



Aisin Seiki A465, AS68RC

Front Cover Hub

Part No.

AS-HB-1



1. Preparation

- a. Measure and record distance from bearing surface to mounting pads (**Figure 1**).
- b. Create a tool to center the milling tool on each of three welds that hold the OE centerpiece. This tool should be cylindrical with a .750" diameter at one end and .500" diameter at the other end to match the shank of the milling tool (**Figure 2**). The .750" section should be long enough to engage the OE centerpiece, and the .500" diameter section should be long enough to grasp in the milling machine.



NOTE: If milling tool has a shank diameter other than .500", adjust tool diameter accordingly.

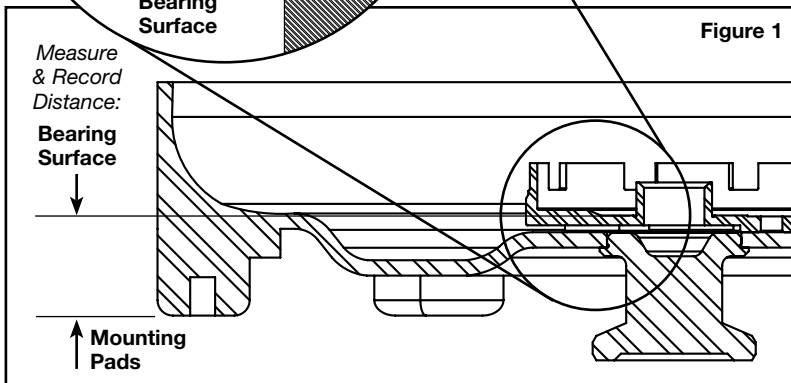
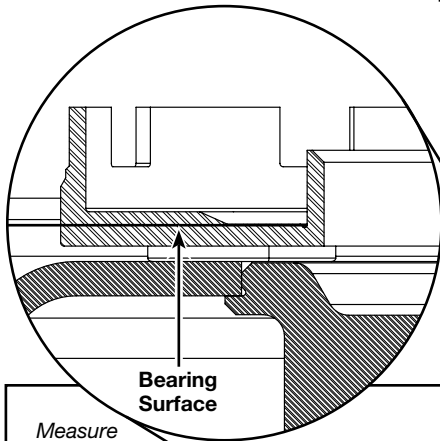


Figure 1

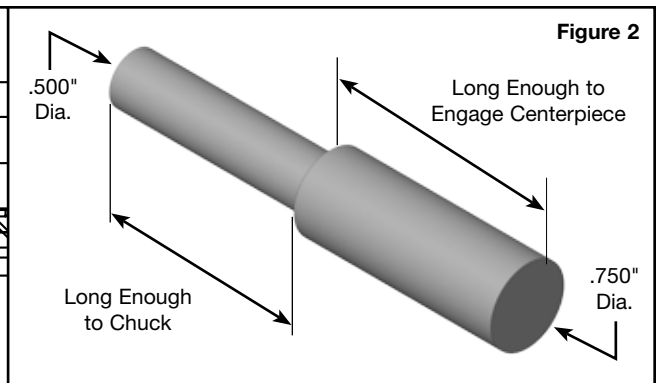


Figure 2



TORQUE CONVERTER PARTS

FRONT COVER HUB AS-HB-1

Instructions

1. Preparation (continued)

- c. Using centering tool, position mill at exact center of one of the three welds.
- d. Clamp down cover and remove centering tool.
- e. Equip a .750" diameter cobalt cutting tool. Mill away .170" to .175" of material (**Figure 3**). Repeat process for other holes to release OE centerpiece.
- f. Once OE centerpiece is removed, mill flush the three posts that remain.
- g. Machine down the remaining cover surface approximately .001" to .005" to ensure good mating with Sonnax hub. The cover's flat surface should be approximately 4.000" diameter, on center.



Figure 3

2. Installation & Assembly

- a. Assemble piston into cover with inner and outer seal rings.



NOTE: Lube is permissible on outer piston seal, but do **NOT** use lube on the inner piston seal at this time because it will cause weld contamination. The inner seal must be dry at this stage.

- b. Position Sonnax hub into place and measure from bearing surface to mounting pads. This measurement must be the same as the OE distance recorded during step "a" in "Preparation" section (**Figure 1**).



NOTE: To achieve exact spacing, material can be removed from the three mounting surfaces of the Sonnax hub **OR** from the cover surface.

- c. Once Sonnax hub is in place and dimensions are correct, tack weld all three holes of the hub onto the cover.
- d. Remove piston before the finish-welding process.
- e. Finish-weld (TIG only) the three diameters in place.



WARNING: Weld just one diameter at a time, then allow the piece to cool completely before starting next weld. Repeat process for all three welds. Failure to follow this process will result in overheating the critical inner wall of the hub.