

Center Support Seal Kit

Part No.

104740-14K

- Center Support Seal Inserts (4) Grooved & Threaded
- Valve Body Seal Inserts (4) Non-Grooved & Threaded
- Springs (2) Short, .250"
- Springs (2) Medium, .380"
- Springs (2) Tall, .560"



Figure 1

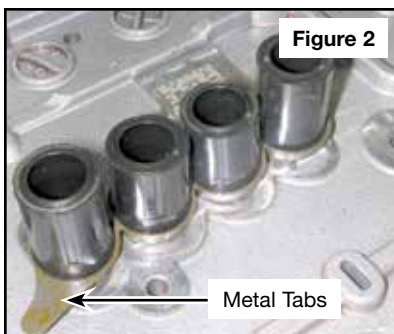


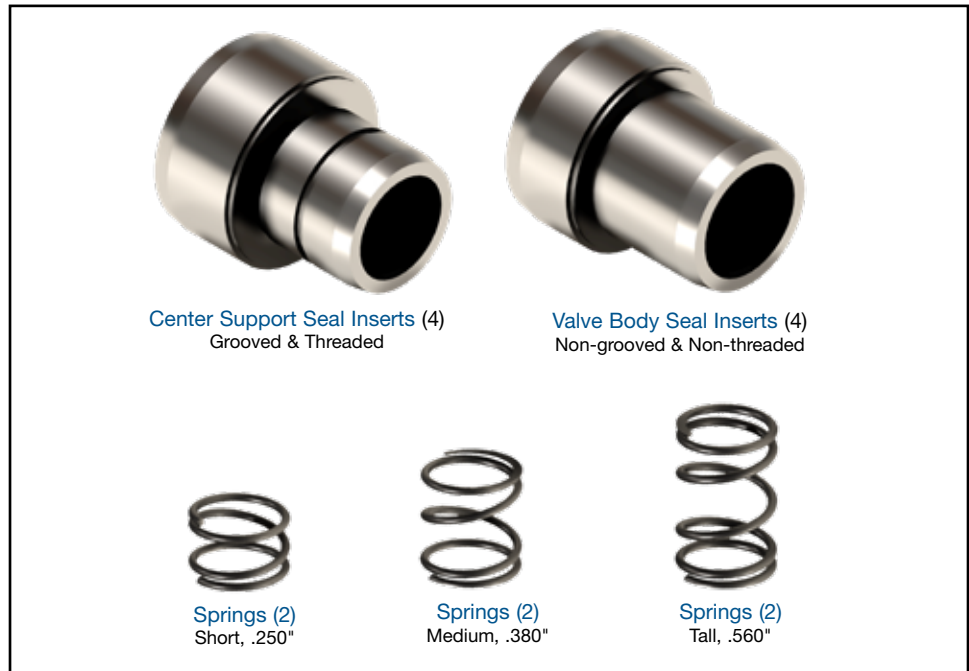
Figure 2

Metal Tabs



Figure 3

GM 6L45, 6L50, 6L80, 6L90



Installation & Assembly

1. Press four Sonnax valve body seal inserts (non-grooved and non-threaded) into the valve body. Ledge on insert should seat flush against the finished valve body surface (**Figure 1**).

2. Install OE center support seal assembly on the pressed-in seal inserts in the valve body.

NOTE: 6L45 and 6L50 unit seals (**Figure 2**) have metal tabs and are approximately .900" (outer) and .730" (inner) tall.

6L80 and 6L90 unit seals do not have metal tabs and are shorter, approximately .590" (outer) and .420" (inner).

3. Install springs as explained below, then secure with assembly lube.

For 6L45/6L50 seals

- Insert tall (.560") springs in tall outer seals.
- Insert medium (.380") springs in shorter middle seals.

For 6L80/6L90 seals

- Insert short springs (.250") in taller outer seals.
- **NO** springs required in shorter middle seals.

4. Press four Sonnax center support seal inserts (grooved and threaded) into the case at the center support locations. The ledge of insert should seat flush against the bottom of the case seal bore. Threads are for removal with slide hammer if required for center support removal (**Figure 3**).

5. Install valve body into case per OE instructions. Ensure the four OE center support seals mate into the case bore. They will seal around the installed inserts when the valve body is positioned correctly and bolted to the case.