

**Installation Instructions for 603301
Input Drum Reinforcement
For GM 4L60, 4L60-E, 4L65-E & 4-70-E Transmissions**

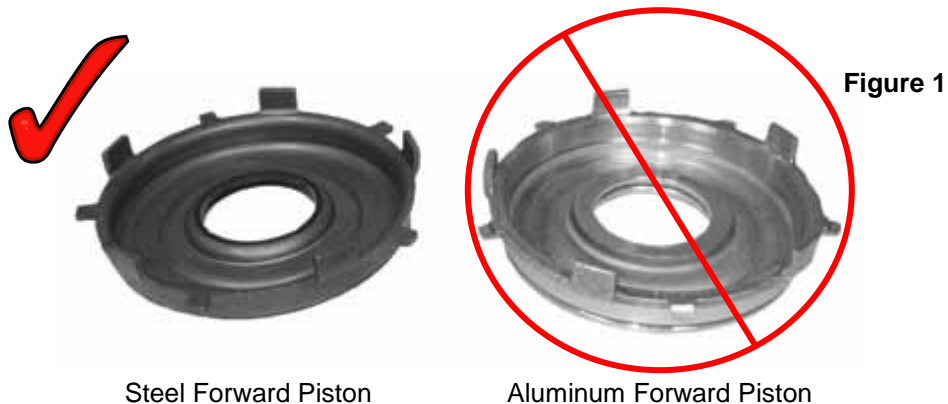


1. Sleeve Installation

- a. Inspect the drum for cracks or damage. This sleeve will not repair a cracked drum. Set the input drum into a hydraulic press (or arbor press). Use an appropriate sized tube or a spare (not to be reused) 4L60 stator shaft with the selective spacer (with bearing left out) to support the aluminum housing directly under the area being pressed on. A 4L60-E rear sun gear works well to drive the sleeve on.

CAUTION: Not supporting the drum directly under the sleeve can result in damage to the shell.

- b. Refer to photo shown above. Clean the reinforcement sleeve area and take note of the overrun clutch feed hole location.
- c. Thoroughly clean the reinforcement sleeve.
- d. Coat the inside of the sleeve with green Loctite® 609. With the tabs located toward the inside of the drum, line up the overrun clutch oil feed hole between the sleeve tabs. Then set the sleeve into position on the input drum.
- e. Using the press, install the sleeve until just barely seated. Do not seat the sleeve with the full force of the press since excessive force will ruin the housing. Do NOT hammer or pound the sleeve into place.



Steel Forward Piston

Aluminum Forward Piston

2. Input Drum Assembly

- a. Can be installed in early & late model transmissions, but requires a 1997-up stamped steel forward piston – see Figure 1.

NOTE: A recommended measure before installation is to seat the checkball in the overrun piston with a small punch.

- b. If using a late-model return spring assembly (identified by two spring retainers on both ends of the springs), remove and discard the lower spring retainer (Figure 2). Although not required, the early-style return spring used with OE aluminum pistons is about 10% stronger and is preferred for high RPM applications.
- c. Assemble input drum as usual.

Note: Three lip seals are included for use with aftermarket gasket and seal kits which do not include these seals.



Figure 2