



**6L80 Transmission Installation Kit Instructions**

**Kit P/N - 19367014**

**Instruction Sheet – 19367015**

**THIS TRANSMISSION INSTALLATION KIT IS FOR A CHEVROLET PERFORMANCE 6L80 TRANSMISSION INSTALLATION TO AN "LS" STYLE CRATE ENGINE USING A CHEVROLET PERFORMANCE ENGINE CONTROL SYSTEM.**

Thank you for choosing Chevrolet Performance as your high performance source. Chevrolet Performance is committed to providing proven, innovative performance technology that is truly more than just power. Chevrolet Performance parts are engineered, developed and tested to exceed your expectations for fit and function. Please refer to our catalog for the Chevrolet Performance Parts Authorized Center nearest you or visit our website at [www.chevroletperformance.com](http://www.chevroletperformance.com).

This publication provides general information on components and procedures that may be useful when installing or servicing a Supermatic Transmission. Please read this entire publication before starting work. Also, please verify that all of the components listed in the Package Contents section below were shipped in the kit.

The information below is divided into the following sections: package contents, component information, and Supermatic Transmission specifications, additional parts that you may need to purchase, torque specifications, and a service parts list.

It is not the intent of these specifications to replace the comprehensive and detailed service practices explained in the factory service manuals.

For information about warranty coverage, please contact your local Chevy Performance parts dealer.

Observe all safety precautions and warnings in the service manuals when installing a Supermatic Transmission in any vehicle. Wear eye protection and appropriate protective clothing. Support the vehicle securely with jack stands when working under or around it. Use only the proper tools. Exercise extreme caution when working with flammable, corrosive, and hazardous liquids and materials. Some procedures require special equipment and skills. If you do not have the appropriate training, expertise, and tools to perform any part of this conversion safely, this work should be done by a professional.

The information contained in this publication is presented without any warranty. All the risk for its use is entirely assumed by the user. Specific component design, mechanical procedures, and the qualifications of individual readers are beyond the control of the publisher, and therefore the publisher disclaims all liability incurred in connection with the use of the information provided in this publication.

**Legal and Emissions Information**

This publication is intended to provide information about the Supermatic Transmission and related components. This manual also describes procedures and modifications that may be useful during the installation of a Supermatic Transmission. It is not intended to replace the comprehensive service manuals and parts catalogs which cover Chevrolet engines and components. Rather, it is designed to provide supplemental information in areas of interest to "do-it-yourself" enthusiasts and mechanics.

This publication pertains to transmissions and vehicles which are used off the public highways except where specifically noted otherwise. Federal law restricts the removal of any part of a federally required emission control system on motor vehicles. Further, many states have enacted laws which prohibit tampering with or modifying any required emission or noise control system. Vehicles which are not operated on public highways are generally exempt from most regulations, as are some special interest and pre-emission vehicles. The reader is strongly urged to check all applicable local and state laws.



Many of the parts described or listed in this manual are merchandised for off-highway application only, and are tagged with the "Special Parts Notice" reproduced here:

**Special Parts Notice**

This part has been specifically designed for Off-Highway application only. Since the installation of this part may either impair your vehicle's emission control performance or be uncertified under current Motor Vehicle Safety Standards, it should not be installed in a vehicle used on any street or highway. Additionally, any such application could adversely affect the warranty coverage of such an on-street or highway vehicle.

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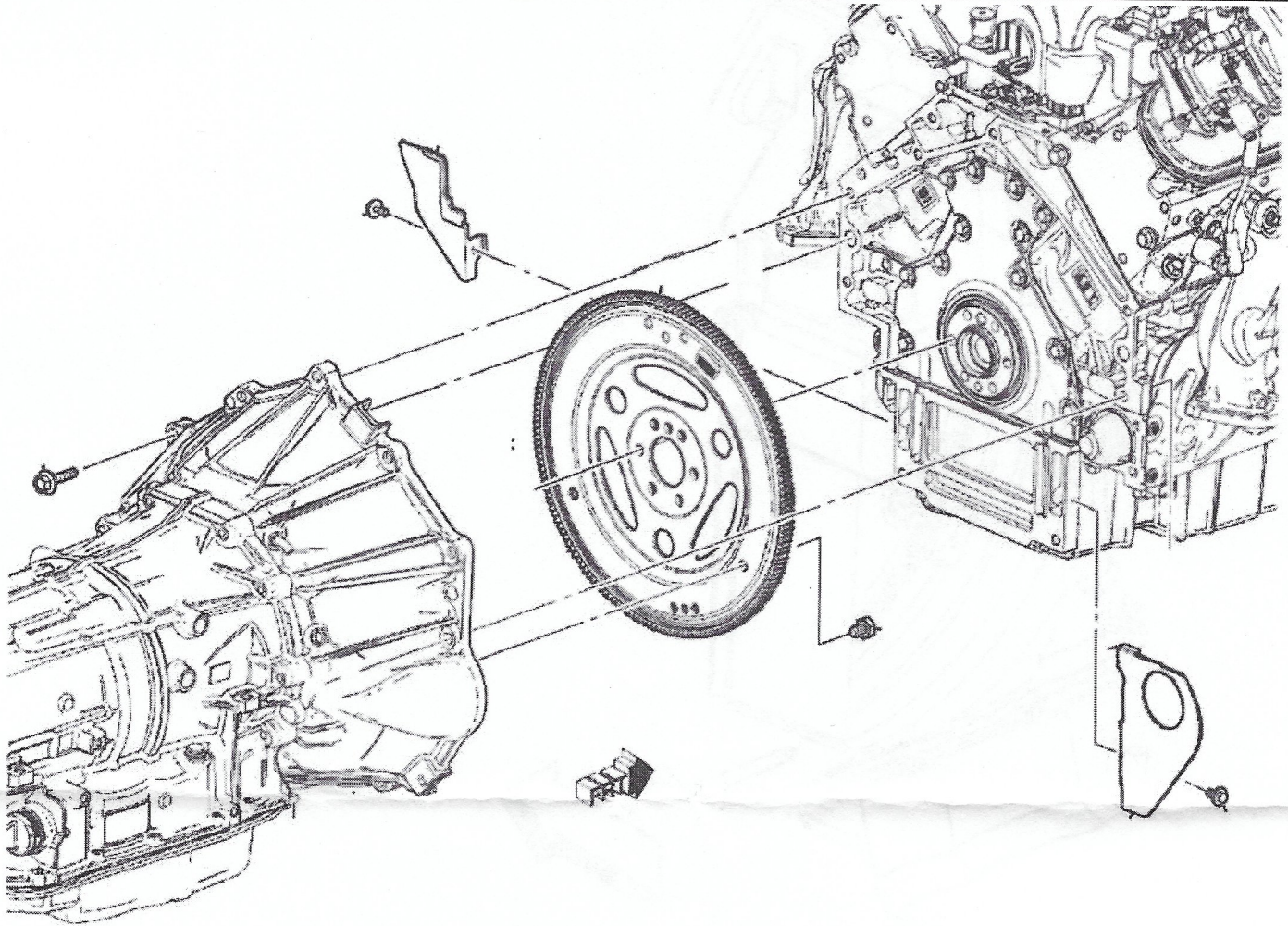
**Kit Contents:**

**Kit P/N 19367014**

Qty	Part Number	Description
1	19367015	Instruction Sheet
3	11546840	Bolt, M10x1.5x21.5 – Torque Converter Attachment
8	11515768	Bolt M10x1.5x40 – Transmission Attachment
2	11519376	Bolt, M6x1x23 – Side Cover Attachment
1	24283130	Cover-Trans LH
1	24282999	Cover-Trans RH

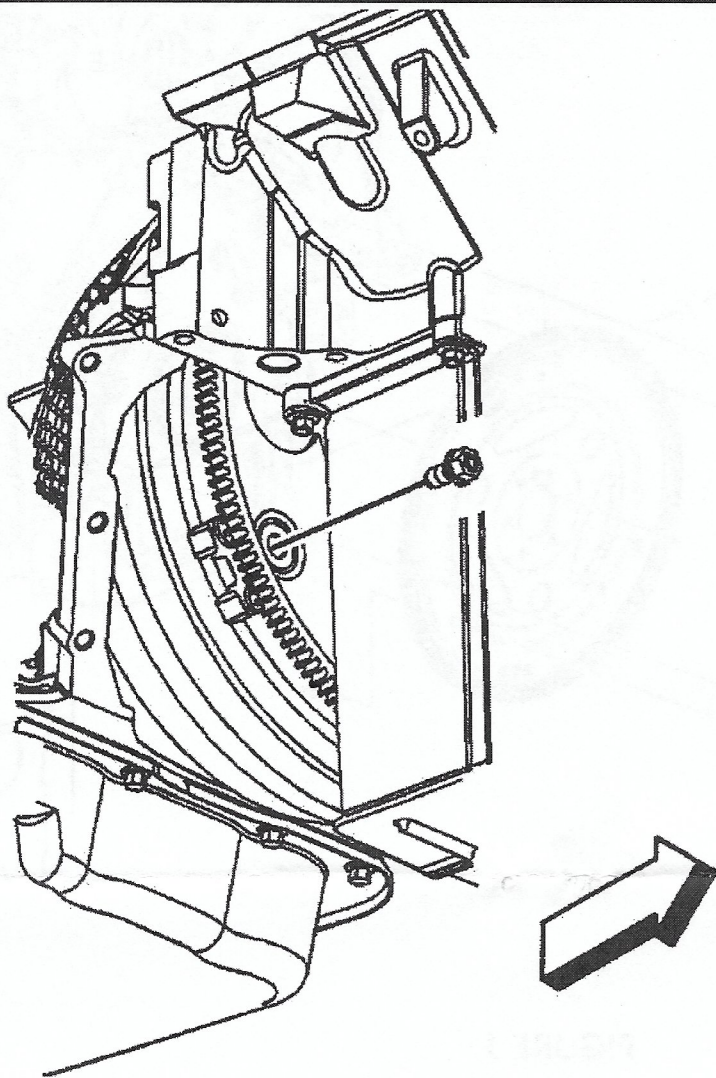
**Transmission Installation:**

1. Remove the converter holding strap from the transmissions. Spin the torque converter to engage the turbine shaft splines in the torque converter hub, the stator shaft splines in the stator race and to engage the drive flats on the converter pump hub with the oil pump drive gear.
2. Install vent tube assembly (part of transmission kit) if it has not been.
3. Install transmission to engine using 8 11515768 bolts as shown in Figure 1. Install bracket from transmission kit under center top bolt to facilitate holding vent tube (part of transmission kit). Torque to 58 Nm (43 lb-ft).
4. Install side covers using 11519376 bolts. Torque to 12 Nm (106 lb-in).



**FIGURE 1**

5. Push the torque converter forward (remove the torque converter access plug in the bottom of the bell housing) to seat the converter pilot in the crank bore. Re-install the torque converter access plug, if needed.
6. Install torque converter attachment bolts as shown in Figure 2, through starter hole. Install one bolt hand tight, rotate engine install next bolt hand tight, rotate engine, install last bolt. Torque to 65 Nm (48 lb-ft). Rotate engine to torque remaining bolts. If rotating engine using crank balancer bolt, rotate only in clockwise direction (as standing in front of engine). The crank balancer bolt should only be turned in a "tightening" direction. Note: if re-using torque converter bolts, clean the bolt threads and apply sealant.



**FIGURE 2**

7. Transmission oil cooler lines must be installed for proper transmission function and durability. AN-6 fittings are provided on the transmission to facilitate cooler line installation. The cooler line adapter may be removed if production style lines are used – the inserts in the transmission should not be removed.
8. Ensure the transmission is properly filled with oil prior to operation.