

GM 6L80, 6L90

High Capacity 4-5-6 Clutch Apply Piston Kit

Part No.

104960-20K

- Apply Piston
- Piston Dam
- Apply Plate
- Backing Plate

Patent Pending



NOTE: Not for use with OE type clutches. Must be used with aftermarket 45-tooth Powerglide style frictions and related steels and corresponding 45-tooth 4-5-6 hub shaft.



1. Clutch Assembly Information

OE recommended clutch clearance is .008–.012" per friction. See list of selective retaining rings for adjusting clutch clearance (**Figure 1**).

2. Disassembly

- Dismantle 4-5-6 clutch assembly using OEM recommended methods and procedures.
- Discard OE apply piston, piston dam, waved plate and backing plate, clutches and steels.

3. Installation & Assembly (Refer to **Figure 2** on page 2)

- Install Sonnax apply piston into housing assembly.
- Reinstall OE clutch return spring.
- Install Sonnax piston dam. Using appropriate tools, compress piston dam just far enough to allow OE piston dam retaining ring installation.



WARNING: Use care to avoid damaging inner and outer sealing lips on piston dam. Compressing the piston dam too far will cause inner seal lip damage.

- Install Sonnax piston apply plate (**Figure 2**).
- Assemble 4-5-6 clutch pack with with aftermarket 45-tooth Powerglide style frictions and related steels.
- Install Sonnax backing plate.
- Reinstall or replace OE backing plate retaining ring.



NOTE: OE retaining ring is selective and is available in varying thicknesses to allow for proper setting of clutch clearance (**Figure 1**).

Backing Plate Selective Retaining Rings

Figure 1

GM Part No.	Thickness	Color
24233407	.063–.067"	Yellow
24233408	.080–.083"	None
24233406	.096–.100"	Purple

Figure 2

