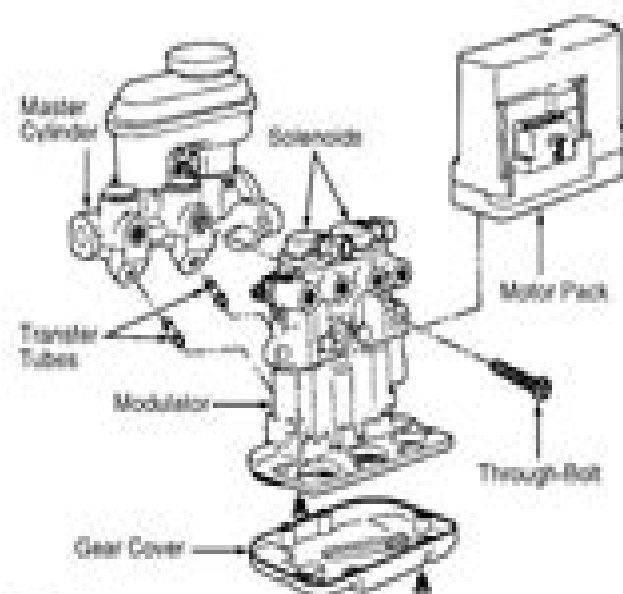


DO NOT drop motor pack. If motor pack is dropped, replacement is necessary.

- Remove 2 ABS modulator-to-master cylinder through bolts and "O" rings. Separate master cylinder from ABS modulator. Remove 2 transfer tubes and "O" rings from master cylinder to ABS modulator. See Fig. 4. If ABS modulator is being replaced, ensure gears are installed in same location on replacement ABS modulator. See **ABS/ELS MODULATOR GEARS**.



GM-077194

Fig. 4. Identifying ABS Modulator/Motor Pack & Master Cylinder Assembly Components  
Courtesy of GENERAL MOTORS CORP.

**NOTE:** DO NOT reuse transfer tubes or "O" rings. Install NEW components.

#### REASSEMBLY

- To assemble master cylinder and ABS modulator, lubricate NEW transfer tube "O" rings and NEW through-bolt "O" rings with clean brake fluid. Install NEW transfer tubes with "O" rings into ABS modulator. Install NEW through-bolt "O" rings into master cylinder and ABS modulator.

- Clamp mounting flange of master cylinder in a soft-jawed vise. Assemble master cylinder to ABS modulator. Ensure transfer tubes and "O" rings are not damaged during assembly. Tighten ABS modulator-to-master cylinder through bolts to specification. See **TORQUE SPECIFICATIONS**.
- Place master cylinder and ABS modulator assembly upside-down with gears facing you, rotate each gear counter-clockwise until maximum stops. Rotating gears counter-clockwise will position pistons very close to top of ABS modulator bore, making brake bleeding easier.
- To complete assembly, reverse disassembly procedure. Ensure motor pack gears are aligned with ABS modulator gears. Bleed brake system. See **BLEEDING BRAKE SYSTEM**.

## TORQUE SPECIFICATIONS

### TORQUE SPECIFICATIONS

| Application                                    | Ft. Lbs. (Nm) |
|------------------------------------------------|---------------|
| ABS Modulator To Master Cylinder Through Bolts | 17 (23)       |
| Axis Shaft Nut                                 | 111 (200)     |
| Brake Caliper Bolts                            | 67 (92)       |
| Front Hub/Bearing Assembly Bolts               | 96 (130)      |
| Master Cylinder To Vacuum Booster Nut          | 20 (27)       |
| Modulator Brake Pipe Fitting                   | 18 (25)       |
| Wheel Lug Nuts                                 | 100 (136)     |
| <b>PSI (lb.) (Nm)</b>                          |               |
| Brake Caliper/Cylinder Bleeder Valves          |               |
| Front                                          | 113 (15)      |
| Rear                                           | 67 (9)        |
| Modulator Bleeder Valves                       | 80 (9)        |
| Modulator Gear Cover Screws                    | 33 (4)        |
| Modulator Gear Retaining Nut                   | 70 (9.5)      |
| Motor Pack To Modulator Screws                 | 40 (5.5)      |
| Solenoid To ABS Modulator Screws               | 40 (5.5)      |

## WIRING DIAGRAM

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**Clemens Wendtner**



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