



Piston/Damper Sleeve Kit

Part No.

BW-DS-1K

- BW-DS-1 Damper Sleeve
- BW-RV-2 Damper Rivets (10)

BorgWarner 310mm LU (A618)



Machining & Welding Instructions

1. To prepare the piston plate for Sonnax **BW-DS-1** sleeve installation, remove the damper assembly from the piston plate by removing the rivets.
2. Chuck the piston plate in a lathe on either the inside or outside diameter as shown (see **Figure 1** on page 2).
3. Bore the inside diameter to 2.5500"/2.5515" to accept the replacement sleeve as shown (see **Figure 1** on page 2).
4. Remove plate from the lathe and remove all the burrs.
5. Insert the sleeve on the damper side, making sure that the sleeve is held firmly against the plate with a clamping fixture (see **Figure 2** on page 2). **Figure 3** shows how to build a clamping fixture.
6. After the sleeve is welded and cooled, remove the fixture, then lightly clean the inside diameter with 600-grit emery cloth.
7. When you reassemble the damper assembly using the rivets that are supplied with the kit, make sure that you check for leaks around hub and rivets. If they leak, it will cause lockup problems and burn the clutch.



TORQUE CONVERTER Parts

PISTON/DAMPER SLEEVE KIT BW-DS-1K

Instructions

