

GM 4L60 (700-R4), 4L60-E, 200-4R (298mm NLU)

Unit Size: 10" • Core: GM 245mm • Dampened: No • Turbine Hub Input Spline Count: 27

298mm Performance Converter Kit

Part No.

GM-RK-9

- Flanged Impeller Hub
- 27-Tooth Turbine Hub
- Thrust Washer
- Front Cover Bushing (installed)
- Front Cover, Dual Bolt Pattern
- Pilot
- Mounting Pad Spacers (3)

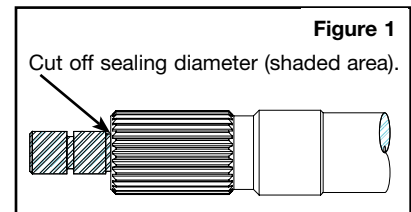
NOTE: Converts lockup converters to high performance, non-lockup converters.



1. Transmission Modification

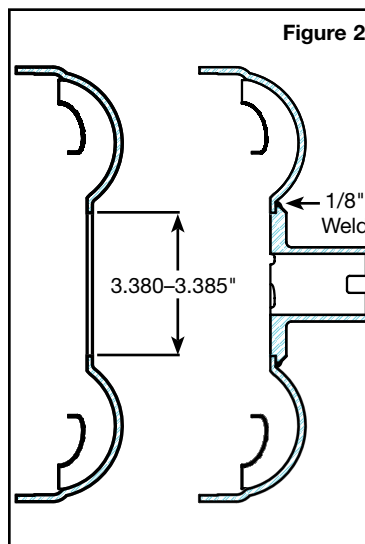
Transmissions originally equipped with lockup torque converter must be modified as follows:

- Remove end nub of the input shaft (**Figure 1**).
- TCC apply valve located in pump must be blocked or otherwise disabled.



2. Impeller Assembly (Figure 2)

- Remove stock GM 245mm impeller hub by boring a 3.380" to 3.385" dia. hole on-center in the impeller.
- Install impeller hub from the outside. Weld around O.D. of the impeller hub, ensuring it is centered on the impeller.



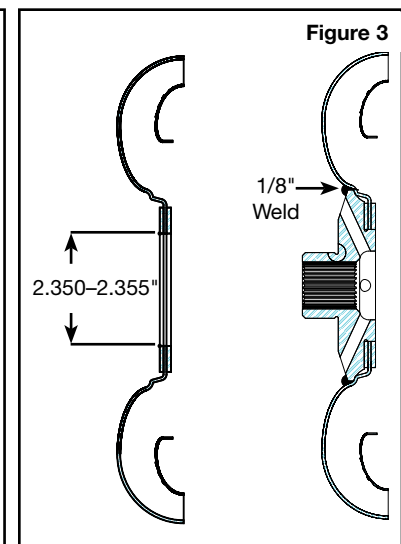
3. Turbine Assembly (Figure 3)

- Bore a 2.350" to 2.355" dia. hole on-center in the stock GM 245mm turbine. This will allow removal of OE turbine hub.

NOTE: Both flanges of the OE turbine hub assembly are retained and should not be removed.

If using Sonnax stator **GM-ST-082** or **GM-ST-086**, the stator will be .345" taller than OE stator. Approximately .345" must be removed off the turbine bearing face to correct clearances and stack height.

- Install Sonnax turbine hub into turbine from the front cover side and weld around O.D. of the turbine hub.



4. Front Cover Assembly (Figure 4)

- Apply thread locking compound to internal pilot threads.
- Screw pilot onto the threaded pilot of front cover and tighten with pin spanner.

NOTE: Sonnax mounting pad spacers **MUST** be used in order to obtain correct converter height. Spacers can be permanently attached to front cover or can be installed when bolting converter to flexplate.

5. Permanently Attach Spacers

Using a 7/16"-20 mounting bolt, secure spacer to the appropriate bolt hole of the front cover. Tack weld spacer in place, then remove bolt (Figure 5). Repeat for other mounting pads.

NOTE: The stock 298mm bolt pattern is the 10-3/4" BCD (smaller pattern in the cover). Many flexplates allow the use of both BCDs. Sonnax recommends using the largest BCD the customer's flexplate will accommodate.

6. Stator Assembly

- Install new stator race (not included in kit).
- Install new springs and rolls (not included in kit).
- Reinstall OE stator cap and snap ring.

7. Final Assembly

Continue converter assembly. Sonnax thrust washer is included for use during reassembly. Final endplay after welding should be .000" to .010", and the stator and turbine assemblies should be able to turn with minimal effort.

