

GM Powerglide, TH350, TH400, 10"

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

10" Performance Converter Kit

Part No. GM-RK-1S

- Flanged Impeller Hub
- 30-Tooth Turbine Hub
- Thrust Washer
- Front Cover, Small Bolt Pattern
- Front Cover Bushing (installed)

NOTE: Pilot kit not included.



1. Impeller Assembly (Figure 1)

- Remove stock GM 245mm impeller hub by boring a 3.380–3.385" dia. hole on-center in the impeller.
- Install Sonnax impeller hub from the outside. Weld around O.D. of the impeller hub, ensuring it is centered on the impeller.

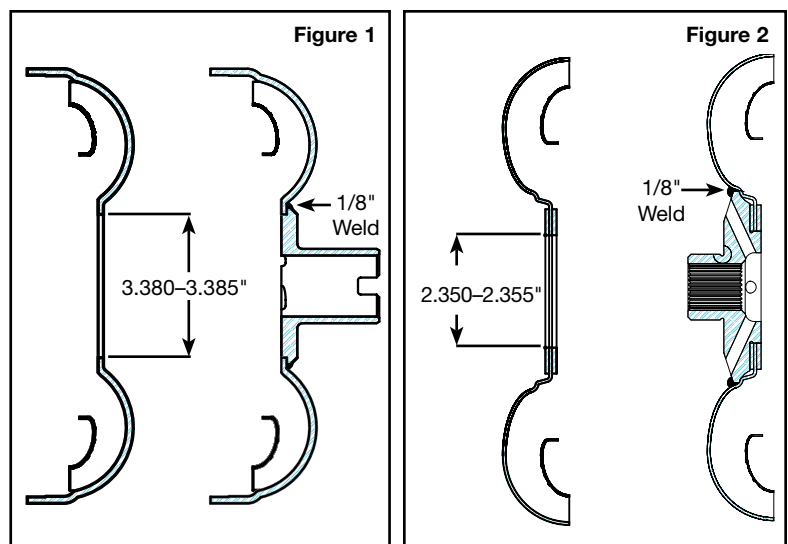
2. Turbine Assembly (Figure 2)

- Bore a 2.350–2.355" diameter hole on-center in the stock GM 245mm turbine. This will allow removal of OE turbine hub.

NOTE: Both flanges of the OE turbine hub assembly are retained and should not be removed.

If using Sonnax stator **GM-ST-082** or **GM-ST-086**, the stator will be .345" taller than OE stator. Approximately .345" must be removed off the turbine bearing face to correct clearances and stack height.

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



3. Front Cover Assembly (Figure 4)

- a. Apply thread locking compound to internal pilot threads.
- b. Screw pilot onto the threaded pilot of front cover and tighten with pin spanner.

4. Permanently Attach Spacers

When using mounting pad spacers, secure spacer to the appropriate bolt hole of the front cover using a 7/16"-20 mounting bolt. Tack weld spacer in place, then remove bolt (Figure 5). Repeat for other mounting pads.

5. Stator Assembly

- a. Install new stator race (not included in kit).
- b. Install new springs and rolls (not included in kit).
- c. Reinstall OE stator cap and snap ring.

6. Final Assembly

Continue normal assembly.

