

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.
2. 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.
5. 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.

