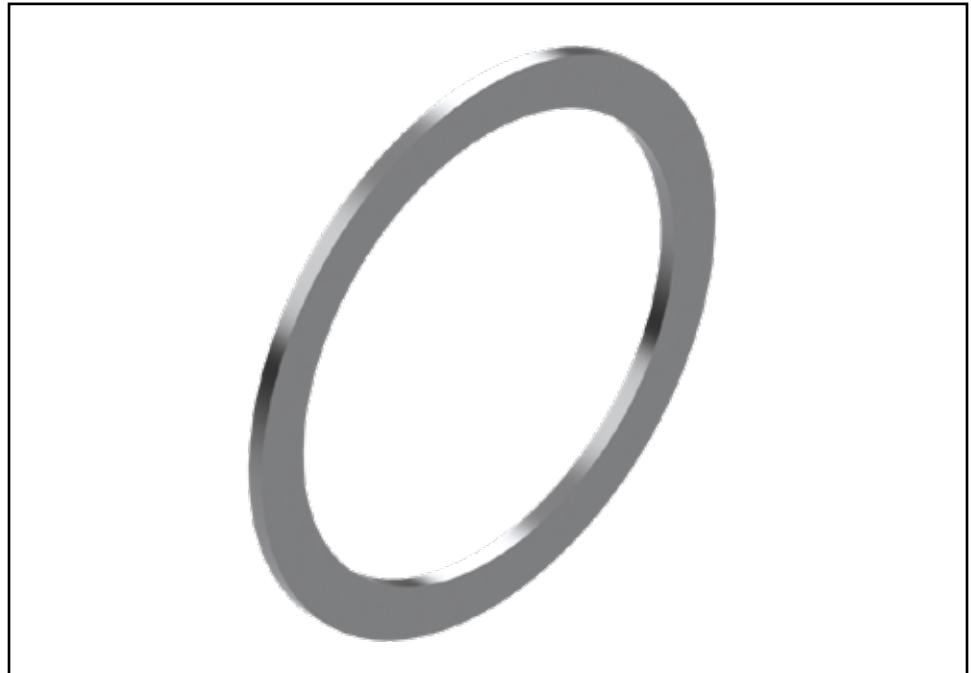


Bearing Retainer

Part No.

FD-WS-41

Ford 6R80, 280mm (Early), 6R80, 280mm (Late)



1. Disassemble

Remove bearing, stator cap, inner race, springs, rollers, outer race and any loose material on surface of stator (**Figure 1**).

2. Stator Modification

To create a modified pocket and seat for Sonnax bearing retainer turn the stator from $\text{Ø}3.670/3.660$ " to the outer diameter ($\text{Ø}4.510/4.506$ ") and remove material up to .005" below the bearing surface (**Figure 2**).

3. Assembly

- a. Place Sonnax bearing retainer in modified pocket and swedge in place (**Figure 3**).



WARNING: Ensure the top bearing face sits at least .020" above **FD-WS-41**, when installed in the impeller. No material is allowed above the top surface of **FD-WS-41**.

- b. Reassemble outer race, rollers, springs and inner race.
- c. Re-swedge stator cap in place.

