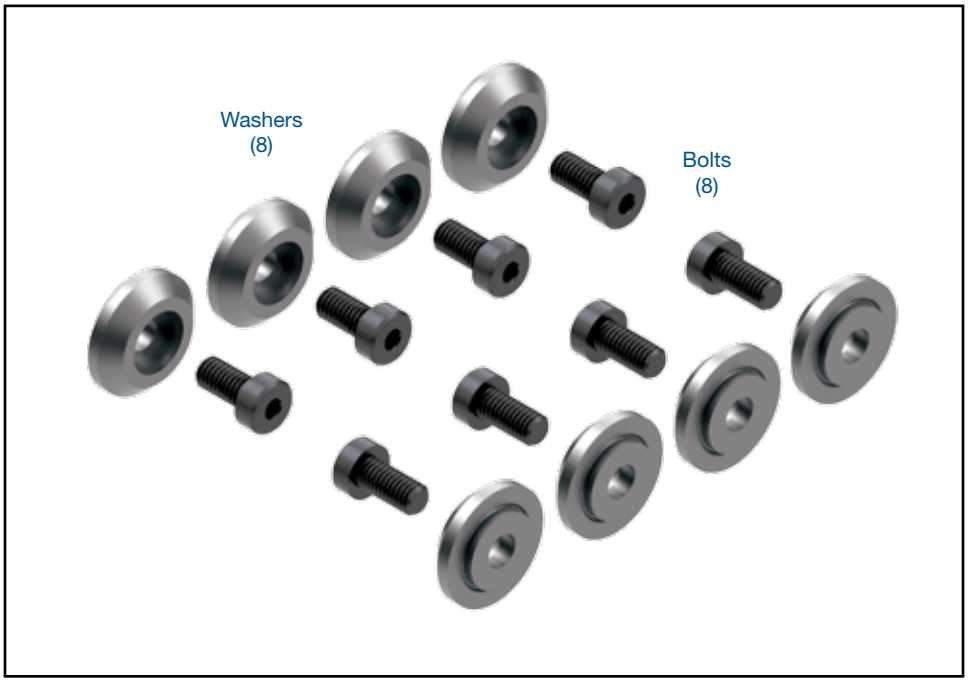
Mercedes 722.9 (Late)

Bolt & Washer Kit

Part No.
MB-FN-2K

- Bolts (8)
- Washers (8)



1. Disassembly

a. Separate converter halves

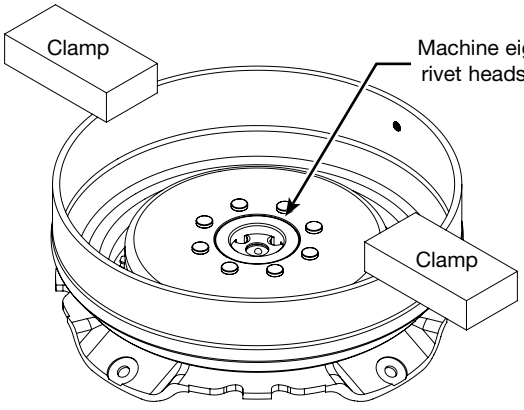
b. Clamp front cover to machine table (**Figure 1**).

c. Carefully machine eight indicated OE rivets flush, using caution to remove as little material as possible from the piston plate (**Figure 1**).

d. Remove piston plate, frictions, steels, seals and wave springs.

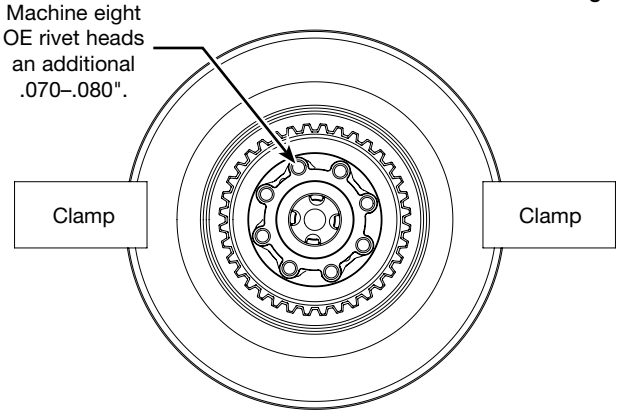
e. Machine eight rivet studs an additional .070–.080" (**Figure 2**).

Figure 1



Mercedes 722.9 (Late) Converter Half

Figure 2



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TORQUE CONVERTER PARTS

BOLT & WASHER KIT MB-FN-2K

Instructions

1. Disassembly (continued)

f. Using piston plate and one washer as a template, drill one stud with 4.2mm drill x .422" depth. (**Figure 3**).

g. Remove piston plate and washer. Tap one stud using M5 x 0.8 bottoming tap, thread depth .375".

h. Install piston plate, one washer and one bolt. Use remaining seven washers and piston plate as drill template. Drill seven remaining studs, 4.2mm drill x .422" depth (**Figure 4**).

i. Remove bolt, washers and piston plate. Tap remaining seven studs using M5 x 0.8mm bottoming tap, thread depth .375" (**Figure 5**).

2. Installation & Assembly

a. Install steels, frictions, wave springs, seals and piston plate.

b. Install Sonnax washers and bolts. Apply Loctite® to bolt threads and torque to 6 NM (**Figure 6**).

Figure 3

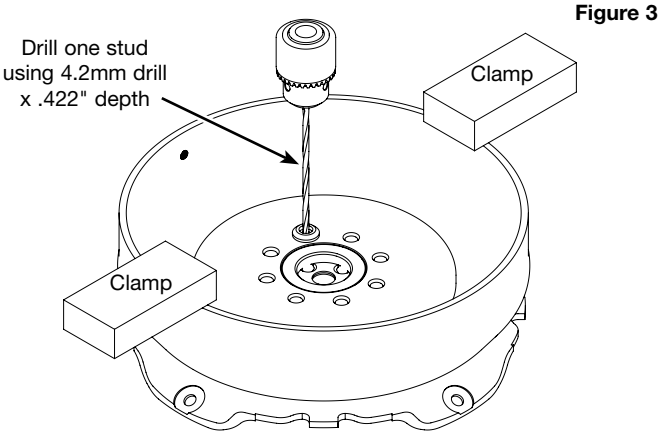

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Figure 4

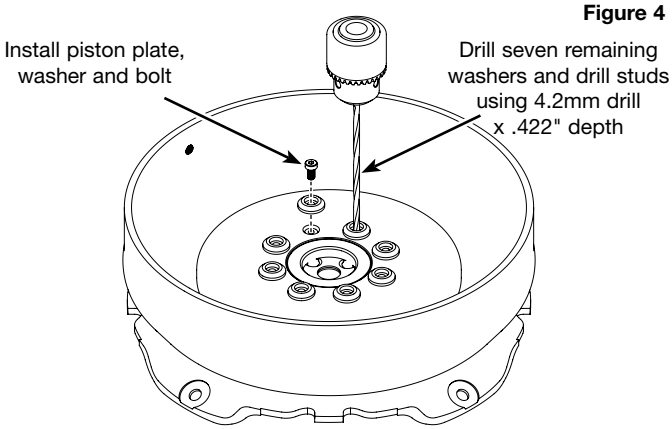

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Figure 5

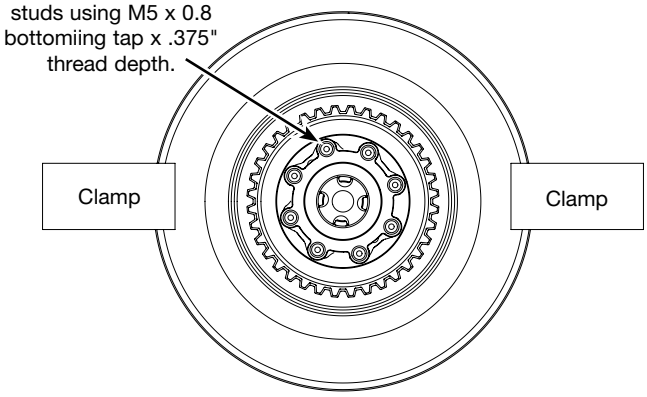

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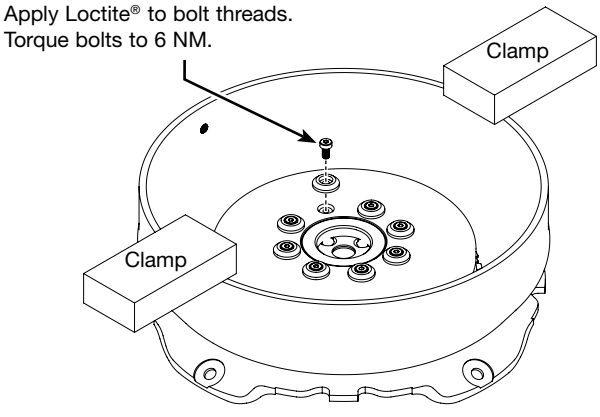
Figure 6



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