



**Speed Gems**  
transmission adapters

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## 1954-and-up Cadillac 365/390 to Chevy Automatic

### Disclaimer - Please Read Carefully

**WARNING:** Due to the nature of engine and transmission swaps, we cannot guarantee fitment into your vehicle without having to make mild to extensive modifications. This should be considered when starting your project. It is highly recommended to take the time to research any potential issues you may face prior to starting your build. There are numerous forums and websites that can help and give insight into any potential issues involved in the project. This project is not for a novice mechanic. If an individual is not confident in performing such extensive vehicle modifications, Speed Gems recommends finding a capable shop for assistance.

Prior to and during installation of your new Speed Gems Transmission Adapter Kit, always ensure to:

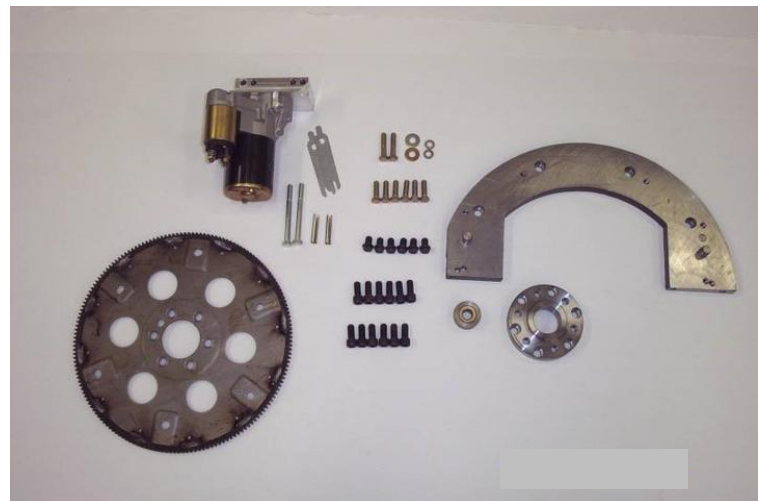
- Clean everything, including all components and surfaces.
- Use proper torque and **Loctite all bolts.**
- Do not force anything and begin all bolts by hand before using any tools. This will prevent cross-threading.
- Check all bolt clearances.

We try to make everything as simple as possible to help you, but the ultimate responsibility as to the assembly of the kit is up to the installer.

If you have any additional questions, please contact us by phone (763) 767-4480 during business hours or email [sales@transmissionadapters.com](mailto:sales@transmissionadapters.com) at any time.

### COMPONENTS INCLUDED IN KIT

(1) Adapter Plate - 1954 & up Cadillac to Chevy Automatic
(1) Crank Adapter
(1) High Torque mini-Starter
(2) HCS 3/8-16 x 3-3/4 YZ 8
(4) SHCS 7/16-14 x 1
(6) SHCS 7/16-20 x 3/4
(6) 7/16-20 x 3/4 Flexplate Bolts
(1) HCS 3/8-16 x 1-3/4 YZ 8
(3) USS Flat Washer 3/8 YZ 8
(1) Lock Washer 3/8 YZ 8
(6) HCS 3/8-16 x 1-1/4 YZ 8
(1) 168-tooth Chevy Flexplate
(2) Dowel Pin .625 x 1



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## INSTALLATION INSTRUCTIONS

1. Once the transmission is removed, clean the back surface of the block where the adapter will contact. Make sure both alignment dowels are in place.
2. Install the provided dowel pins into the block so they only stick out approximately 3/8". If they do not go in far enough, cut them off so they stick out the required amount.
3. Make sure that the crank flange is extremely clean (i.e. - no burrs).
4. Install the provided crank adapter and flexplate using the included hardware. There are (6) 7/16-20 x 3/4" SHCS for the crank adapter and (6) 7/16 x 3/4" flexplate bolts.
5. Install the provided adapter plate using the 7/16-14 x 1 SHCS bolts included. Two of the bolts are to be thread into the adapter plate from the front side of the block.

**NOTE:** If the block is tapered near the head of either of these bolts, material will need to be taken off that area of the block. The head of the bolt/s should sit flush after tightening.

6. Install the starter using the 3/8-16 x 3-3/4" HCS bolts included. Make sure the starter aligns with the ring gear. If adjustment is needed, rotate the starter by removing the two small bolts that hold it to the aluminum block.

Next, turn the engine over with the starter to make sure everything is going to work correctly. Check and confirm the depth of starter engagement, or distance of the drive to the ring gear. If the engine can be started and ran, you can also make sure there is no vibration present.

7. Everything should now be set to install the Chevy automatic transmission.



Speed Gems would like to THANK YOU for purchasing our products!

We would love to see pictures of our products installed on your Hotrod. Please tag us on our social media or send a picture to [sales@transmissionadapters.com](mailto:sales@transmissionadapters.com) and we will get your project posted on our website.

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