



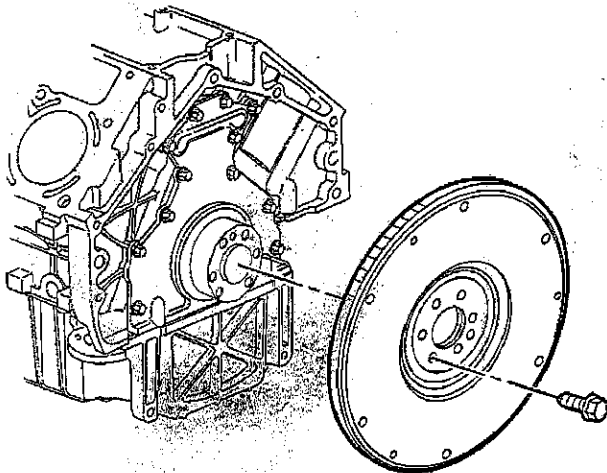
T56 Magnum Transmission Installation Kit

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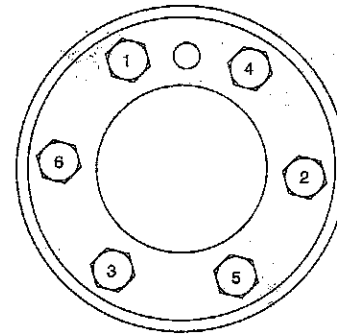
Kit Contents

Part Number	Description	Qty
12453263	Bell Housing	1
24264182	Cylinder, Clutch Actuator	1
11516424	Bolt, Clutch Actuator to Trans	2
12523235	Bolt, Bell to Trans	7
12571611	Flywheel, 6-Bolt Crankshaft Flange	1
11569956	Bolt, Flywheel	6
24255748	Kit, Clutch/Pressure Plate	1
12561465	Bolt, Pressure Plate	6
14061685	Bearing, Pilot	1
11515768	Bolt, Bell Housing to Engine	8
92262148	Cover, Dust (Left)	1
92169247	Cover, Dust (Right)	1
12560226	Bolt, Dust Cover	2
19301619	Instruction Sheet	1

Flywheel Installation Procedure



1. Install the manual transmission flywheel (12571611) to the crankshaft using (6) bolts (11569956).

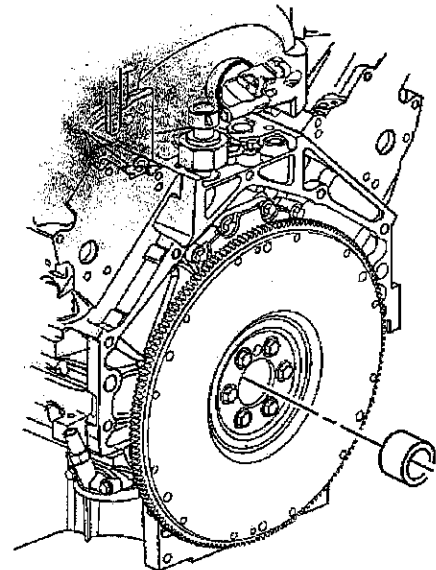


2. Apply threadlock GM U.S. P/N 12345382, Canada P/N 10953489, or equivalent to the threads of the flywheel bolts.
3. Install the flywheel bolts.

Tighten

1. Tighten the engine flywheel bolts a first pass in sequence to 20 N·m (15 lb ft).
2. Tighten the engine flywheel bolts a second pass in sequence to 50 N·m (37 lb ft).
3. Tighten the engine flywheel bolts a final pass in sequence to 100 N·m (74 lb ft).

Pilot Bearing Installation Procedure



1. Using a suitable size socket, install the clutch pilot bearing (14061685).
2. Install the clutch.

Clutch Installation Procedure

Important: When the clutch driven plate requires replacement, the engine flywheel must also be replaced along with the clutch pressure plate as an assembly.

TITLE T56 Magnum Transmission Installation Kit

DATE 05E13

PART NO. 19301619

SHEET 1 OF 6

ALL INFORMATION WITHIN ABOVE BORDER TO BE PRINTED EXACTLY AS SHOWN ON 8 1/2" WHITE 16 POUND BOND PAPER. PRINT ON BOTH SIDES, EXCLUDING TEMPLATES.

DATE 05E13

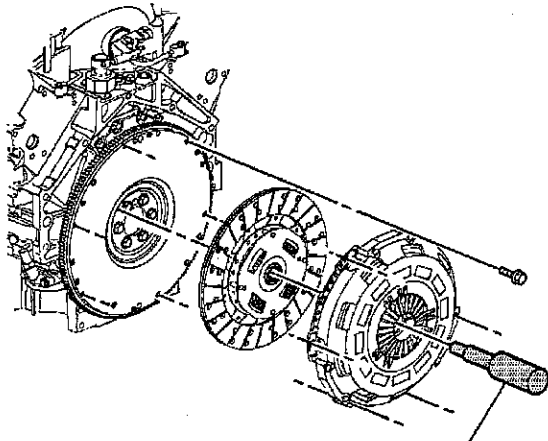
REVISION Initial Release - Rusty Sampsel

REVISION

AUTH

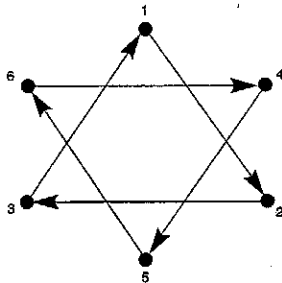
N/A

TO BE UNITIZED IN ACCORDANCE WITH GM SPECIFICATIONS.



J38836

1. Install the clutch pressure plate and driven plate (24255748 kit) to the dowel pins on the flywheel.
2. Install the clutch pressure plate bolts (12561465) finger tight.
3. Install the J 38836 (or equivalent clutch alignment tool) in order to align the clutch driven plate to the clutch pilot bearing.

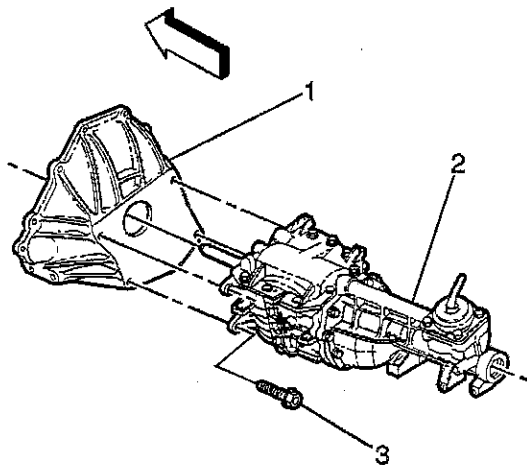


4. Tighten the clutch pressure plate bolts.

Tighten

Tighten the clutch pressure plate bolts (in sequence shown above) to 70 N·m (52 lb ft).

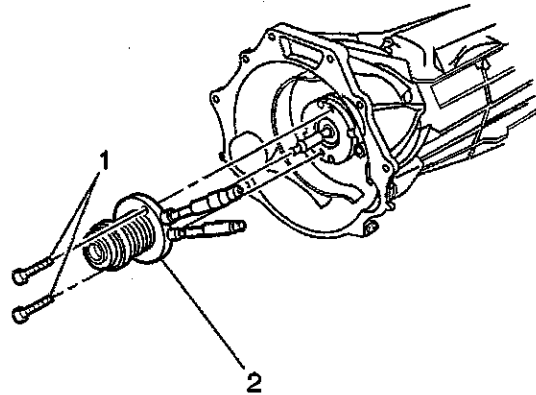
Clutch Housing and Transmission Installation



1. Install the clutch bell housing (12453263) to the transmission case.
2. Install the clutch housing bolts.

Tighten

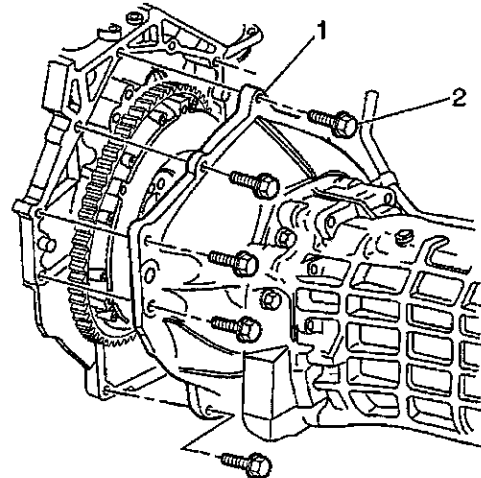
Tighten the clutch housing bolts (12523235) to 50 N·m (37 lb ft).



3. Install the clutch actuator cylinder (24264182) onto front of transmission.
4. Install the clutch actuator cylinder bolts (11516424).

Tighten

Tighten the clutch actuator cylinder bolts (1) to 8 N·m (71 lb in).



5. Install the transmission (1) to the engine.
6. Slowly raise the transmission until in place. Make sure transmission clutch housing mates fully to engine without binding.

Notice: Do not draw the transmission up to the engine using the bolts or engine/transmission damage may occur.

7. Install the transmission to engine bolts (11515768).

Tighten

Tighten the transmission to engine bolts to 50 N·m (37 lb ft).