



Speed Gems
transmission adapters

Performance. Delivered.
www.transmissionadapters.com
Email: sales@transmissionadapters.com
Phone: (763) 767-4480

1954 & Up Cadillac 365/390 to Chevy Manual Transmission

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:

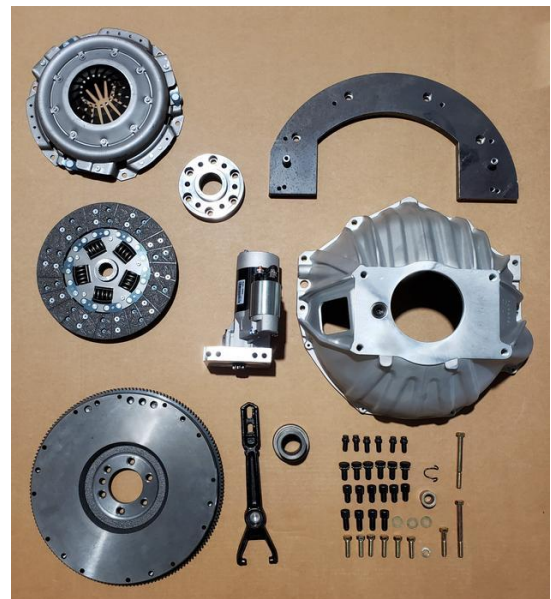
- Clean everything, including all components and surfaces.
- Use proper torque and **Loctite all bolts.**
- Do not force anything and begin all bolts by hand before using any tools. This will prevent cross-threading.
- Check all bolt clearances.

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 at any time.

COMPONENTS INCLUDED IN KIT

(1) Adapter Plate - 1954 & Up Cadillac to Chevy Automatic
(1) Crank Adapter
(1) High Torque mini-Starter
(1) Clutch Disc, (1) Pressure Plate & (1) Throw-out Bearing
(1) 168-tooth Flywheel
(1) Bell Housing
(1) Clutch Fork, (1) CF Retaining Clip & (1) Pivot Ball
(1) Pilot Bushing & Pilot Bushing Adapter
(1) Long throw-out Bearing
(2) Dowel Pin .620 x 1
(6) 7/16-20 x 1 Flywheel Bolts & (6) 3/8-16 x 3/4 Pressure Plate Bolts
(2) HCS 3/8-16 x 3-3/4
(4) SHCS 7/16-14 x 1
(6) SHCS 7/16-20 x 3/4
(1) HCS 3/8-16 x 1 3/4
(3) Flat Washer 3/8
(1) Lock Washer 3/8
(8) HCS 3/8-16 x 1 1/4



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INSTALLATION INSTRUCTIONS

1. Make sure that the crank flange is extremely clean (i.e. - no burrs). Trial fit the provided crank adapter onto the crankshaft to ensure that the holes line up and that the inner crank adapter goes on flush. This crank adapter is manufactured to very tight tolerances. Due to its size and weight, having any type of burr, debris, or other reason for it not to be flush, will cause a wobble and vibration.

Once placement is located and the crank adapter sits flush, install the provided crank adapter with proper alignment using the (6) 7/16-20 x 3/4" SHCS bolts included.

2. Install and align the provided flywheel using the (6) 7/16-20 x 1" bolts included. If there is a balance weight, it will go on towards the engine. Otherwise, the side of the flywheel with the deeper recess on the ring gear will point towards the engine.
3. Install the lower bellhousing and starter to make sure the starter is going to align with the flywheel provided. 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 flywheel ring-gear. If the engine can be started and ran, you can also make sure there is no vibration present.
4. Install the provided adapter plate. The dowel locating holes are reamed slightly larger on these adapter plates due to some of these engines having larger dowel pins in them.

NOTE: This adapter plate may fit snug on some of these dowels or could be looser on others.

5. Everything should now be ready to install the clutch components, pressure plate and bellhousing.
6. Everything should now be set to install the Chevy manual 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 and we will get your project posted on our website.

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806H S. Division St., Waunakee, WI 53597

sales@transmissionadapters.com

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