

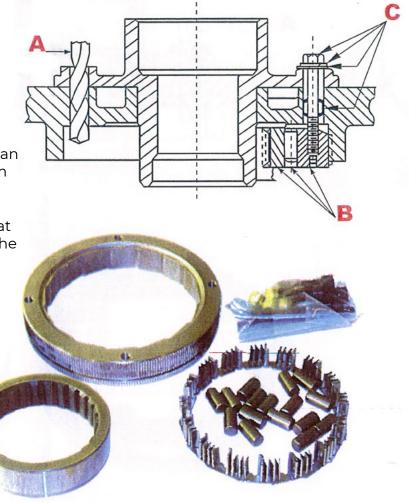
16 ELEMENT SPRAG RACE REMOVAL & INSTALLATION INSTRUCTIONS

DISASSEMBLY:

- 1. With the transmission fully disassembled, remove the O.E. outer race in the rear of the case using a 1/8" Allen key, loosen the Allen screw that retains the race.
- 2. Rotate the case onto it's bell housing and insert a 1/4" drift punch into any of the 4 governor support holes. Carefully, in an alternating fashion, gently tap outer race out of the bore. Care must be taken not to cock the race or damage might occur.
- 3. Enlarge the 4 existing holes with an 11/32" diameter drill (A).
- 4. Chamfer drilled holes and clean the case.

ASSEMBLY:

- 1. Install the new race by visually aligning holes of the race and case.
- Start 4 bolts using only the flat washers provided in the kit and evenly tighten in an alternating fashion until the bolts bottom out (B). Remove the bolts.
- 3. Install the governor support, bolts and flat washers only, once again start drawing the race into it's finished position.
- 4. Ensure the race is evenly bottomed into the case bore and re-tighten the 1/8" factory set screw.
- Finally install the 4 bolts with the brass ferrules to help center the bolts (C). Finish off by installing the flat and lock washers and tighten each bolt to 13 ft/lbs. torque.



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