

Bearing Retainer

Part No.

FD-WS-42

Ford 6R80, 260mm (Late)



1. Disassemble

Remove bearing and any loose material on surface of stator and impeller.

NOTE: It is recommended to replace the OE bearing with Sonnax **GM-N-11** upon reassembly.

2. Impeller Modification

Turn bearing surface on impeller from a dia. of 2.25" outward. Take no more than .015" of material from impeller surface. Ensure surface is flat, free of burrs and has a smooth surface finish.

3. Assembly

- Center Sonnax bearing retainer using either a weld bead (**Step 4, Page 2**) or fixture, onto the new impeller surface.
- Weld Sonnax bearing retainer in place in at least 6 locations, equally spaced around the O.D.
- Turn I.D. of Sonnax bearing retainer to allow the bearing to drop into place (nominal O.D. of bearing is 3.38").



REQUIRED: Ensure the top bearing face sits at least .020" above **FD-WS-42**, when installed in the impeller. No material is allowed above the top surface of **FD-WS-42**.



CRITICAL: Outer weld bead should not interfere with stator or rotation of the stator.



OPTIONAL: Turn the bearing surface of the stator to remove any rough surfaces. Do not remove more than .010" of material.

4. Weld Bead Instructions

- Place weld bead centered on impeller roughly the size of Sonnax bearing retainer (**Figure 1**).
- Machine pocket in the weld bead for O.D. of Sonnax bearing retainer (3.61" nominal O.D.) to drop into (**Figure 2**).
- Weld in place (**Figure 3**).

