

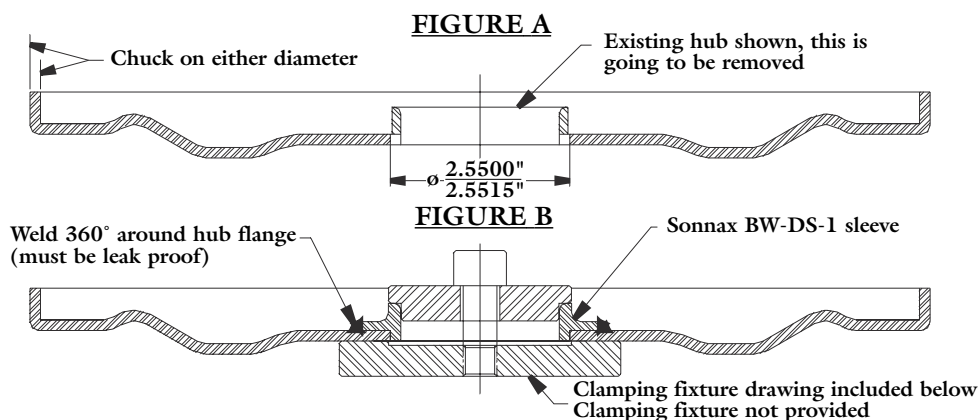


TORQUE CONVERTER PARTS

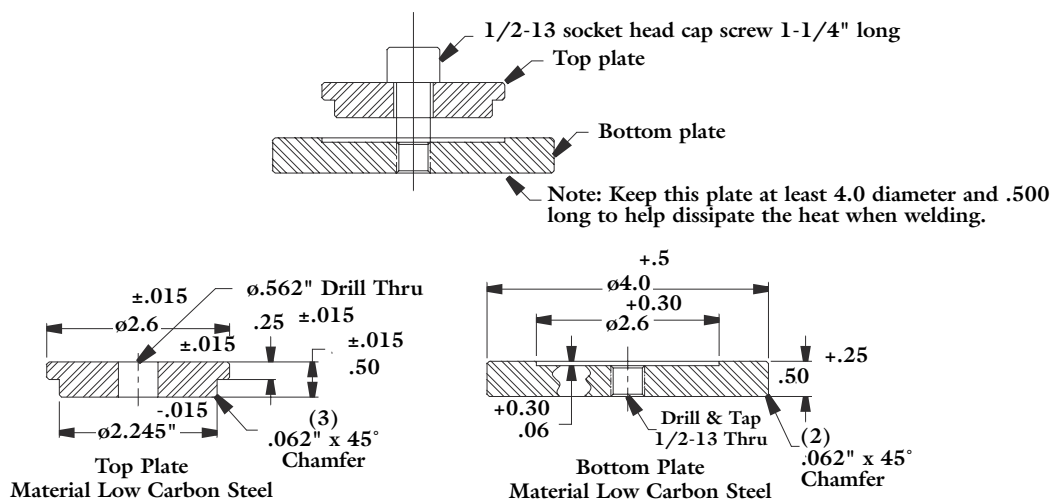
BW-DS-1K

PISTON/DAMPER SLEEVE KIT

MACHINING AND WELDING INSTRUCTIONS



CLAMPING FIXTURE DRAWING



INSTALLATION

1. To prepare the piston plate for Sonnax BW-DS-1 sleeve installation, remove the damper assembly from the piston plate by removing the rivets.
2. Chuck the piston plate in a lathe on either the inside or outside diameter as shown (see figure A).
3. Bore the inside diameter to $2.5500"/2.5515"$ to accept the replacement sleeve as shown.
4. Remove from the lathe and remove all the burrs.
5. Insert the sleeve on the damper side, making sure that the sleeve is held firmly against the plate with a clamping fixture (see Figure B).
6. After the sleeve is welded and cooled, remove the fixture, then lightly clean the inside diameter with 600-grit emery cloth.
7. When you reassemble the damper assembly, using the rivets that are supplied with the kit, make sure that you check for leaks around hub and rivets. If they leak, it will cause lockup problems and burn the clutch.