

GM 6L80

Extreme Duty 4-5-6 Clutch Hub & Intermediate Shaft

Part No.

104680-45

Patent Pending

NOTE: Use with Powerglide-style, 45-tooth frictions, Sonnax steels and high capacity piston kit **104960-20K**. OE Part No. 24238004.



Instructions

This shaft has a smaller diameter hub with 45 teeth that is intended for use with Powerglide style clutches and special steels. It also requires use of apply and backing plate with smaller inner diameter. See Sonnax parts:

- **104120-01** 4-5-6 Clutch Steel, Wide .080" thick
- **104120-02** 4-5-6 Clutch Steel, Wide .090" thick
- **104120-03** Clutch Friction, BW HE .060" thick
- **104960-20K** High Capacity 4-5-6 Clutch Apply Piston Kit

Reference Stack-Up with 104960-20K			6L80	6L90
104120-03	Friction	.060"	7	8
104120-02	Steel	.090"	5	4
104120-01	Steel	.078"	1	3

NOTE: See page 2 for Instructions.

Special Tools

- DT-47868-1 - Clutch Travel Weight / 10 lbs

Instructions

Before checking clutch clearance, soak clutches in fluid for 15 minutes. Install clutches and steels into 4-5-6 housing and apply clutch pack several times with compressed air.

1. Place clutch travel weight onto 4-5-6 backing plate (**Figure 2**).
2. Position dial indicator to read clutch travel weight movement.
3. Apply 4-5-6 clutch with compressed air.
4. Clutch clearance .008-.012" per friction, adjust by changing retaining ring or using different thickness steels (**Figure 3**).

4-5-6 Clutch

Figure 3

OE Part No.	Retaining Ring Thickness	Color
2423407	.063-.067"	Yellow
2423408	.080-.083"	None
2423406	.096-.100"	Purple

Sonnax Part No.	Steel Thickness	Color
104120-01	.078"	None
104120-02	.090"	None

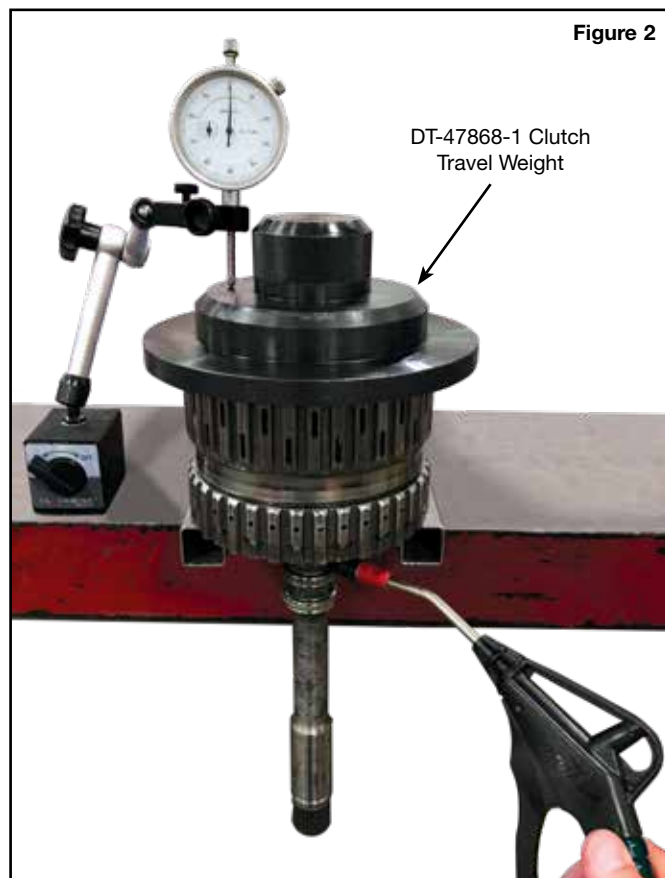


Figure 2

DT-47868-1 Clutch Travel Weight