

Piston/Damper Repair Sleeve Kit

Part No.

BW-DS-1K

- Damper Sleeve
- Damper Rivets (10)

Associated Parts

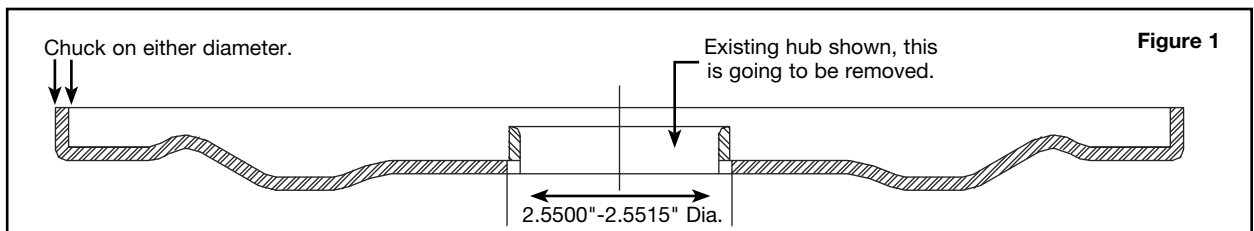
- GM-O-8V O-Ring
- BW-DA-3P Piston Plate
- BW-DS-2 Piston/Damper Repair Sleeve (No disassembly required)

BorgWarner 310mm LU (A618, 47RH/RE, 48RE)

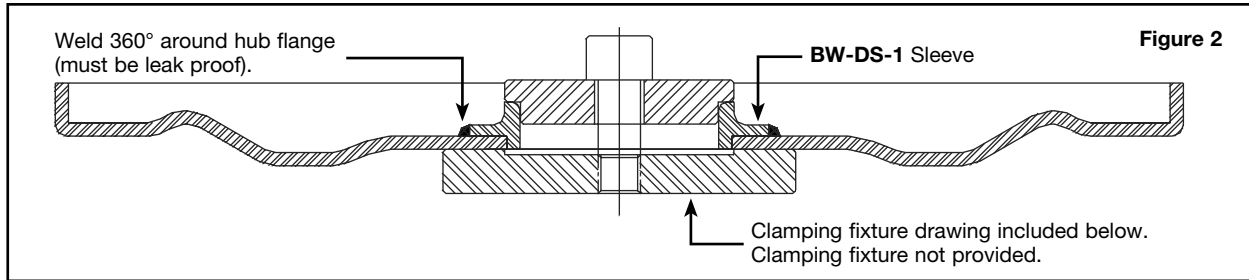


Machining & Welding Instructions

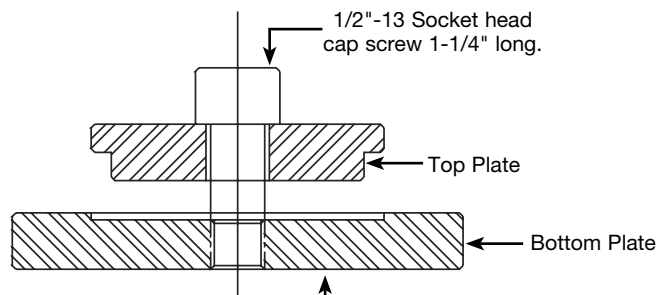
1. To prepare the piston plate for Sonnax **BW-DS-1** sleeve installation, remove the damper assembly from the piston plate by removing the rivets.
2. Chuck the piston plate in a lathe on either the inside or outside diameter (**Figure 1**).
3. Bore the inside diameter to 2.5500–2.5515" to accept the replacement sleeve (**Figure 1**).
4. Remove plate from the lathe and remove all the burrs.



5. Insert the sleeve on the damper side, making sure that the sleeve is held firmly against the plate with a clamping fixture (**Figure 2, page 2**). See how to build a clamping fixture (**Figure 3, page 2**).
6. After the sleeve is welded and cooled, remove the fixture, then lightly clean the inside diameter with 600-grit emery cloth.
7. Check for leaks around hub and rivets. Leaks will cause lockup problems and burn the clutch.



How to Build a Clamping Fixture



NOTE: Keep this plate at least 4.000" dia. and .500" thick to help dissipate the heat when welding.

