

Ring Gear Stabilizer Kit

Part No.
28510-S1

- Ring Gear Stabilizer Race
- Bearing Buttons (5)

Patent Pending

NOTE: For 1.82 ratio stamped steel carriers only.

GM Powerglide[®]

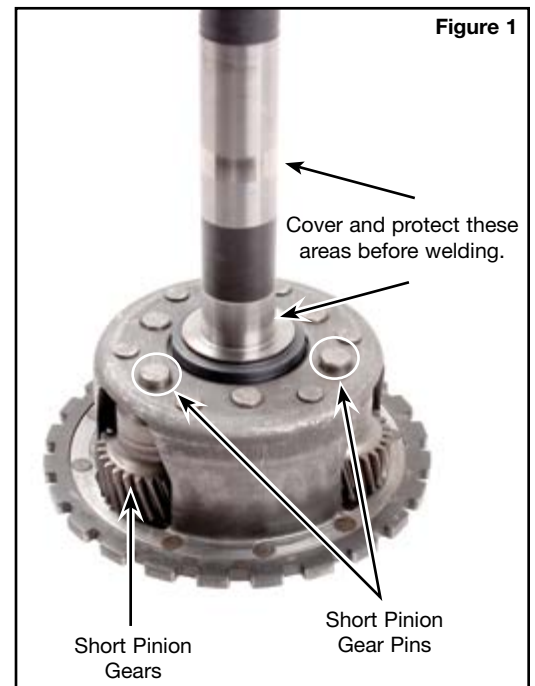


NOTE: The following tools are required to install this ring gear stabilizer kit.

- Three 4" C-clamps
- 1/8" drill bit
- 1/4" drill bit
- Welder, MIG or TIG

1. Ring Gear Stabilizer Race Installation

- Wrap output shaft journals and thrust bearing surface to protect from weld-spatter (**Figure 1**).
- Inspect rear surface of stamped carrier housing and remove any high spots or burrs.
- Sonnax ring gear stabilizer race is aligned to three pins of the short pinion gear (gears visible from outside of housing).
- Remove three screws from pin retainer plate from front of carrier.

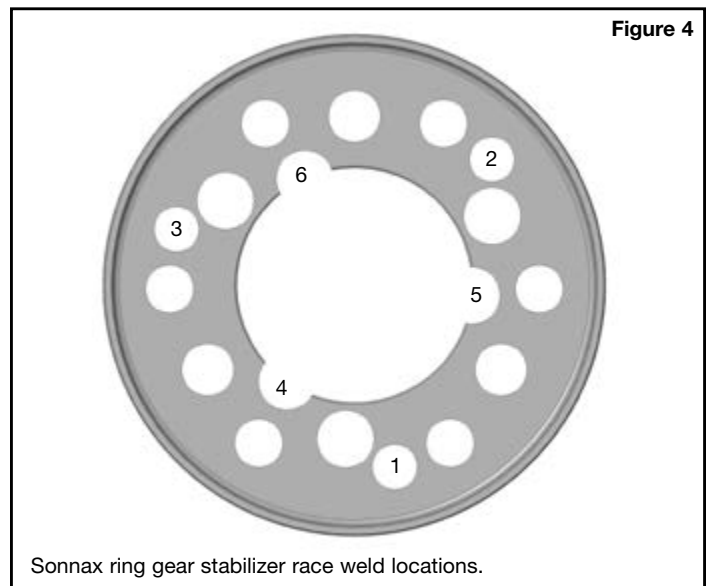
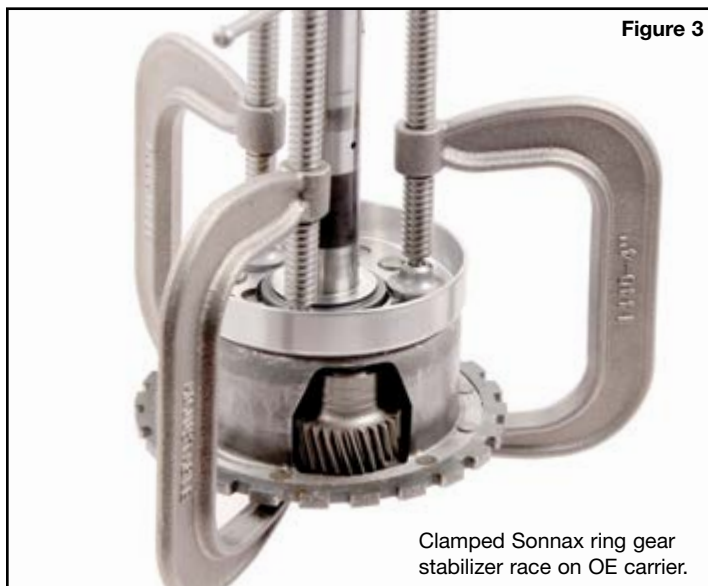
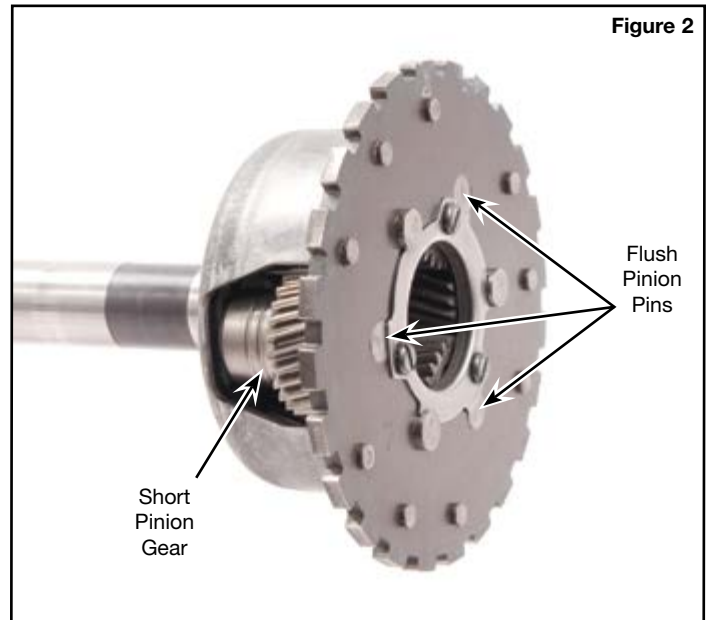


1. Ring Gear Stabilizer Race Installation continued

- e. Push three short pinion gear, pinion-pins rearward $\frac{1}{8}$ " until flush with front of OE carrier and slightly protruding from rear of carrier (**Figure 2**).
- f. Temporarily reinstall retainer plate to hold other three pins in location as Sonnax ring gear stabilizer race installation is completed (**Figure 2**).
- g. Place ring gear stabilizer race over three pins protruding from rear of carrier.
- h. Clamp ring gear stabilizer race in place using three C-clamps (**Figure 3**).
- i. Weld three outer locations (1, 2 and 3), then remove C-clamps and weld three inner locations (4, 5 and 6, **Figure 4**).

NOTE: Use appropriate, but not excessive, heat and weld times.

- j. Remove retainer plate, push three pins back into position and reinstall retainer plate.



2. Ring Gear Preparation

- Mark a line $\frac{3}{8}$ " from the rear end of the OE ring gear around the outside of the ring gear clutch splines (**Figure 5**).
- Use a center punch to create an indent in the middle of one of the clutch splines at the line that is $\frac{3}{8}$ " from the end of the ring gear.
- Move over five splines and repeat (there should be four regular splines between each pair of marked splines).
- Drill a $\frac{1}{8}$ " pilot hole through the five indented splines.
- Re-drill pilot holes with a $\frac{1}{4}$ " drill bit (**Figure 6**).
- Insert five bearing buttons from the inside (**Figure 7**).

3. Final Assembly

Use normal assembly procedures.

