

Flanged Turbine Hub Insert

Part No.

GM-I-27FL

NOTE: For late-style GM 245mm torque converters. To convert early GM 245mm units to late-style units with **GM-I-27FL**, you must use the late-style piston and modify the early-style turbine.

GM 245mm LU (3T40, 3L30, TH200C, 4T60-E, 4L60 & E:S-10 only)



Early Turbine Modification Instructions

1. Bore a pilot diameter in the turbine 2.501–2.499" to accommodate the flanged insert.
2. Chamfer the pilot diameter at .020" x 45° for proper fit.
3. Fit **GM-I-27FL** into the pilot diameter. From the inside of the turbine, weld the insert on the outer flange diameter.
4. After the O.D. weld is completed, machine the bearing surface; an extra .010" material was added to bearing surface for this purpose. The total distance from this surface to the top of insert should be approximately 1.693".