

HIGH PERFORMANCE TRANSMISSION PARTS

Instructions

## Extreme Duty Forward Clutch Hub Kit

### Part No. 34322-02K

- Bearing
- Hub

# GM 400, 425, 4L80-E, 4L85-E



**WARNING:** Compared to OE or other replacement forward clutch hubs, this hub and bearing combination has an additional .025" thickness designed-in to reduce endplay and provide further endplay adjustment options.

**NOTE:** No machining is required for typical installation.

**NOTE:** This forward clutch hub and bearing combination shifts the support of the forward clutch hub from the main shaft to the direct housing and sun gear shaft.

NOTE: Preassemble unit to check and set endplay before final transmission assembly.

#### **Directions**

- a. Stack bearing and forward clutch hub onto direct clutch housing.
- b. Place bronze washer on top of forward clutch hub.
- c. Place forward clutch housing on top of bronze washer.
- d. Install pump cover and gasket.



NOTE: For 4L80E, install necessary overdrive components to allow endplay check.

- c. Check front end play. Ensure output shaft is pre-loaded forward when checking front endplay. See front endplay selective washers and specifications (Figures 1 & 2).
- d. If endplay is too tight, material can be removed from following locations as needed.
  - Front of direct clutch housing
  - Rear of forward clutch hub
  - Rear of forward clutch housing



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### Figure 1

4L80E Front Selective Thrust Washers					
Thickness	Identification Color	OE#	INDUSTRY #		
.123"	Black	8677575	34211HE		
.107"	Green	8677574	34211HD		
.091"	Brown	8677573	34211HC		
.075"	Red	8677572	34211HB		
.059"	Blue	8677571	34211HA		
	.004–.022"				
	.005–.025"				

#### Figure 2

THM400 Front Selective Thrust Washers					
Thickness	Identification Color	OE #	INDUSTRY #		
.130"	Purple	8623306	34211G		
.117"	Black	8623305	34211E		
.106"	Green	8623304	34211D		
.095"	Brown	8623303	34211C		
.084"	Red	8623302	34211B		
.073"	Blue	8623301	34211A		
.062" **	Yellow	8623300	34211		
Front End Play Specification			.003–.024"		
Rear End Play Specification			.007–.019"		

<sup>\*\*</sup>Check to ensure lube passage at rear of pump cover is not crowded by forward clutch housing.