

INSTALLATION METHOD FOR DIRECT DRUM

PCE623.1002

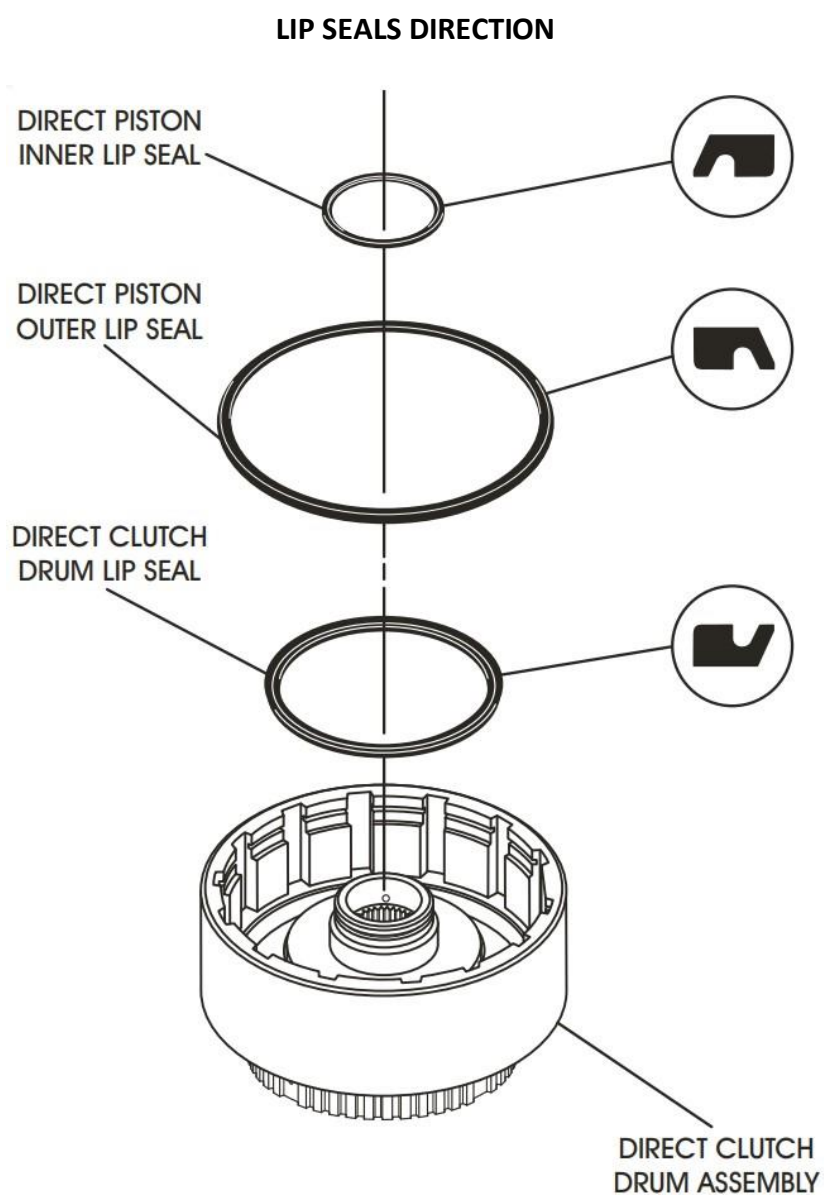


NOTE: This model uses an intermediate sprag assembly (34 Element).

NOTE: Spring compressor tool is needed.

INSTALLATION PROCESS

1. Install new direct drum lip seal into the groove in direct drum, with the lip facing the correct direction, and lubricate with a small amount of ATF lubricant.
2. Install new direct clutch piston outer lip seal in groove of direct clutch piston, with lip facing the correct direction.
3. Install new direct clutch piston inner lip seal in groove of direct clutch piston, with lip facing the correct direction.
4. Lubricate both seals with a small amount of ATF lubricant.

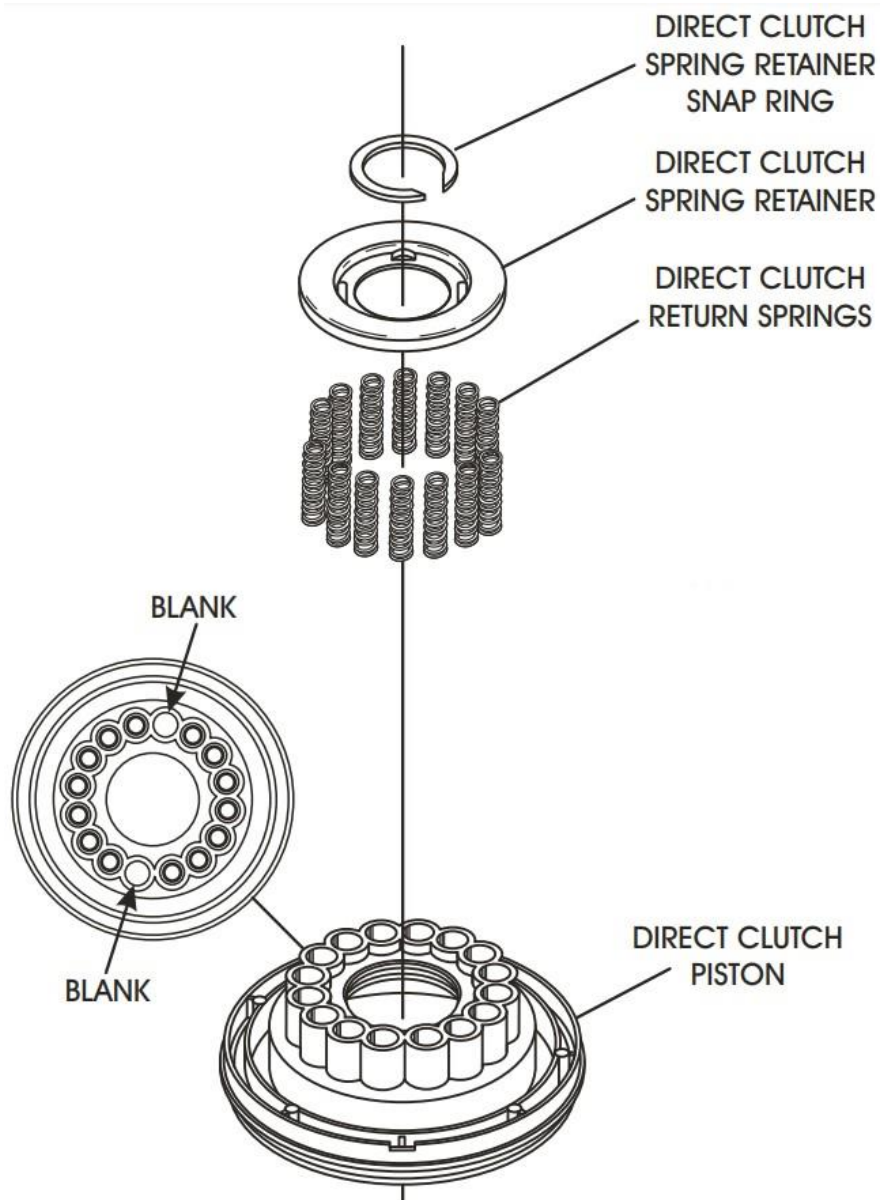


NOTE: This model does not use a stamped steel direct clutch piston and spacer.

5. Install inner lip seal protector J-21362 (GM SKU) on the hub of direct drum.
6. Install outer lip seal protector J-21409 (GM SKU) into the direct drum.
7. Install the direct clutch piston assembly into the direct clutch housing using a twisting motion.

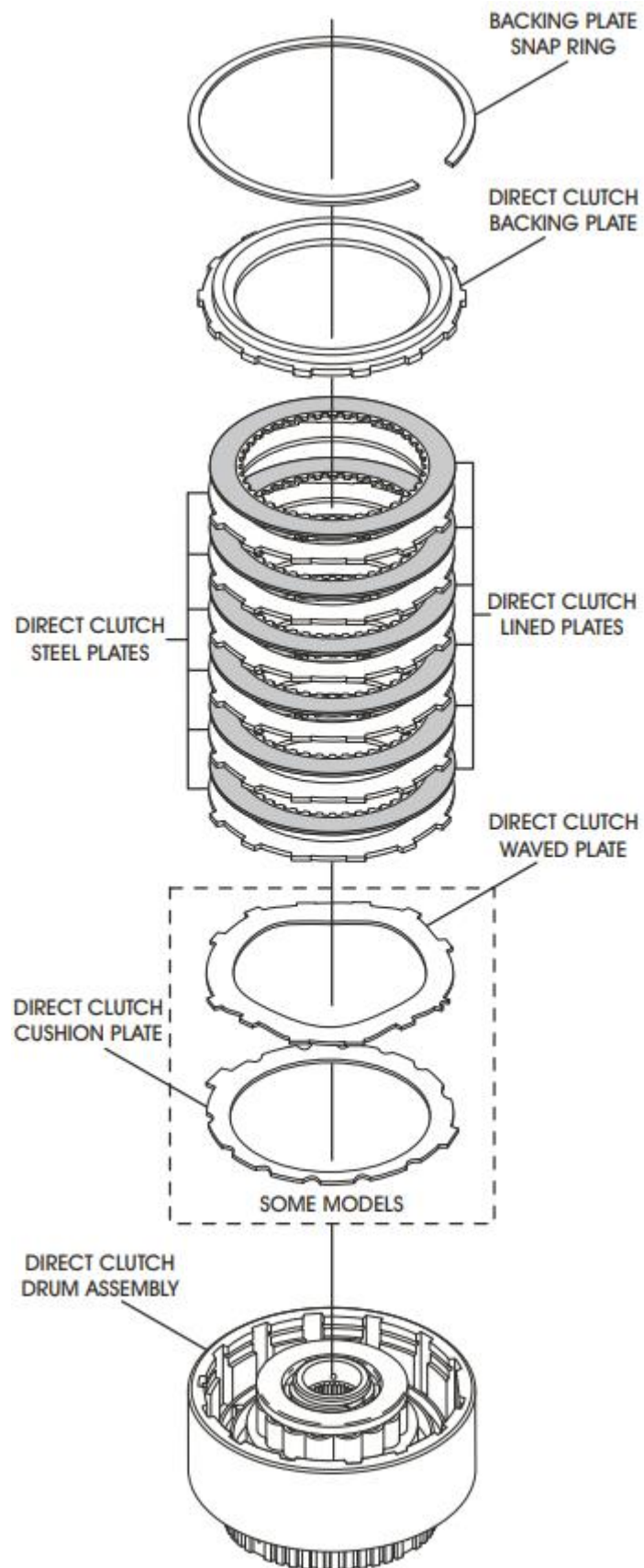
8. Install the 14 direct clutch piston return springs into the cavities in the piston in the positions, leaving two blank pockets 180 degrees from one another.
9. Install the direct clutch return spring retainer on top of the springs, and lay the snap ring on top of the retainer.
10. Compress the spring retainer and return springs and install the snap ring, using the compressor.

PISTON ASSEMBLY



11. Install the waved plate or the cushion plate.
12. Install the direct clutches beginning with a steel plate and alternating with a friction plate.

PLATE CONFIGURATION



NOTE: The direct clutch uses 6 lined plates.

13. Install the direct clutch backing plate with flat side down.
14. Install the direct clutch backing plate snap ring and ensure that it is seated in groove.

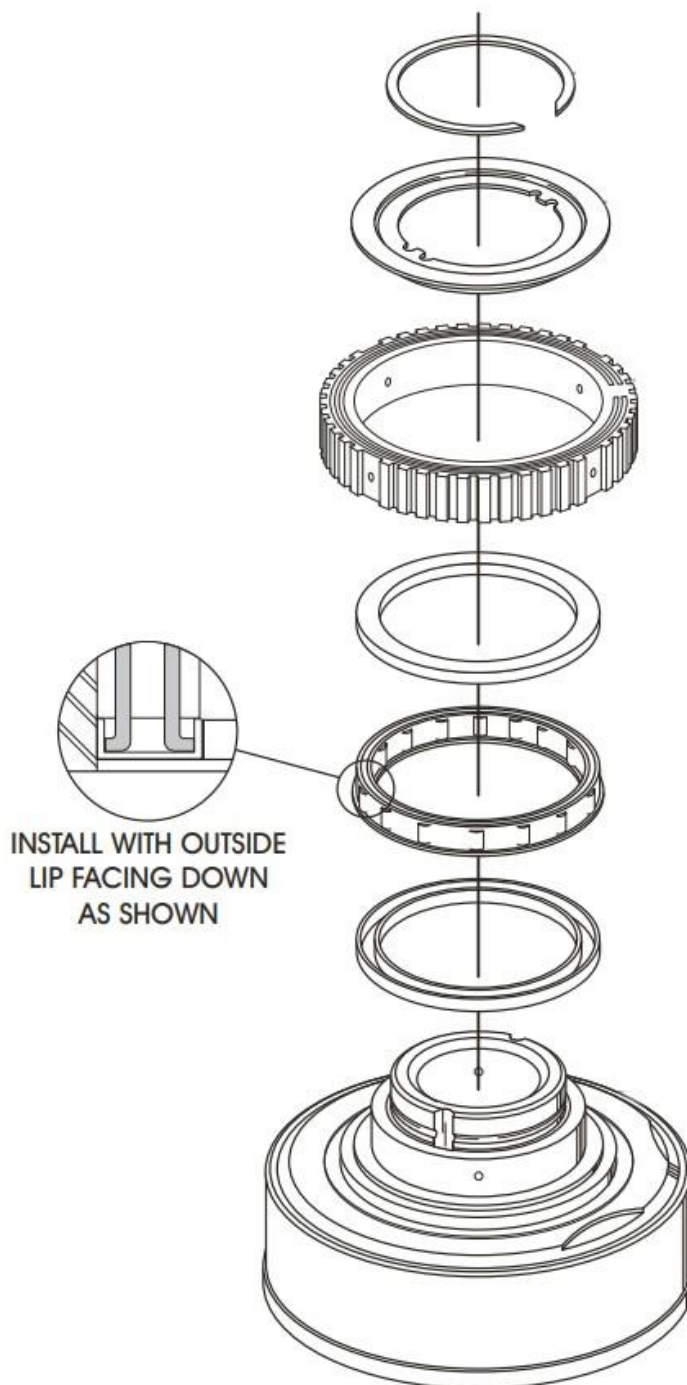
NOTE: Direct clutch clearance should measure approximately .010" per lined plate.

15. Turn the direct clutch housing over.

NOTE: This direct drum is a "Sprag" style freewheel.

16. Use Figure 83 to assemble "Sprag" style intermediate freewheel.

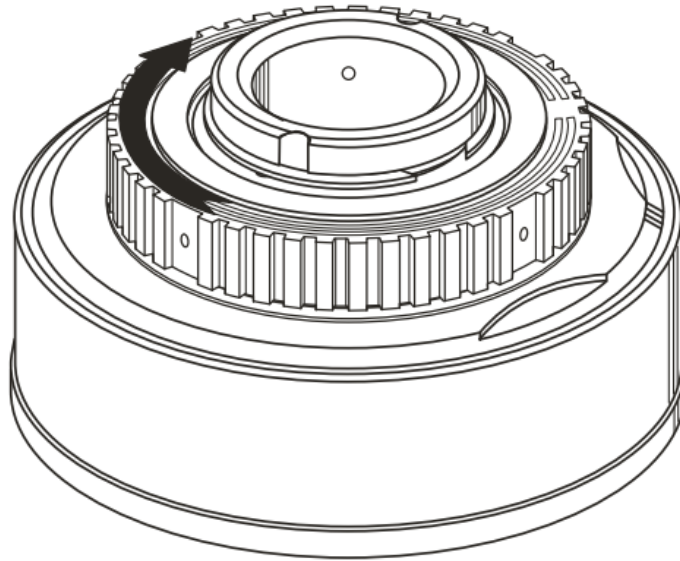
SPRAG ASSEMBLY



17. After assembly, check the outer race for proper freewheel direction.

FREEWHEEL DIRECTION

MUST FREEWHEEL CLOCKWISE



18. The direct clutch housing assembly is complete.

19. Set the direct clutch housing assembly aside for the final assembly process.