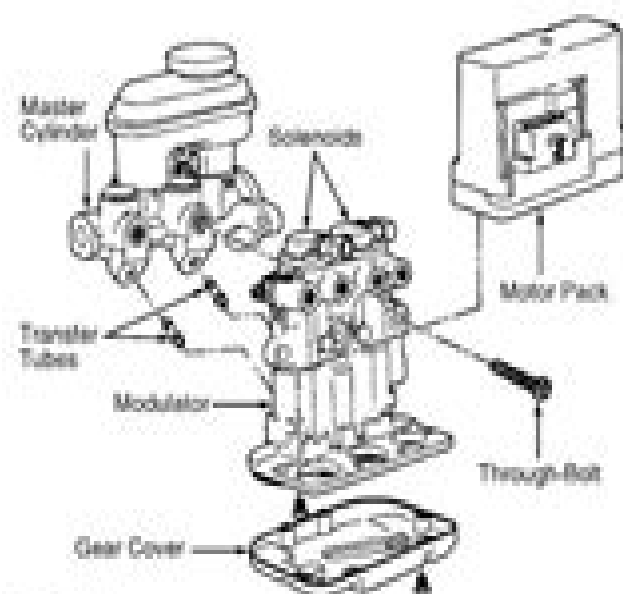


DO NOT drop motor pack. If motor pack is dropped, replacement is necessary.

- 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 movement 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)
Axle 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)
PSI (lb.) (Nm)	
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 (8.5)
Motor Pack To Modulator Screws	80 (8.5)
Solenoid To ABS Modulator Screws	80 (8.5)

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`y = 1 5 0 2743 0 3446 0 4207 0 5000 0 5793`

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