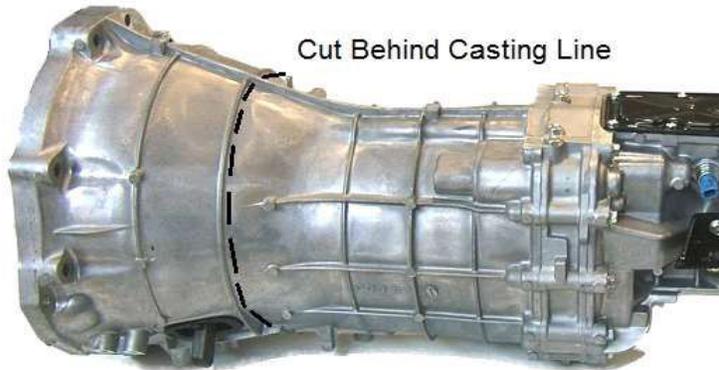


Thanks for your purchase of a CD009 transmission adapter to Volvo Redblock!

I have put together this simple installation guide to help you get it in smoothly. While it is a simple installation, it is recommended to read these instructions at least once.

1) Cutting

The first thing you need to do is cut the stock bellhousing off. There is several video of this on youtube. Keep the stock bearing plate while cutting it so you don't end up with aluminum chips in the transmission. It is recommended to cut on the right side of the Casting Line, along the dotted line shown in the following picture.



Next is to cut 1/4" off the input shaft. Simply draw a line on the shaft, cut with a cutting wheel and grind a small and smooth bevel so the input shaft will easily fit in the pilot bearing. You can also get the transmission in low gear so the shaft won't turn while getting cut.



2) Drain and Clean

If not done yet, drain the transmission. Before unbolting the stock bearing flange, clean the casting all around from all the clutch disc dust, then proceed to remove the stock bearing flange. You can discard the old gasket as you will install a new one. Clean the face of the transmission and remove any leftover of the old gasket.

3) Adapter Installation

Take the adapter and make sure that all faces are clean. Using the 11x M8 SHCS bolt that are supplied and the supplied gasket, torque down the adapter plate on the transmission. Make sure there is an O'Ring inside the transmission adapter. The 4 lower bolt (as shown in the following picture) must be sealed. They could let some gear oil drip out if not sealed as the oil level is over them. Use the included one time use .02 oz Loctite 545 capsule on these 4 bolt. Face sealant like Loctite 510 can also be used on both side of the gasket if

available.



4) Prepare the BellHousing

Working inside the Volvo bellhousing, remove the circlip from the throwout bearing sleeve. You'll want to remove the throwout bearing and fork for this operation. Using a piece of wood, drive the throwout bearing sleeve out of the bellhousing, which will also press out the M46 transmission seal. Once this is done, carefully clean all of the back face of the bellhousing from old gasket and grease. Install the supplied 30x40x7 seal on the throwout bearing sleeve as shown on the following picture then install the sleeve with the same piece of wood.



4) Install the BellHousing

Identify which bolt pattern you need to use and install the bellhousing on the adapter with the supplied flanged bolt. It might be hard to put in place by hand; the O'Ring inside the adapter plate will seal the throwout bearing sleeve. The bellhousing is held down by 4 M10 Flanged bolt. Torque each bolt little by little until the adapter and bellhousing are fully seated.

5) Install the Pilot Bearing

The transmission life is dependant of a good pilot bearing. It is now time to remove your original pilot bearing and install a 16 x 35 x 11 bearing. If you purchased one with your kit, it will be included in the hardware kit.

If you have any question, feel free to contact me at info@deeworks.ca

Thanks!

-DeeWorks.ca