

GM Powerglide[®]

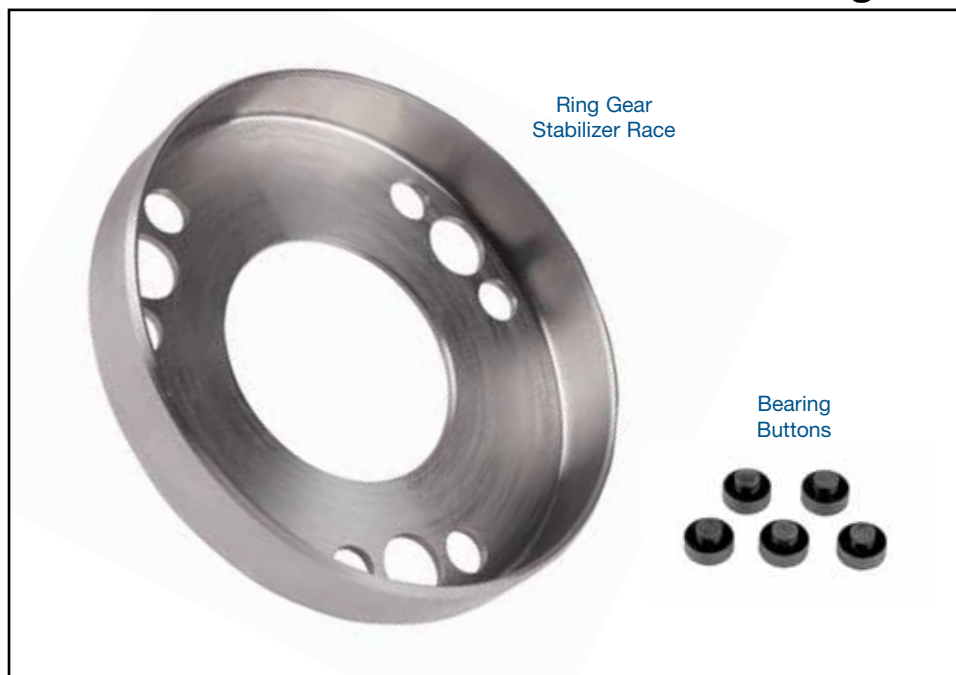
Ring Gear Stabilizer Kit

Part No.
28510-S2

- Ring Gear Stabilizer Race
- Bearing Buttons (5)

Patent Pending

NOTE: For Sonnax 1.69 and 1.80 ratio bolt-together carriers only.

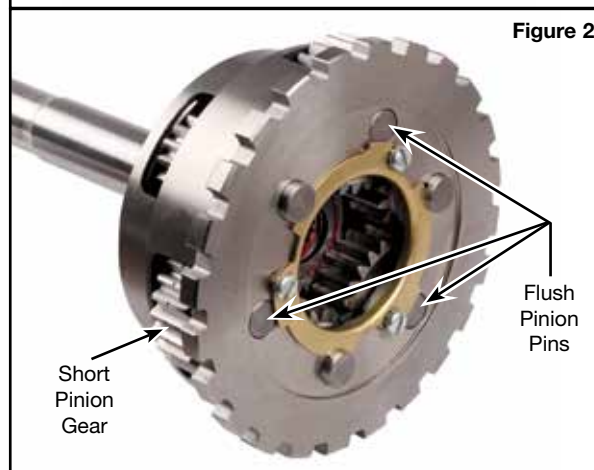
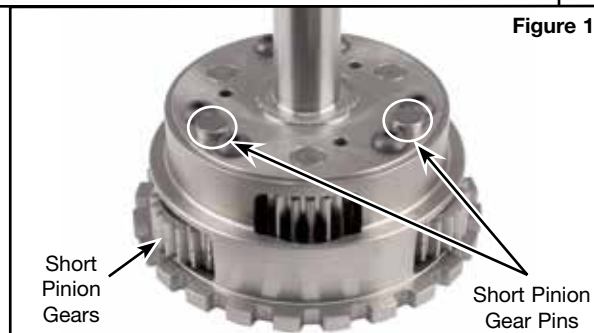


NOTE: The following tools are required to install this ring gear stabilizer kit.

- 1/8" drill bit
- 1/4" drill bit

1. Ring Gear Stabilizer Race Installation

- Sonnax ring gear stabilizer race is aligned to three pins of the short pinion gears (**Figure 1**).
- Remove three screws from pin retainer plate from front of carrier.
- Push three short pinion gear, pinion-pins rearward 1/8" until flush with front of carrier and slightly protruding from rear of carrier (**Figures 1 & 2**).
- Temporarily re-install retainer plate to hold other three pins in location as Sonnax ring gear stabilizer race installation is completed (**Figure 2**).
- Place ring gear stabilizer race over three pins protruding from rear of carrier.
- Bolt in place using six bolts supplied with carrier.
- 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 ring gear around the outside of the ring gear clutch splines (**Figure 3**).
- 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 4**).
- Insert five buttons from the inside (**Figures 5 & 6**).

3. Final Assembly

Use normal assembly procedures.

