



FD-RK-3, -3S, -4, -9

FORD C4 & C6 RACEKITS

HIGH PERFORMANCE TORQUE CONVERTER PARTS

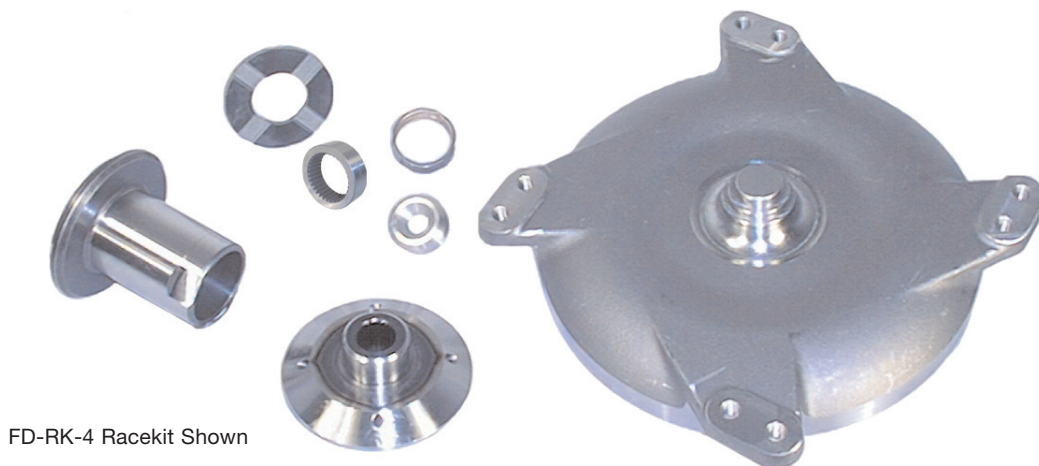
Part Nos.

FD-RK-3, -3S

C4 Racekit (5 $\frac{1}{16}$ " stack height)

Includes:

- 1 Impeller Hub
- 1 Stator Race
- 1 Turbine Hub
- 1 Thrust Washer
- 1 Front Cover Bushing
- 1 Front Cover
- 1 Front Cover Pilot
- 4 Cap Screws
- 4 Stud Covers



FD-RK-4 Racekit Shown

FD-RK-4

C6 Racekit Includes:

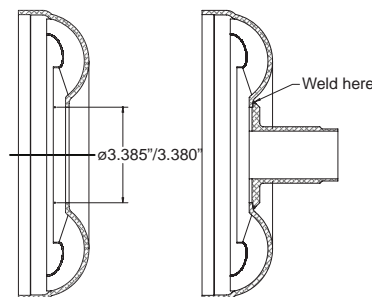
- 1 Impeller Hub
- 1 Stator Race
- 1 Turbine Hub
- 1 Thrust Washer
- 1 Front Cover Bushing
- 1 Front Cover
- 1 Front Cover Pilot
- 4 Cap Screws
- 4 Stud Covers

INSTRUCTIONS:

IMPELLER ASSEMBLY (SEE FIGURE 1)

1. Remove the stock GM 245mm impeller hub by boring a 3.380"/3.385" diameter hole on center in the stock GM 245mm impeller.
2. Install the impeller hub from the outside. Make sure the impeller hub and impeller run concentric. Weld around the OD of the impeller hub as shown.

Figure 1



FD-RK-9

C4 Racekit (5 $\frac{1}{16}$ " stack height)

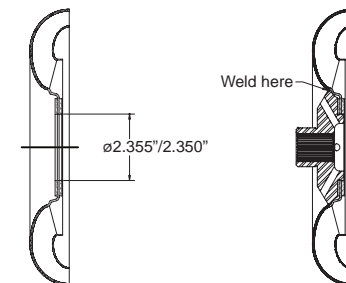
Includes:

- 1 Impeller Hub
- 1 Stator Race
- 1 Turbine Hub
- 1 Thrust Washer
- 1 Front Cover Bushing
- 1 Front Cover
- 4 Cap Screws
- 4 Stud Covers

TURBINE ASSEMBLY (SEE FIGURE 2)

1. Bore a 2.350"/2.355" diameter hole on center in the stock GM 245mm turbine. This will remove the OEM turbine hub.
- Note:** Both flanges of the OEM turbine assembly are retained and should **NOT** be removed.
2. Install the turbine hub into the turbine from the front cover side. Weld around the OD of the turbine hub.

Figure 2



STATOR ASSEMBLY

Install the conversion stator race included with the kit as well as new springs and rolls. Install the stator cap and snap ring.

Ford C4 & C6 Racekits**FRONT COVER ASSEMBLY (SEE FIGURE 3)**

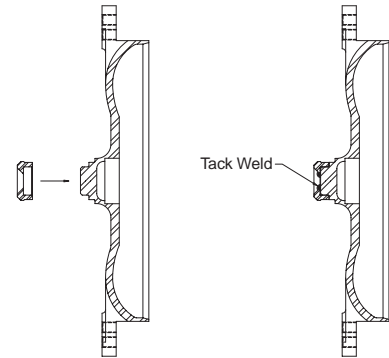
1. Press the pilot onto the center boss of the front cover. Tack weld the pilot in place on the ID of the pilot.

NOTE: The Ford 11" C4 racekit has an integral pilot and does not require this step.

2. Install the socket head cap screws from the impeller side into the appropriate bolt pattern. Use Loctite[™] on the cap screws.

NOTE: When using the smaller bolt pattern, the screws cannot be installed after the entire converter has been assembled.

OPTIONAL: The Sonnax Ford front covers and turbine hubs have been designed to use a front cover bushing for better support of the turbine assembly. If you wish to run the bushing, you will need to press it into the front cover.

Figure 3**FINAL ASSEMBLY**

Assemble all the components and use the front cover thrust washer included in the kit (optional bearing available, order 1-**MI-N-15** bearing and 2-**MI-N-16** races). Final endplay, after welding, should be between 0 and .010" and the stator assembly and turbine assembly should be able to turn with minimal effort.