

Reaction Plate & Bolt-On Anchor Plate Service Kit

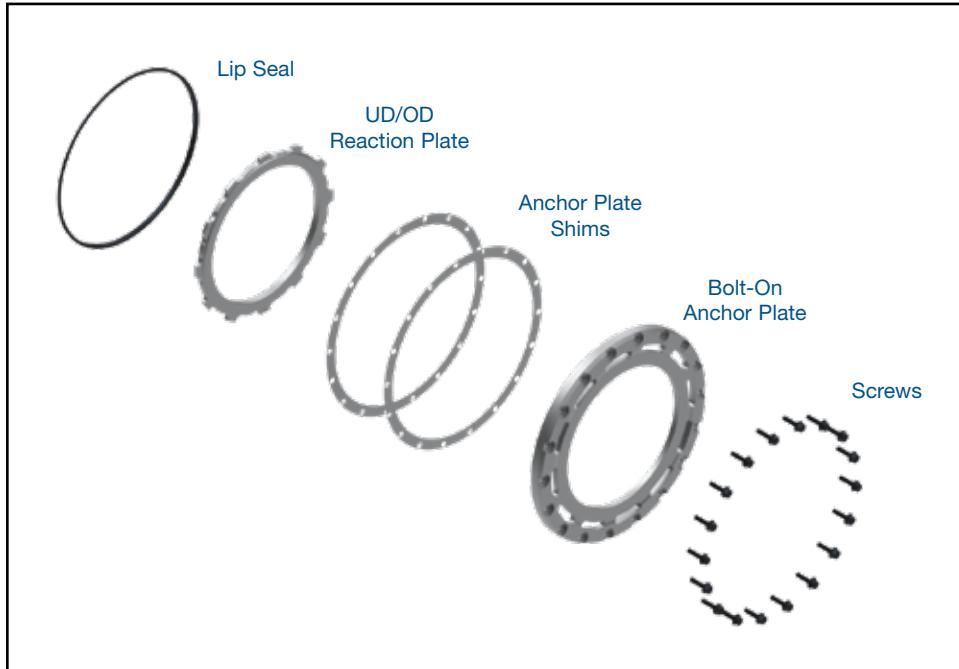
Part No. **72960-18SVC**

- Lip Seal
- UD/OD Reaction Plate
- Anchor Plate Shims (2)
- Bolt-On Anchor Plate
- Screws (18)

Patent Nos. 10,480,592 B1, 11,009,084, 11,713,788 & 12,209,618 B2.

NOTE: For use only with Smart-Tech® overdrive clutch housing kit 72960-18K.

Chrysler 68RFE



1. Remove all residual thread-locking compound from screw and bolt-on anchor plate mounting surfaces. Measure overdrive clutch clearance, mount a dial indicator to the assembly and zero the indicator against the Sonnax bolt-on anchor plate. Apply 20 psi of air pressure to the overdrive clutch and record the indicator reading. OE specification is 0.75–1.61mm (.030–.063").
2. Clutch clearance is adjusted with bolt-on anchor plate shims.
3. Fasten bolt-on anchor plate to Sonnax overdrive/reverse housing with 18 screws as follows:
 - Prior to assembly, clean screw threads and threaded holes in housing with brake wash cleaner so all threads are clean and dry.
 - Apply a drop of high-strength red Loctite® Threadlocker 262 or equivalent to the threads of each socket head cap screw and a small amount to each threaded hole in housing.
 - Install 18 Sonnax screws through the bolt-on anchor plate into the threaded holes in the housing and lightly tighten each screw.
4. Torque screws to 51 in-lb as follows: tighten all screws to lower 40 in-lb value by working around the housing in a criss-cross (star) pattern to ensure even pressure on the bolt-on anchor plate. Before the threadlocker cures, retorque to 51 in-lb specification.