



## Clutch Plate Fastener Kit

### Part No.

**FD-FN-6K**

- 5/16"-18 Weld Screws (6)
- 5/16"-18 Flanged Lock Nuts (6)

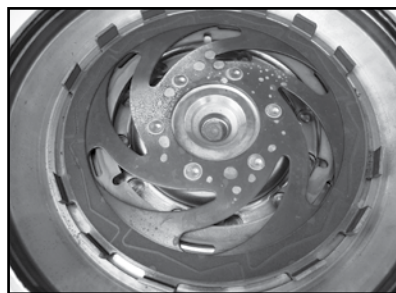
## Ford 6R60, 6R75W



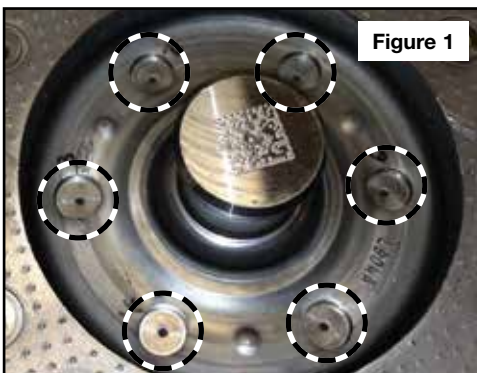
There are two versions of the Ford 6R60 torque converter clutch plate: early and late.

Using Sonnax friction plate **FD-CP-15A** instead of the early version friction plate is recommended because the six leaf springs are prone to failure.

Late Ford 6R60



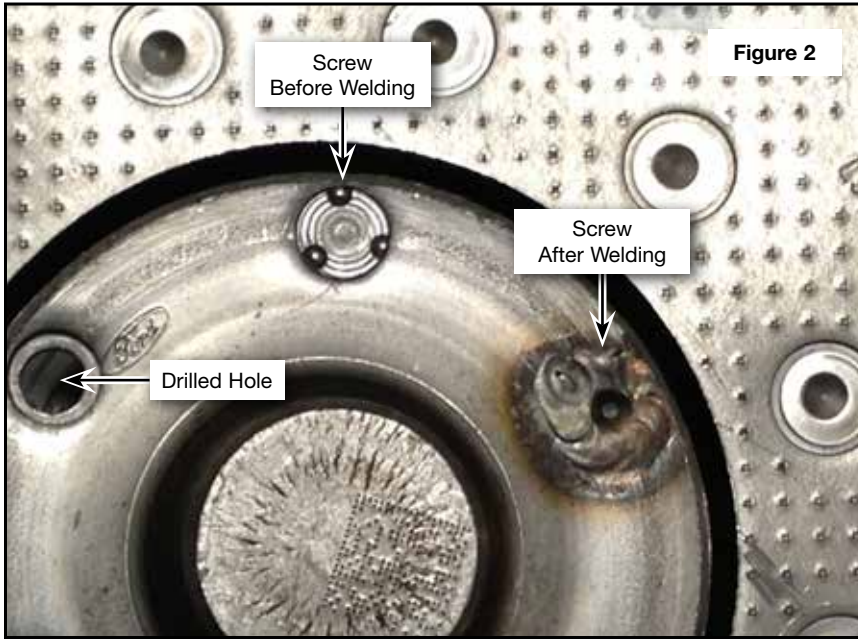
Early Ford 6R60



### 1. Disassembly

- Split the converter in half.
- On the front side of the cover, note the dimples in the center of the six pocket holes used to form the OE rivet (**Figure 1**). Use these dimples to center a 5/16" drill bit.

**NOTE:** Be careful locating the drill bit accurately and make sure the drill does not walk away from the center.



### 1. Disassembly (continued)

- c. Drill through the cover (Figure 2). The original clutch plate should fall off the cover after the last hole is complete.
- d. Turn the cover over and deburr the holes so that the clutch plate sits flat on the cover.

**NOTE:** If the original plate is to be reused, extra care is required to avoid damaging the plate or springs.

### 2. Assembly

- a. Fasten the old clutch plate on to the cover by using the six weld screws and six standard 5/16-18" nuts. This procedure is to ensure that the screws are positioned and held straight during the welding process.  
**NOTE:** Do not use the flange lock nuts provided at this time.
- b. TIG weld the six screws on to the cover (Figure 2).
- c. Remove the six nuts and old clutch plate.
- d. Install the new clutch plate using the flanged lock nuts provided (Figure 3).
- e. Torque the nuts to 11 ft-lbs. Make sure the new clutch plate is correctly oriented, otherwise the clutch plate will fail during lockup.

**NOTE:** Make sure to install the tabbed clutch plate underneath the new Sonnax clutch plate **FD-CP-15A** or the original clutch plate with new frictions.

