

Impeller Hub

Part No.

GM-90-94G

GM 280mm LU (4L60-E) "VJCX"

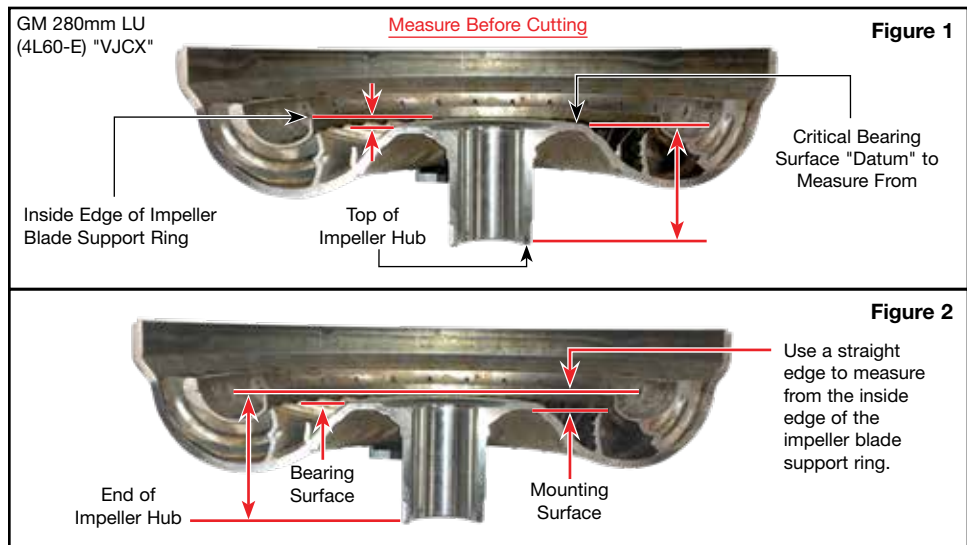


1. Measure & Record



NOTE: Measure and record everything before cutting the old impeller hub out of the impeller and installing Sonnax **GM-90-94G**.

- Reference the point which is the inside edge of the impeller blade support ring (**Figure 1**).
- Using a straight edge across the inside diameter of the impeller blade support ring, measure to the bearing surface and mounting surface (**Figure 2**).



2. Installation

- a. Remove existing impeller hub at about a 3.5" diameter.
- b. Finish bore the hole to 3.68" diameter.
- c. Create a flat out to 3.96" for Sonnax flanged impeller hub to sit on. Make this flat approximately .290" from the inside edge of the impeller blade support ring (**Figure 3**).
- d. Double check the original measurements after setting Sonnax impeller hub into place.
- e. Weld into place from the outside.
- f. Measure everything once again to ensure the proper placement. If needed there is extra material on the bottom of Sonnax impeller hub to clean up for a good bearing contact surface.

