

HIGH PERFORMANCE TRANSMISSION PARTS

Instructions

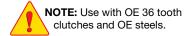
GM 6L80, 6L90

High Capacity 4-5-6 Clutch Apply Piston Kit

Part No. 104960-10K

- Apply Piston
- Piston Dam
- Apply Plate
- Backing Plate

Patent Pending





1. Clutch Assembly Information

OE recommended clutch clearance is .008–.012" per friction. See list of selective retaining rings for adjusting clutch clearance (**Figure 1**).

2. Disassembly

- a. Dismantle 4-5-6 clutch assembly using OEM recommended methods and procedures.
- b. Discard OE apply piston, piston dam, waved plate and backing plate. Set aside remaining components for reuse.

3. Installation & Assembly (Refer to Figure 2 on page 2)

- a. Install Sonnax apply piston into housing assembly.
- b. Reinstall OE clutch return spring.
- c. Install Sonnax piston dam. Using appropriate tools, compress piston dam just far enough to allow OE piston dam retaining ring installation.



WARNING: Use care to avoid damaging inner and outer sealing lips on piston dam. Compressing the piston dam too far will cause inner seal lip damage.

- d. Install Sonnax piston apply plate (Figure 2). Do NOT install OE waved plate.
- e. Assemble 4-5-6 clutch pack with one additional OE thickness friction plate.
- f. Install Sonnax backing plate.
- g. Reinstall or replace OE backing plate retaining ring.



NOTE: OE retaining ring is selective and is available in varying thicknesses to allow for proper setting of clutch clearance (**Figure 1**).

Backing Plate Selective Retaining Rings Figure 1

	GM Part No.	Thickness	Color
	24233407	.063–.067"	Yellow
	24233408	.080083"	None
	24233406	.096–.100"	Purple



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