

HIGH PERFORMANCE TORQUE CONVERTER PARTS

Instructions

Outer Stator Race

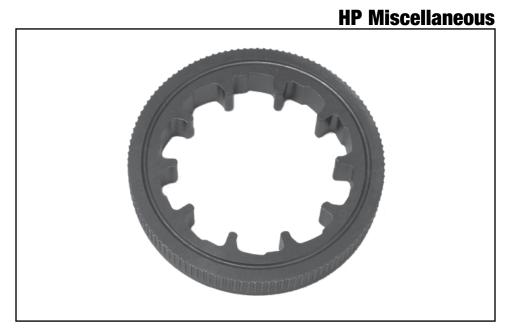
Part No. GM-R-15

Applications

- GM 4L60-E (300mm) & 6L80
- Conversion for Chrysler BW 310mm LU (A618), GM TH400 (3L80), AT-540 & Buick 350

Associated Parts

- GMBW-WS-40 Conversion Spacer
- GM-S-11 Accordion Spring
- GM-RO-572 Roller
- GM-HR-2 Inner Stator Race, GM 300mm & GM 298mm
- **GM-HR-1** Inner Stator Race, BW 310mm LU (A618), GM TH400 (3L80), AT-540 & Buick 350



NOTE: Sonnax outer stator race **GM-R-15** and conversion spacer **GMBW-WS-40** can be used with the GM 4L60-E (300mm) and 6L80 springs and rollers for a cost-effective upgrade to BW 310mm LU (A618), GM TH400 (3L80), AT-540 and Buick 350 stator clutch assemblies. The upgrade repairs and improves the performance of OE stator cams with problematic roller clutch design.

Conversion Instructions

- 1. Remove the outer stator race, spring retainer, springs, rolls and inner stator race from the stator. The spring retainer is no longer used with the conversion.
- 2. Modify the stator by milling five slots into the stator using a 3/8" end mill (Figure 1).
- 3. Drop the **GMBW-WS-40** conversion spacer into stator (**Figure 2**).
- 4. Drop in the GM 300mm outer stator race **GM-R-15** and MIG-weld in place at the end of the slots (**Figure 3**).
- 5. Reassemble the stator clutch using the springs **GM-S-11** and rollers **GM-RO-572** from the GM 300mm unit and the inner stator race **GM-HR-1** from the original stator.

