

#### Part No.

**GM-ST-082**

1 Stator

#### INSTRUCTIONS

The **GM-ST-082** stator is designed for GM 245mm cores and allows the use of Sonnax mechanical diodes (**GM-MD-3**, **GMFD-MD-1**, **CH-MD-1**) or Sonnax sprag cartridges (**GM-CS-3**, **FD-CS-2**, **CH-CS-1**). This stator assembly will be approximately .345" taller than the stock GM 245mm stator assembly when used with the following Sonnax one-way clutches and components:

**GM-MD-3** (with **GM-WA-15**, **GM-WS-7** stator caps and **CH-N-1** thrust bearings)

**GMFD-MD-1** (with **GM-WA-26**, **GM-WS-28** stator caps and **CH-N-1** thrust bearings)

**CH-CS-1** (with **CH-N-1** thrust bearings)

**FD-CS-2** (with **CH-N-1** thrust bearings)

**GM-CS-3** (with **CH-N-1** thrust bearings)

**NOTE:** When used with Sonnax Racekits, the turbine assembly **MUST** be modified.

#### TURBINE ASSEMBLY INSTRUCTIONS:

- Center the turbine in a lathe and bore a 2.350/2.355" diameter hole (see Figure 1).

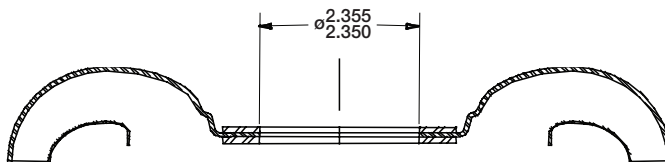


Figure 1

- Fixture the hub and weld (see Figure 3).

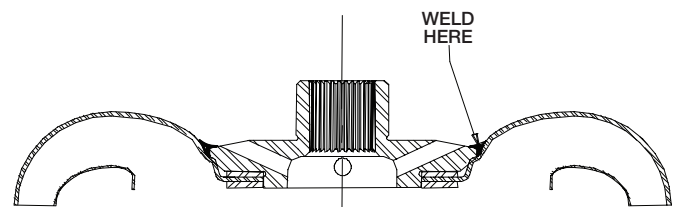


Figure 3

- Insert the turbine hub into the turbine (see Figure 2).

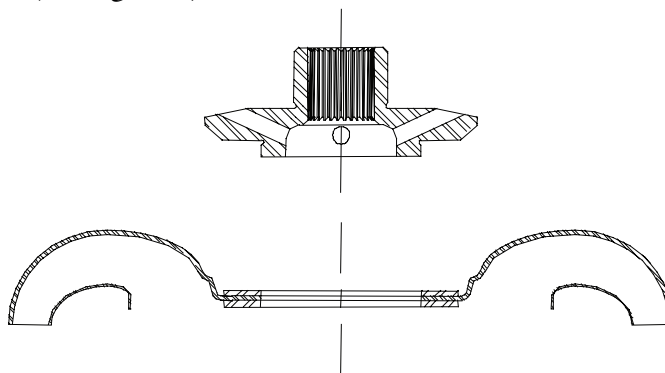


Figure 2

- Machine .345" from the stator bearing face of the turbine assembly (see Figure 4).

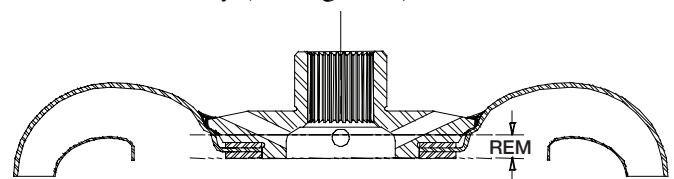


Figure 4

From this point on, the Racekit will assemble normally.

**Note:** If you use different components other than those included in Sonnax Racekits and Sonnax one-way clutches, the amount of machining can vary. In these cases the builder will need to measure and determine how much material must be removed and from which surfaces.