


# Mounting procedure

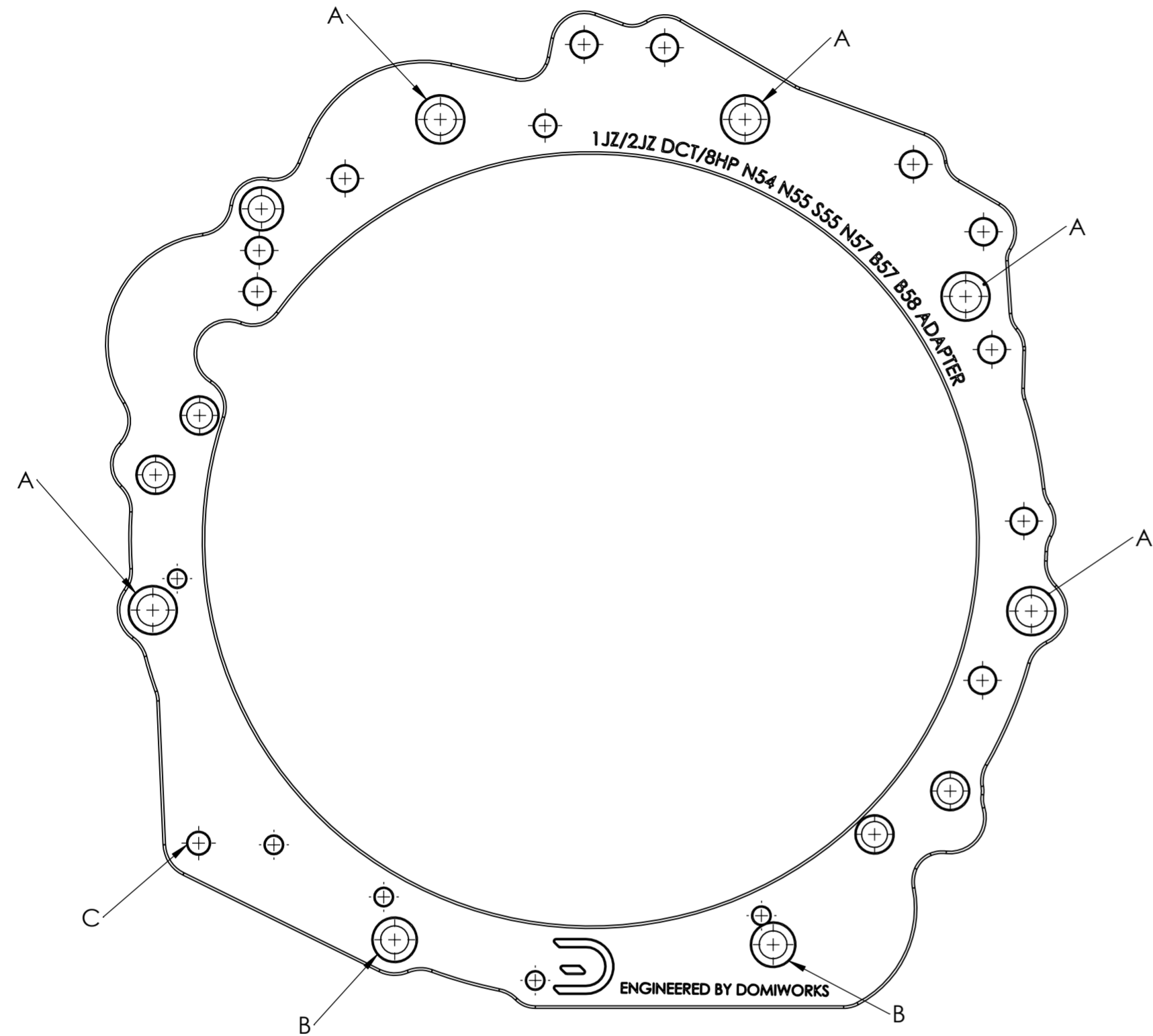
Step by step

1. Prepare starter mounting, see page 4.
2. Mount flexplate to the engine.
3. Mount TC Adapter to 8HP Torque Converter, see page 3.
4. Mount adapter plate to engine, see page 2.
5. Mount transmission and torque converter to adapter plate, see page 3.
6. Mount torque converter adapter to flexplate.
7. Mount starter.

UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN MILLIMETERS		FINISH:		DEBURR AND BREAK SHARP EDGES		DO NOT SCALE DRAWING		REVISION		
SURFACE FINISH:										
TOLERANCES:										
LINEAR:										
ANGULAR:										
DRAWN		NAME	SIGNATURE	DATE						
CHK'D										
APPV'D										
MFG										
Q.A						MATERIAL:	DWG NO. <b>Mounting procedure</b> <b>A2</b>			
						WEIGHT:	SCALE:1:2 SHEET 1 OF 5			


# Bolt reference guide

Adapter plate - Engine to adapter



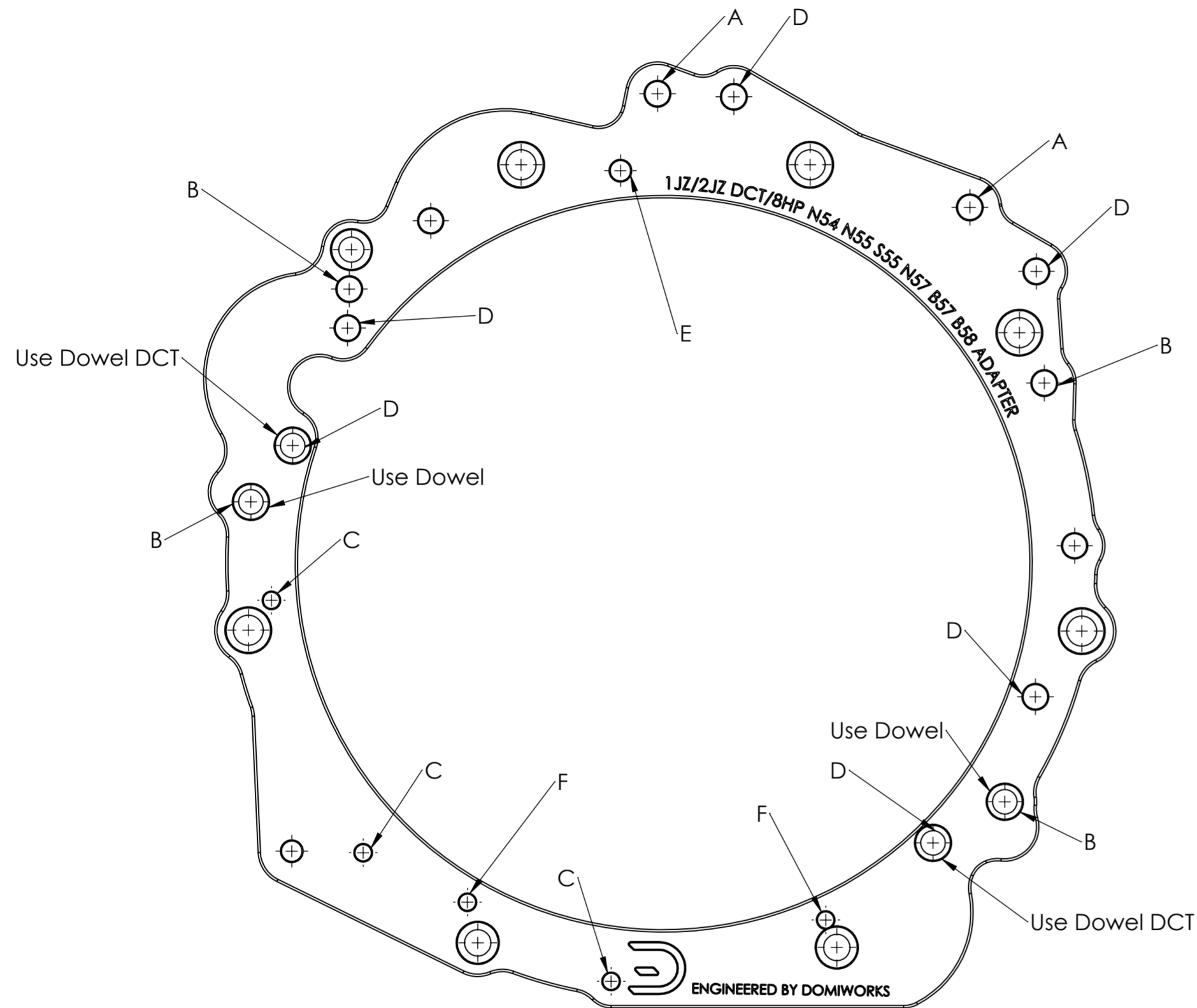
Reference	Bolt dimension	Apperance	Torque
A	M12x20-1.25	Black	Use OEM value
B	M10x30-1.25	Black	Use OEM value
C	M10x30-1.5	Silver	45Nm

**CAUTION!** These are maximum permissable torque values for aluminium threads. Always be careful when tightening. We recommend to go a little bit lower and use a medium locking compound.

UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN MILLIMETERS			FINISH:			DEBURR AND BREAK SHARP EDGES			DO NOT SCALE DRAWING		REVISION			
TOLERANCES: LINEAR: ANGULAR:											DWG NO. Engine to adapter A2 SCALE:1:2 SHEET 2 OF 5			
DRAWN			NAME			SIGNATURE							DATE	
CHK'D														
APPV'D														
MFG														
Q.A														
						MATERIAL:								
						WEIGHT:								


# Bolt reference guide

Adapter plate - Adapter to transmission



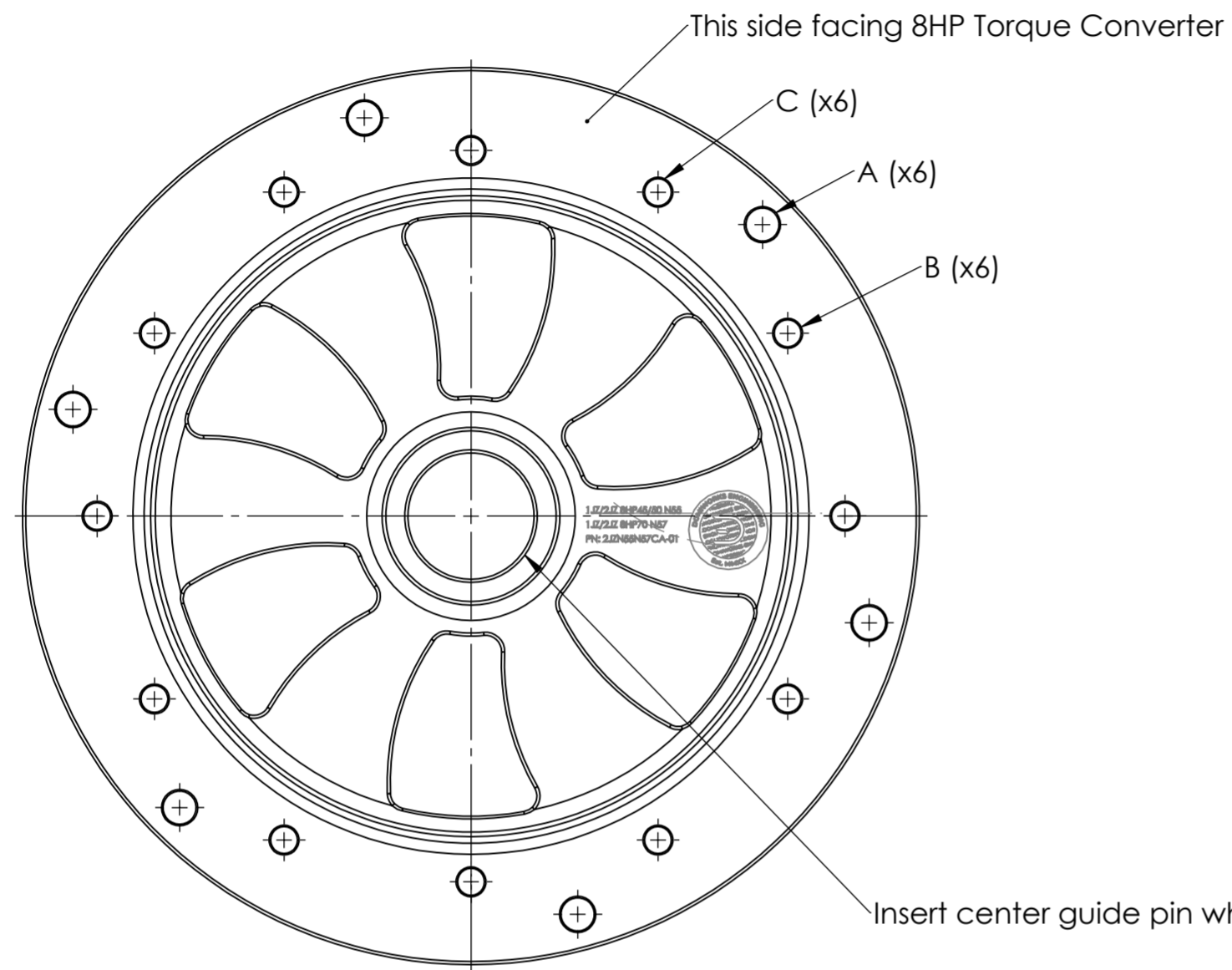
Reference	Bolt dimension	Apperance	Torque	Note
A	M12x40	Silver	70	8HP
B	M12x55	Silver	70	8HP
C	M8x45	Silver	28	8HP
D	M12x40	Silver	70	DCT
E	M12x55	Silver	70	DCT
F	M8x45	Silver	28	DCT

**CAUTION!** These are maximum permissable torque values for aluminium threads. Always be careful when tightening. We recommend to go a little bit lower and use a medium locking compound.

UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN MILLIMETERS		FINISH:		DEBURR AND BREAK SHARP EDGES		DO NOT SCALE DRAWING		REVISION	
SURFACE FINISH:									
TOLERANCES:								DWG NO. Adapter to transmission A2	
LINEAR:								SCALE:1:2	
ANGULAR:								SHEET 3 OF 5	
DRAWN	NAME	SIGNATURE	DATE			MATERIAL:			
CHK'D						WEIGHT:			
APPV'D									
MFG									
Q.A									

# Bolt reference guide

Torque Converter Adapter



Reference	Bolt Dimension	Apperance	Torque	Note
A	M10x20	Black	60Nm	Mount to 8HP TC
B	M10x20	Black	45Nm	Mount to GE Flexplate
C	M10x20	Black	45Nm	Mount to GTE Flexplate

**CAUTION!** These are maximum permissable torque values for aluminium threads. Always be careful when tightening. We recommend to go a little bit lower and use a medium locking compound.

Insert center guide pin when aligning towards 8HP Torque Converter

UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN MILLIMETERS		FINISH:		DEBURR AND BREAK SHARP EDGES		DO NOT SCALE DRAWING		REVISION	
SURFACE FINISH:									
TOLERANCES:									
LINEAR:									
ANGULAR:									
	NAME	SIGNATURE	DATE						
DRAWN									
CHK'D									
APPV'D									
MFG									
Q.A									
						MATERIAL:		DWG NO.	
								TC Adapter	A2
						WEIGHT:		SCALE:1:2	SHEET 4 OF 5



# Starter mount preparation

Due to interference issues with the 8HP transmission the starter bolts needs to be moved from the transmission side to the engine block side. This is done with the included two inserts and the included tool.

This require minor modification to the engine block where the inserts are mounted in the engine block to enable reverse mounting of the starter bolts.

1. The starter holes in the engine block needs to be enlarged to 13mm and a minimum of 22mm deep.
2. When this is done the insers are mounted on the tool and tightend
3. Screw in the insert in the hole until its flat to the surface.
4. Remove the insert tool by loosening the lock nut.
5. Enlarge the hole on the starter by a 11mm drill. Drill through the starter holes and remove the old thread.

Done!

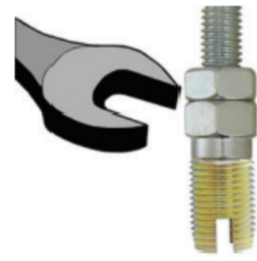
## 1. Drilling

Drill out the old hole with a core drill.  
If necessary countersink the borehole.



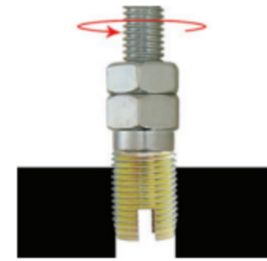
## 2. Screw threaded insert onto the intallation tool

Screw the thread insert onto the installation tool with the slot or hole downwards and lock in place with the locknut using a spanner.



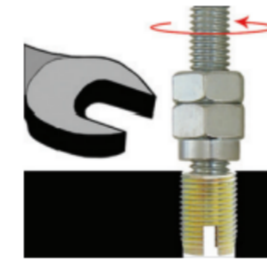
## 3. Screw in the thread insert


Screw in thread insert into the hole. The thread insert cuts its own thread. The intsallation tool has a 1/4" hexagon spigot and can be driven by a cordless driver, ratchet and socket etc.



## 4. Screw out the installation tool

Loosen the lock nuts with a spanner and screw the installation tool out. With the thread insert the thread is now more wear resistant, more durable and vibration resistant than the original thread.



UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN MILLIMETERS			FINISH:			DEBURR AND BREAK SHARP EDGES			DO NOT SCALE DRAWING		REVISION	
SURFACE FINISH:			TOLERANCES:			LINEAR:			ANGULAR:			
DRAWN			NAME			SIGNATURE			DATE			
CHK'D												
APPV'D												
MFG												
Q.A												
						MATERIAL:			DWG NO.			
						WEIGHT:			Starter mount preparation			
									SCALE:1:2			
									SHEET 5 OF 5			