

### 6L80/6L90 PUMP STATOR TORQUE PROCEDURE

Ensure precise seating of the 6L80/6L90 stator within the pump housing by employing an interference, press-in-fit method. Avoid relying on bolts to bring the two components together, as this may hinder proper stator seating or result in bolt stretching. Before initiating the torque procedure, gently pressurize the stator using a press.

It is imperative to use a thread locker on all six bolts before commencing the torque sequence. Begin torquing at 60 inch-pounds, following a star pattern as illustrated. Re-torque to 90 in the same star pattern, repeating until reaching 120 in-lbs.

Regularly inspect all bolts and promptly replace any exhibiting signs of stress, particularly in the washer portion of the bolt head, as these components are prone to failure.

