

17. Install unit assembly into case indexing input shaft pilot with pilot in output shaft and low sun gear with short pinions in planet carrier.
 18. Install low servo piston release spring on servo piston rod and install piston and spring into case using piston ring compressor, J-3365.
 19. Install low brake band over brake drum.
 20. Place apply strut guide spring over piston shaft and apply strut in piston shaft slot with other end of apply strut engaging brake band.
 21. Place brake band anchor strut assembly in brake band groove, then engage slotted end of anchor over strut, locating other end of anchor over adjusting screw.
- NOTE:** 1953 model struts are not interchangeable with past models.
22. Figure 177 shows layout low brake band assembly.

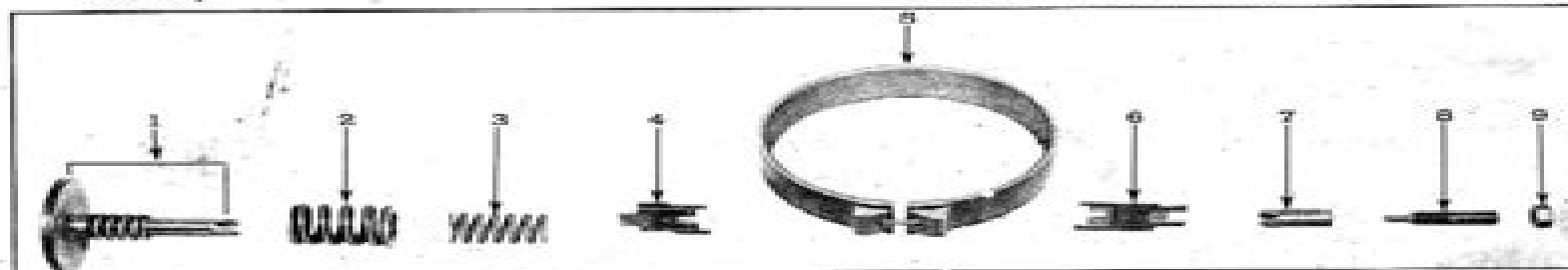


Fig. 177—Layout of Low Brake Band

1. Piston Assembly
2. Piston Return Spring
3. Strut Guide Spring

4. Apply Strut Assembly
5. Brake Band Assembly
6. Anchor Strut Assembly

7. Anchor
8. Anchor Adjusting Screw
9. Adjusting Screw Lock Nut

23. Install governor assembly in the bore in the transmission case, allowing it to rotate in a counterclockwise direction, as the driven gear of the governor meshes with the drive gear of the output shaft.
- CAUTION:** Installation should be done carefully so as not to damage gear teeth.
24. Install two $\frac{5}{16}$ "-18 x 3" guide pins (part of Pilot Stud Set J-3387) as guides for governor cover and install new gasket.
 25. Install governor cover over guide pins and install attaching bolts and lock washers. Tighten to 6½-8½ ft. lbs.
 26. Install speedometer driven gear and tighten to 45-50 ft. lbs.

TRANSMISSION TO CONVERTER HOUSING ASSEMBLY

1. Install manual valve in valve body and manual valve inner lever in converter housing.

- Index lever pin with pick up slot in valve.
2. Set manual valve so end of valve protrudes 1½" from face of valve body. This places valve in reverse position.
3. Install new valve body to case gasket.
4. Raise transmission manual valve lever to top detent position which is reverse. This aligns reaction lever so that it will index with manual valve inner lever.
5. Place clutch drum thrust washer over oil delivery sleeve.
6. Install two $\frac{5}{16}$ "-16 x 3¾" guide pins (part of Pilot Stud Set J-3387) in converter housing, then push case and converter housing together checking to see that reaction lever indexes properly with manual valve inner lever. Then install case to housing bolts and lockwashers and tighten to 25-30 ft. lbs.
7. From front of converter housing, install special self locking bolt. Tighten to 25-30 ft. lbs.

8. Install two $\frac{5}{16}$ "-18 x 3" guide pins (part of Pilot Stud Set J-3387) as guides for servo cover and install new servo cover gasket.
 9. Install pressure regulator valve and inner and outer valve springs. Install reverse servo return spring.
 10. Install servo cover applying pressure to cover to compress springs and secure with servo cover bolts. Tighten to 12½-15 ft. lbs.
- NOTE:** Be sure pressure regulator springs and reverse servo spring seat properly in seat pockets of servo cover.
11. Install new modulator cover gasket and modulator cover and tighten attaching bolts to 12½-15 ft. lbs.
 12. Tighten low servo adjusting screw, using tool, J-4277, down solid and back off four complete turns and tighten lock nut securely (fig. 178). Replace adjusting screw cap.

Gm Powerglide Overhaul Manual

Jim Pickering



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