



GM 4L60-E (300mm), 6L80, 400, AT-540, BW 310mm LU

Outer Stator Race

Part No.

GM-R-15

Applications

- GM 4L60-E (300mm) & 6L80
- Conversion for Chrysler BW 310mm LU (A618), GM 400 (3L80), AT-540 & Buick 350

Associated Parts

- **GMBW-WS-40** Conversion Spacer
- **GM-S-11** Accordion Spring
- **GM-RO-572** Roller
- **GM-HR-2** Inner Stator Race, GM 300mm & GM 298mm
- **GM-HR-1** Inner Stator Race, BW 310mm LU (A618), GM 400 (3L80), AT-540 & Buick 350

Sonnax outer stator race **GM-R-15** and conversion spacer **GMBW-WS-40** can be used with the GM 4L60-E (300mm) and 6L80 springs and rollers for a cost-effective upgrade to BW 310mm LU (A618), GM 400 (3L80), AT-540 and Buick 350 stator clutch assemblies. The upgrade repairs and improves the performance of OE stator cams with problematic roller clutch design.



Conversion Spacer
GMBW-WS-40



Conversion Instructions

1. Remove the outer stator race, spring retainer, springs, rolls and inner stator race from the stator.
The spring retainer is no longer used with the conversion.
2. Modify the stator by milling five slots into the stator using a 3/8" end mill (**Figure 1**).
3. Drop the **GMBW-WS-40** conversion spacer into stator (**Figure 2**).
4. Drop in the GM 300mm outer stator race **GM-R-15** and MIG-weld in place at the end of the slots (**Figure 3**).
5. Reassemble the stator clutch using the springs **GM-S-11** and rollers **GM-RO-572** from the GM 300mm unit and the inner stator race **GM-HR-1** from the original stator.

Figure 1

Five slots milled into the stator using a 3/8" end mill.

Figure 2

Figure 3

