



## Outer Stator Race

**Part No.**  
**GM-R-15**

### Application

Conversion for BW 310mm LU  
(A618), GM 400 (3L80), AT540, &  
Buick 350

## GM 300mm LU, 4L60-E



The **GMBW-WS-40** conversion spacer is used with the GM 300mm outer stator race, springs and rolls to upgrade BW 310mm LU (A618), GM 400 (3L80), AT540, and Buick 350 stator clutch assemblies. The upgrade repairs and improves the performance of OEM stator cams with problematic roller clutch design. Use **GMBW-WS-40** spacer with the Sonnax outer stator race **GM-R-15** to provide a cost-effective upgrade.

### 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 as shown in figure 1.
3. Drop the **GMBW-WS-40** conversion spacer into Stator as shown in 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 as seen in figure 3.
5. Re-assemble 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.

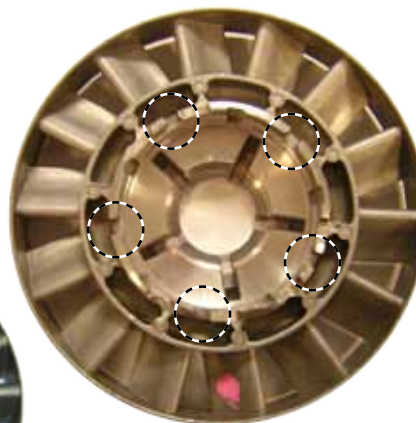
Figure 2



Figure 3



Figure 1



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