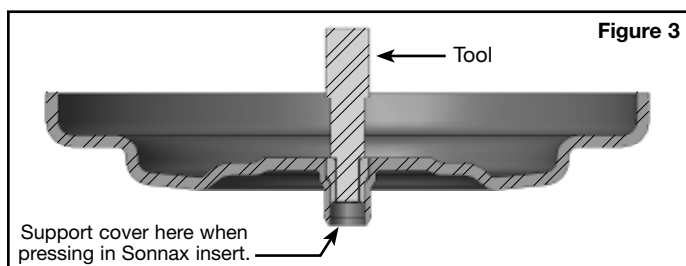
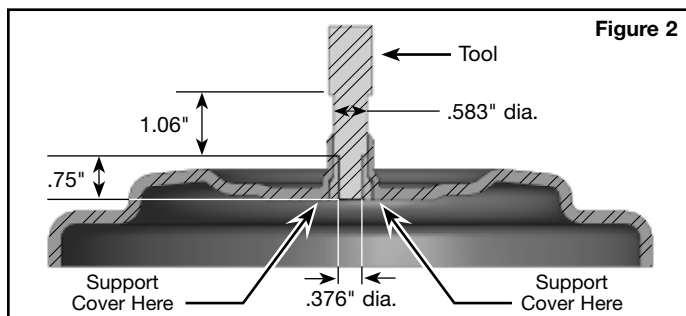
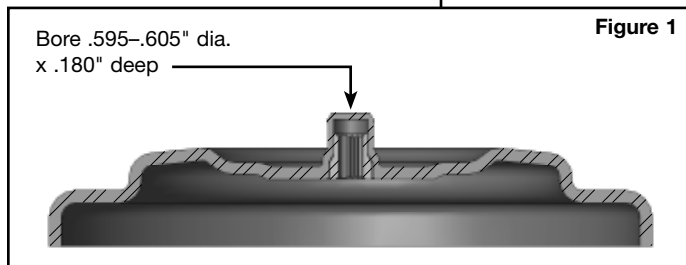


GM 258mm LU (4T65-E)

Splined Insert

Part No.

GM-I-14HS



1. Measure and record original pilot dia. then bore a .595-.605" dia. hole by .180" deep through front cover pilot from the outside, concentric to the pilot (**Figure 1**).
2. Press OE splined insert out of cover using a tool similar to that in illustration. To avoid damage, ensure cover is properly supported (**Figure 2**).
3. Flip the cover over and press in Sonnax splined insert slightly below flush using the same tool, again properly supporting the cover (**Figure 3**).
4. Carefully weld a slug into the hole, using caution to avoid applying excess heat (**Figure 4**).
5. Re-qualify pilot dia. to the original measured dia.

