



Speed Gems
transmission adapters

Performance. Delivered.
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Phone: (763) 767-4480

1942-1948 Cadillac 346 Flathead w/Hydra-matic 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 at any time.

COMPONENTS INCLUDED IN KIT

(1) Adapter Plate-Inner - Cadillac Flathead to Chevy Auto.
(1) Adapter Plate-Outer - Cadillac Flathead to Chevy Auto.
(1) Crank Adapter - 1938-48 Cadillac 346 Flathead to Chevy
(1) Torque Converter Drive Plate
(6) SHCS 7/16-20 x 3
(6) FHSCS 3/8-16 x 1-1/4
(6) SHCS 7/16-14 x 3
(6) 7/16-20 x 3/4 Flexplate Bolts
(4) Dowel Pin .621 x 1
(6) Stud 3/8-16 x 1-3/4 Z
(6) Hex Nut 3/8-16 YZ 8
(1) Starter
(1) Starter Block – Olds/Cadillac applications
(2) SHCS 7/16-14 x 1-1/4
(3) 7/16 H Extra Thick Washer
(3) 7/16 Flat Washer



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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. Remove the outer adapter plate from the inner adapter plate in the provided assembly.
NOTE: It is a tight fit over the dowel pins so use caution to tap it off without damaging.
3. Remove the existing flexplate and grind off any 'lip' or material that may be on or around the center hole. This will need to be a flat surface for the crank adapter to sit flush.
NOTE: This kit is to be used with the original Hydra-matic flexplate and starter that was stock on most motors.
4. Re-install existing flexplate and provided crank adapter using the (6) 7/16-20 x 2-5/8" SHCS included. The crank adapter installs over the existing flexplate and these bolts will retain both the flexplate and the crank adapter. Torque to factory specifications.
NOTE: Check to ensure that there is clearance on the back side of the bolt threads near the engine block. We modified the bolt length prior to shipping, however, this needs to be checked in case more length needs ground off the bolts.
5. Install the provided adapter plate assembly onto your block. The inner plate will bolt to the block using the (6) 7/16-14 x 3" SHCS included and the outer plate will bolt to the inner plate using the (6) 3/8-16 x 1-1/4" FHSCS included.
NOTE: Ensure both of the original 5/8" dowels remain in place.
6. Bolt on the provided torque converter drive plate using the (6) 7/16-20 x 3/4" bolts included.
NOTE: The drive plate has no front/back orientation and can go on in either direction.
7. Install the starter to make sure it aligns with the ring gear. 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.
8. 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 and we will get your project posted on our website.

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