

## Ring Gear Stabilizer Kit

### Part No.

# 28510-S2

- Ring Gear Stabilizer Race
- Bearing Buttons (5)

Patent No. 9,574,653



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

## GM Powerglide

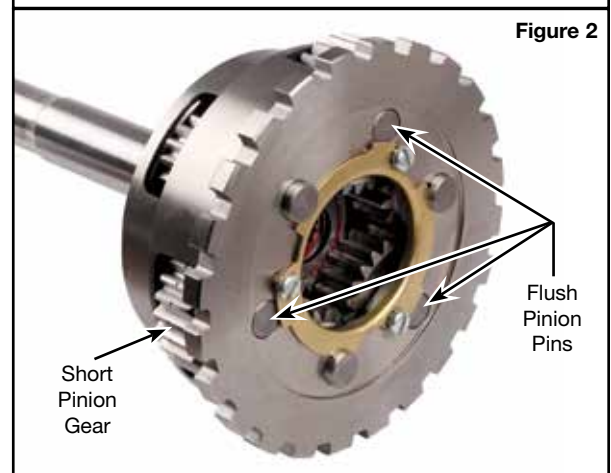
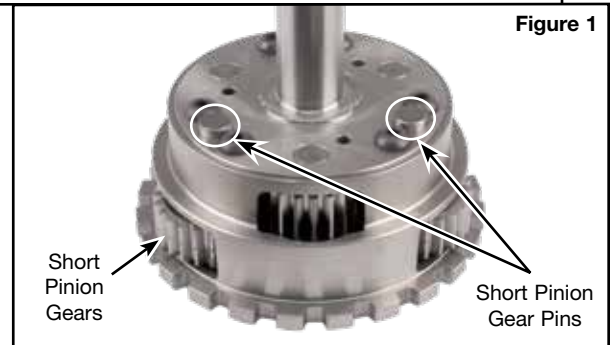


**NOTE:** The following tools are required to install this ring gear stabilizer kit.

- 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  $\frac{1}{8}$ " 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.
- Clean threads and apply red Loctite® to the six bolts supplied with the carrier. Bolt in place, torquing to 30 ft-lb.
- 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.

