



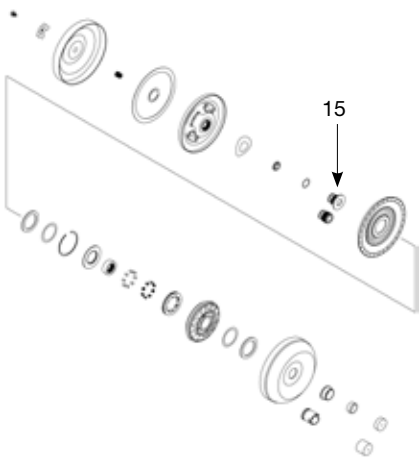
Flanged Turbine Hub Insert

Part No.

GM-I-27FL

Illustration Reference

GM-I-27FL is item number 15 below. For detailed illustration, visit www.sonnax.com.



GM 245mm



The **GM-I-27FL** is a flanged turbine hub insert for late style GM 245mm torque converters. To convert early GM 245mm units to late style units with **GM-I-27FL**, you must use the late-style piston and modify the early style turbine.

Early Turbine Modification Instructions

1. Bore a pilot diameter in the turbine 2.501"/2.499" (63.53mm/63.47mm) to accommodate the flanged insert.
2. Chamfer the pilot diameter at .020" (.51mm) x 45° for proper fit.
3. Fit **GM-I-27FL** into the pilot diameter. From the inside of the turbine, weld the insert on the outer flange diameter.
4. After the O.D. weld is completed, machine the bearing surface; an extra .010" (.25mm) material was added to bearing surface for this purpose. The total distance from this surface to the top of insert should be approximately 1.693" (43.00mm).