

GM 4L60 (700-R4), 4L60-E, 200-4R (298mm NLU)

Unit Size: 10" • Core: GM 245mm • Dampened: No • Turbine Hub Input Spline Count: 27

298mm Performance Converter Kit

Part No.

GM-RK-9

- Flanged Impeller Hub
- 27-Tooth Turbine Hub
- Thrust Washer
- Front Cover Bushing (Installed)
- Front Cover, Dual Bolt Pattern
- Pilot
- Mounting Pad Spacers (3)

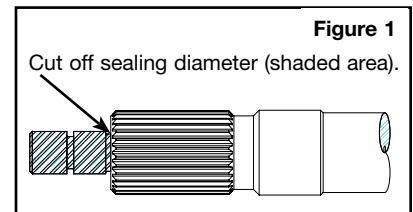
NOTE: Converts lockup converters to high performance, non-lockup converters.



1. Transmission Modification

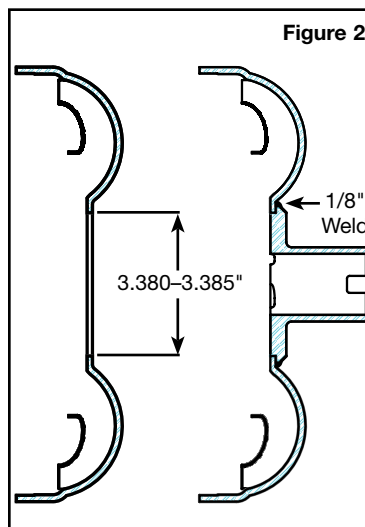
Transmissions originally equipped with lockup torque converter must be modified as follows:

- Remove end nub of the input shaft (**Figure 1**).
- TCC apply valve located in pump must be blocked or otherwise disabled.



2. Impeller Assembly (Figure 2)

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



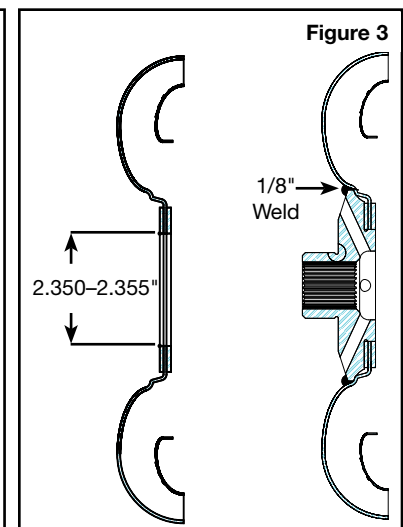
3. Turbine Assembly (Figure 3)

- Bore a 2.350–2.355" dia. 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.



4. Front Cover Assembly (Figure 4)

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

NOTE: Sonnax mounting pad spacers **MUST** be used in order to obtain correct converter height. Spacers can be permanently attached to front cover or can be installed when bolting converter to flexplate.

5. Permanently Attach Spacers

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

NOTE: The stock 298mm bolt pattern is the 10-3/4" BCD (smaller pattern in the cover). Many flexplates allow the use of both BCDs. Sonnax recommends using the largest BCD the customer's flexplate will accommodate.

6. Stator Assembly

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

7. Final Assembly

Continue converter assembly. Sonnax thrust washer is included for use during reassembly. Final endplay after welding should be .000-.010", and the stator and turbine assemblies should be able to turn with minimal effort.

