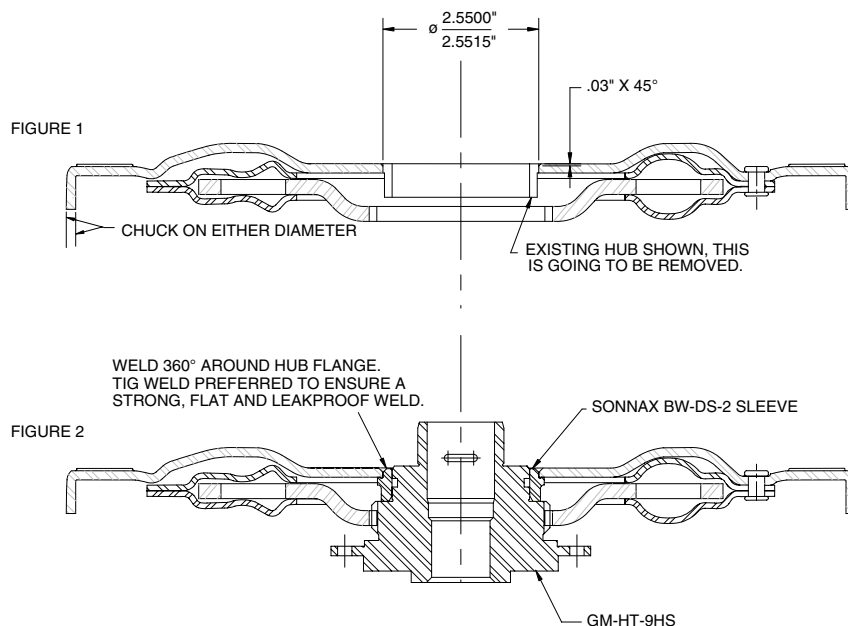




TORQUE CONVERTER PARTS

BW-DS-2

PISTON / DAMPER REPAIR SLEEVE



INSTALLATION INSTRUCTIONS

Preparing the piston plate for Sonnax **BW-DS-2** sleeve installation.

1. Chuck the piston plate in a lathe on either the inside or outside diameter as shown (see Figure 1).
2. Bore the inside diameter to 2.5500"/2.5515" and add chamfer to accept the replacement sleeve as shown (see Figure 2).
3. Remove from the lathe and remove all the burrs.
4. Insert the sleeve on the damper side, being sure that the sleeve is held firmly against the plate using a **GM-HT-9HS** turbine hub as a locating fixture (shown in Figure 2).
5. After the sleeve is welded and cooled remove the fixture, then lightly clean the inside diameter with 600-grit emery cloth.