sonnax®
PERFORMANCE

HIGH PERFORMANCE **TRANSMISSION** PARTS

Instructions

GM Powerglide®

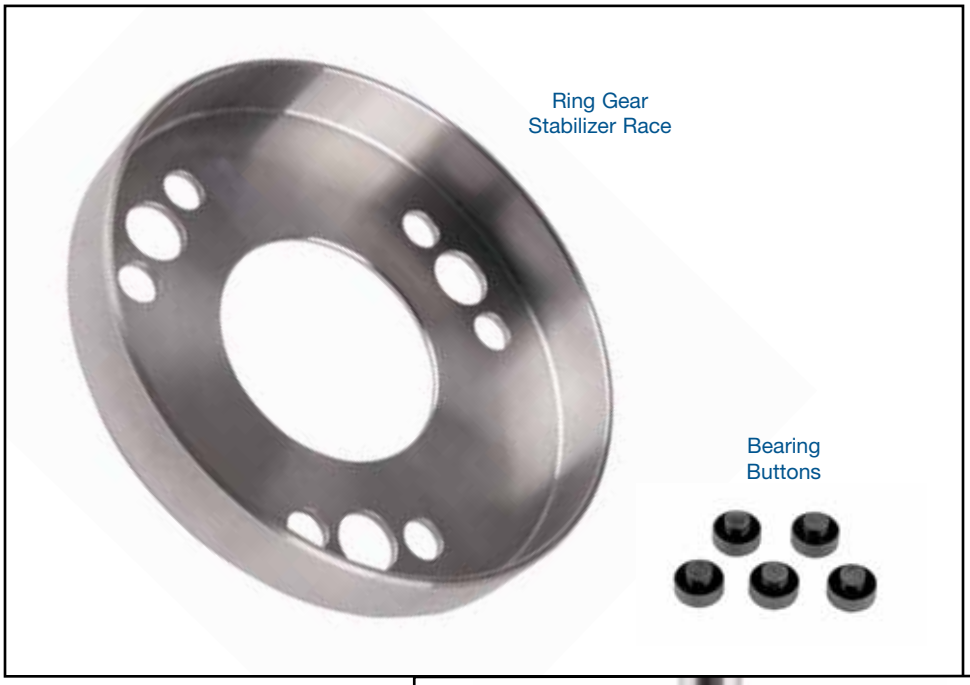
Ring Gear Stabilizer Kit

Part No. 28510-S3

- Ring Gear Stabilizer Race
- Bearing Buttons (5)

Patent Pending

NOTE: For Sonnax 1.58 and 1.65 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

a. Sonnax ring gear stabilizer race is aligned to three pins of the short pinion gears (**Figure 1**).

b. Remove three screws from pin retainer plate from front of carrier.

c. Push three short pinion gear, pinion-pins rearward ⅛" until flush with front of carrier and slightly protruding from rear of carrier (**Figures 1 & 2**).

d. Temporarily re-install retainer plate to hold other three pins in location as Sonnax ring gear stabilizer race installation is completed (**Figure 2**).

e. Place ring gear stabilizer race over three pins protruding from rear of carrier.

f. Bolt in place using six bolts supplied with carrier.

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

Figure 1

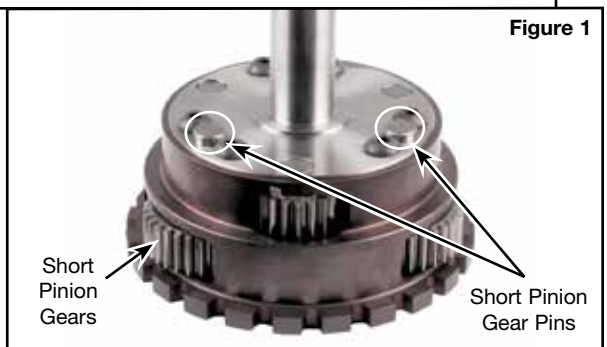
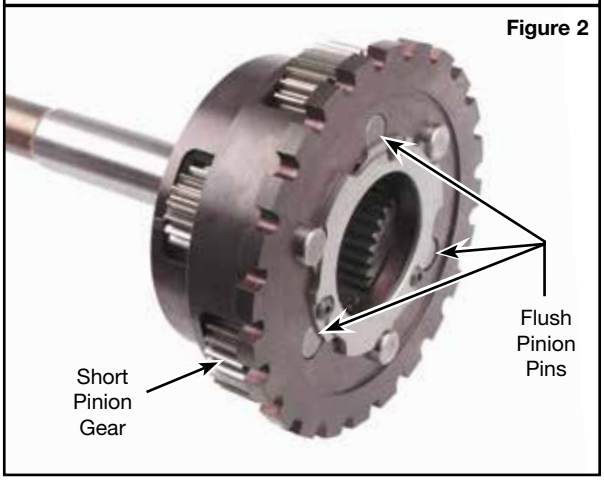


Figure 2



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2. Ring Gear Preparation

a. Mark a line ⅜" from the rear end of the ring gear around the outside of the ring gear clutch splines (**Figure 3**).

b. Use a center punch to create an indent in the middle of one of the clutch splines at the line that is ⅜" from the end of the ring gear.

c. Move over six splines and repeat (there should be five regular splines between each pair of marked splines).

d. Drill a ⅛" pilot hole through the five indented splines.

e. Re-drill pilot holes with a ¼" drill bit (**Figure 4**).

f. Insert five buttons from the inside (**Figures 5 & 6**).

3. Final Assembly

Use normal assembly procedures.

Figure 3

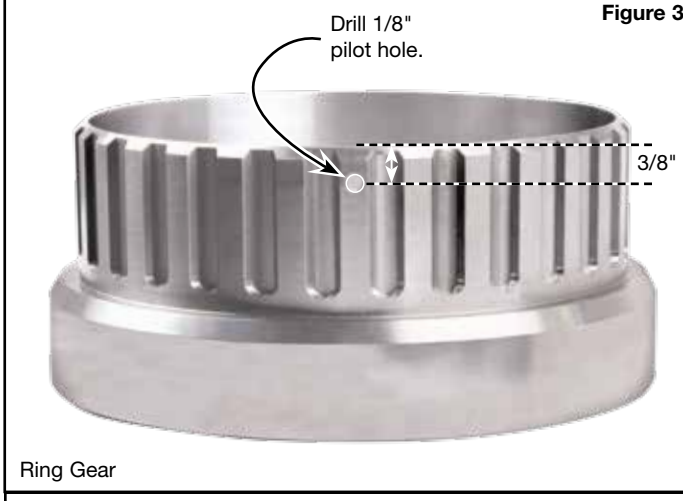


Figure 4

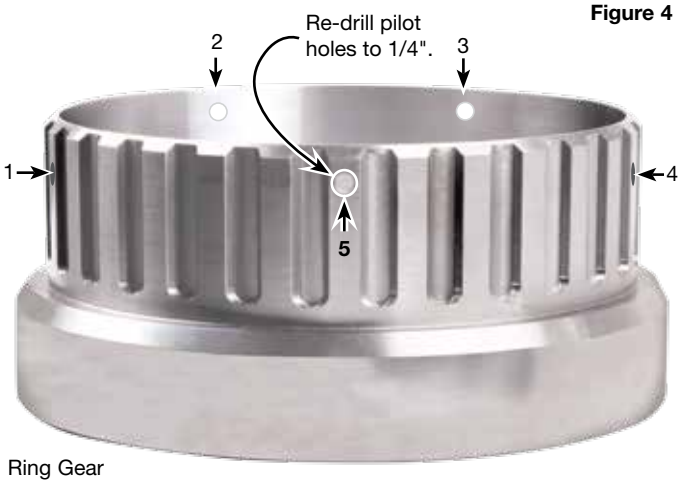


Figure 5

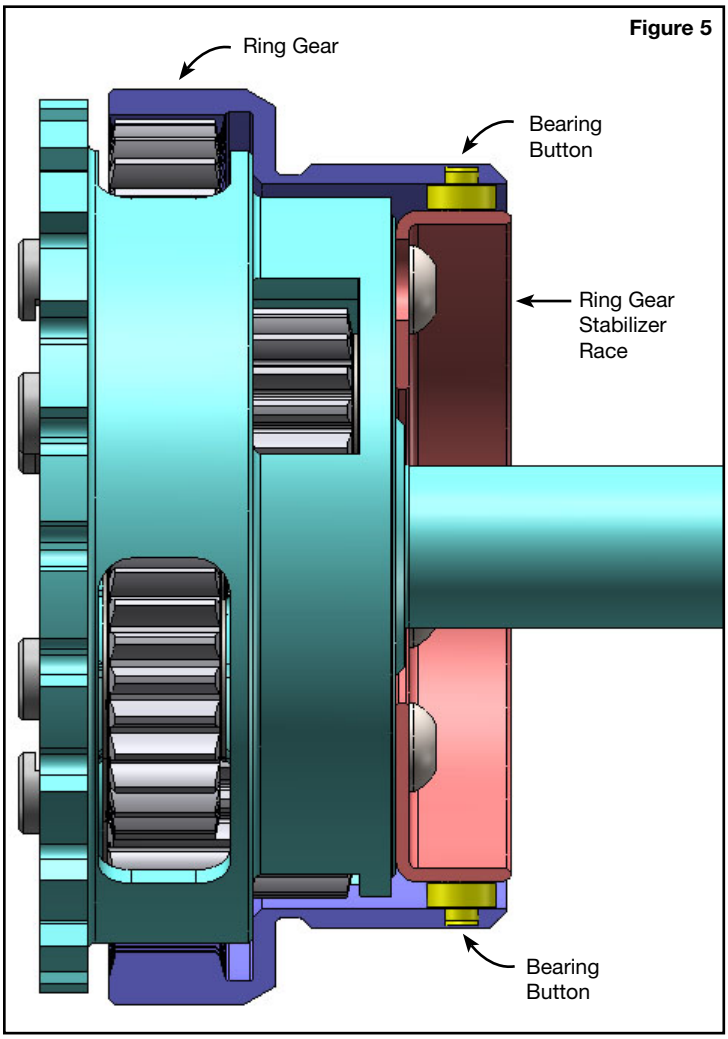
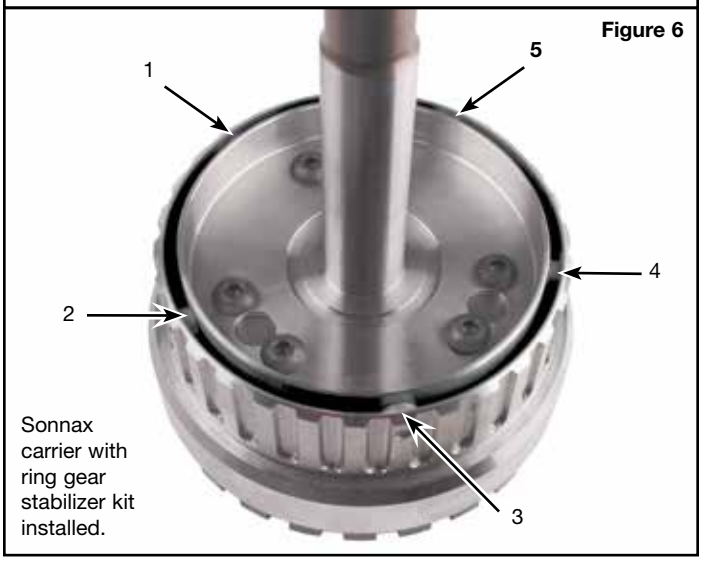


Figure 6



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