



RING GEAR INSTALLATION PROCEDURE



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(Non Asbestos Ring Gear)

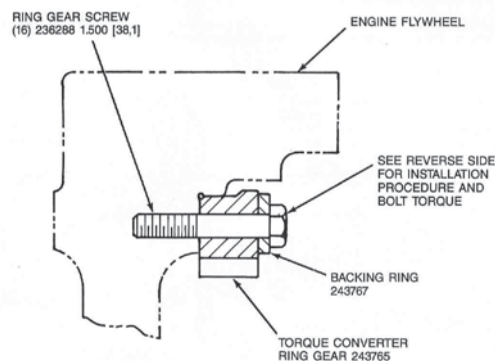
802184 Installation Instruction Sheet



- 1.) Remove all burrs from flywheel mounting face and pilot bores. Clean the torque converter ring gear flywheel mounting surface and the ring gear screw tapped holes with solvent. Dry thoroughly, being certain that the ring gear screw holes are dry and clean.
- 2.) Check the engine flywheel and housing or the housing adaptor for conformance to standard S.A.E. No. 3 - S.A.E. J927 and J1033 tolerance specifications for the pilot bore size, pilot bores eccentricities and mounting face deviations. Measure and record for any engine crankshaft end play.
- 3.) Install the Torque converter ring gear as shown, illustration overleaf:

Note: Assembly of the ring gear must be completed within a fifteen minute period from start of screw installation. The screws are prepared with an epoxy coating which begins to harden after installation into the flywheel mounting holes. If not tightened to the correct torque within the fifteen minute period insufficient screw clamping tension will result.

- 4.) Install the backing ring and sixteen (16) special screws to approximately .06 inch (1.5 mm) of seated position. It is permissible to use a power wrench for this installation phase. With a calibrated torque wrench, tighten these screws to between 30 and 33 foot pounds of torque (40.7 - 44.7 N.m.).
To obtain the maximum effectiveness of the special screw's locking feature, a minimum time period after screw installation of twelve (12) hours is suggested before engine start-up. The special screw is to be used for ONE installation only. If the screw is removed for any reason it MUST BE REPLACED. It is recommended that the epoxy left in the flywheel hole is removed with the proper tap and cleaned with solvent. Dry hole thoroughly and use a NEW screw for re-installation.
- 5.) Assemble the torque converter to the engine flywheel by sliding the converter into position by hand before fastening the housing attachment screws. This may require more than one trial to match the drive gear teeth. Pulling the converter into position with the housing attachment bolts is not recommended.
- 6.) Measure the engine crankshaft end play after assembly of the torque converter. This value must be within one thousandth (.001 of an inch) (or 0.0254 mm) of end play recorded (in paragraph #2) before the assembly of the torque converter.



802183 - 1.5 INCH (38.1) 16 SCREW RING GEAR KIT		
1	243765	Torque Converter Ring Gear
16	236288	Ring Gear Screw 1.5 inch (38.1)
1	802184	Installation Instruction sheet
802392 - 1.5 INCH (38.1) 16 SCREW RING GEAR KIT		
1	243765	Torque Converter Ring Gear
16	236288	Ring Gear Screw 1.5 inch (38.1)
1	243767	Backing Ring
1	802184	Installation Instruction Sheet



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