembly Core

#### OPTION #2:

- GM 258mm Piston/Damper Assembly

### Required Stator Assembly Parts

- CH-N-1 Thrust Bearing (2)
- GM-CS-5 Sprag Cartridge
- GM-ST-082 or GM-ST-086 Stator

### Required OE Core Parts

- GM 245mm Impeller
- GM 245mm Turbine (requires machining)

### Optional Assembly Parts

- B78 Hex Head Screw (100/bag)

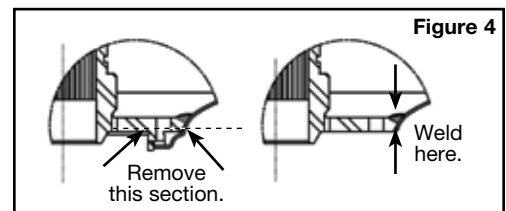
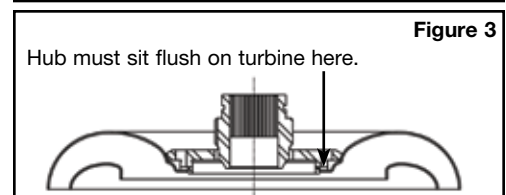
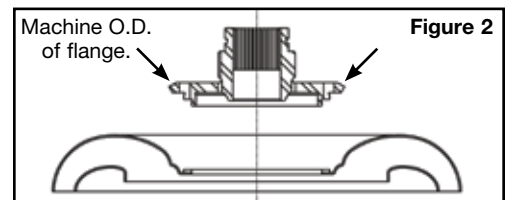
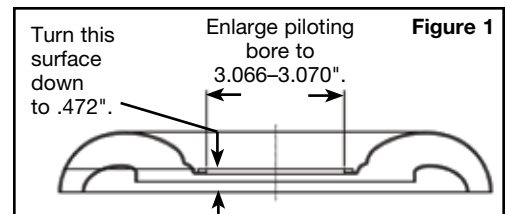
The Sonnax performance converter kit **GM-RK-16** is illustrated above. The entire torque converter line-up (complete with other required parts listed at left) is illustrated for reference on page 2.

### 1. Turbine Assembly

The Sonnax turbine hub **GM-HTCM-53** is designed for GM 245mm cores and allows the use of either stator **GM-ST-082** or **GM-ST-086** along with the sprag cartridge **GM-CS-5** (used with two **CH-N-1** thrust bearings).

**NOTE:** When used with Sonnax performance converter kits, the turbine assembly **MUST** be modified as described below.

- a. Enlarge piloting bore to 3.066–3.070" (**Figure 1**).
- b. Turn surface indicated (**Figure 1**) down to .472". To obtain the proper measurement of how much material to remove from this area, place the turbine on a flat surface and measure the start dimension through the enlarged bore.
- c. Machine the turbine hub flange O.D. for proper fit with turbine (**Figure 2**).
- d. Place the turbine hub flush on the turbine (**Figure 3**).
- e. Remove the section below the turbine hub flange and weld the hub to the turbine (**Figure 4**).



## 2. Cover Assembly

The pilot **GM-PI-20** will be a sliding fit to light press on the cover. Insert the pilot all the way to the cover back surface and weld in place.

## 3. Damper Assembly

- If piston/damper assembly **Option #1** is used, assemble the Sonnax piston plate **GM-DA-6P** to the GM 258mm damper assembly using **GM-RV-9** rivets.
- Install the piston/damper assembly (either **Option #1** or **Option #2**) to the turbine hub and press the aluminum thrust washer into the end of the turbine hub.
- Insert the thrust bearing into the front cover, then the complete piston/damper and turbine assemblies.

**NOTE:** The overall height should be 6.150" (156mm).

**R&R NOTE:** Use only the shorter .570" early-style hex head screws in the smallest cover bolt circle. Sonnax **B78** converter bolts can be used as a replacement. The long .890" OE torque converter hex head screws will bottom out when used in the smallest bolt circle.

