



## 30 spline inner axle upgrade

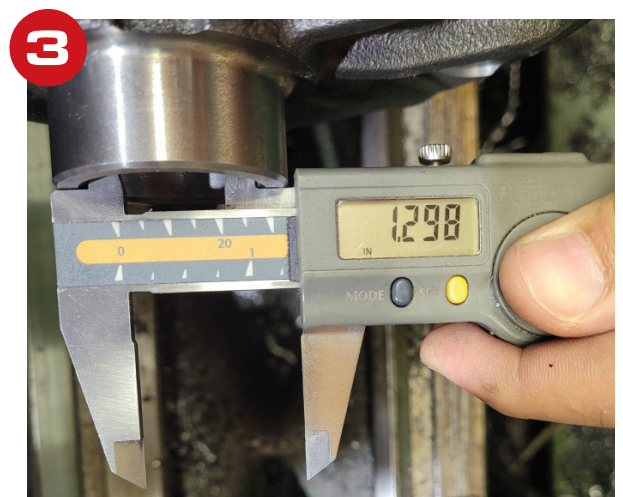
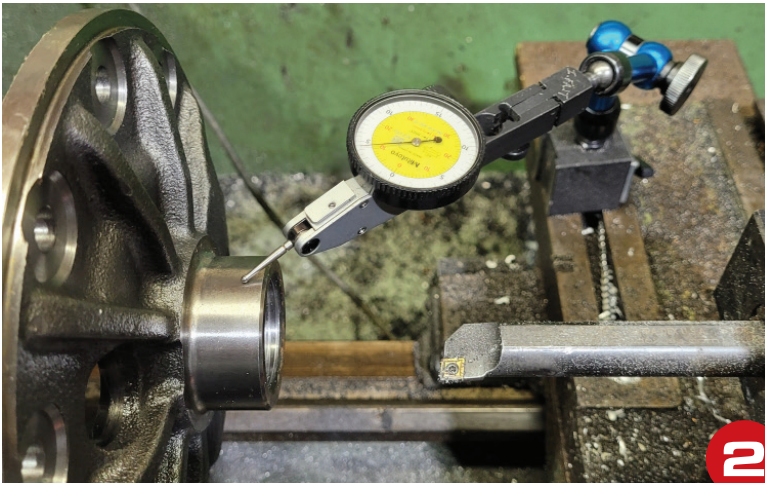
HSHP-25K

### Parts List:

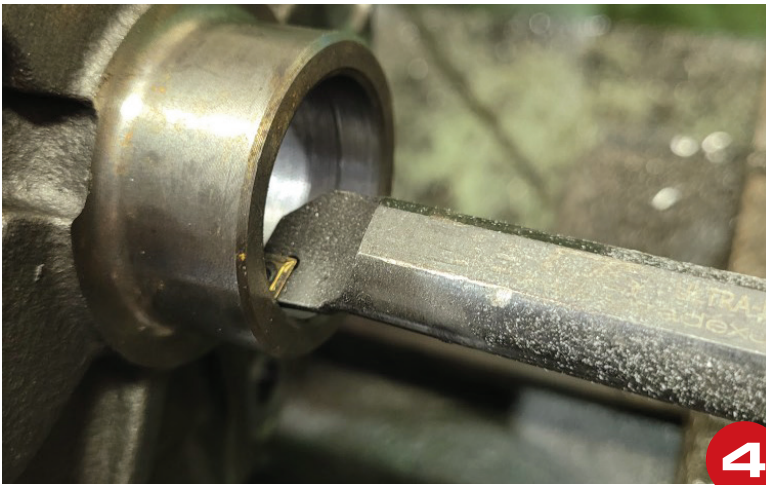
- (2) 30 spline inner axles
- 30 spline spider gears
- (2) 10 Vette thrust washer
- (2) half shaft flanges

Once the differential is out of the car, you must pull the posi unit and completely disassemble it. The posi unit needs to be machined for the new larger side yokes to fit. Please read instructions thoroughly before proceeding to machining.

1. Remove the carrier bearings, ring gear, plates and springs, then clutches.
2. Chuck the posi in a lathe and ensure it's centered. Dial indicator is to make sure the unit is running true on the lathe before machining.
3. Standard ID on the posi is around 1.247". This will need to be opened up a diameter of 1.295" for the new axles with a step cut coming next.







4. Continue opening the outer edge bore in .020" increments until .100" of material is removed creating a step that is .325" deep.
5. Your posi should now have a bore of 1.295" and a step that is 1.395" on the outer edge of the bore that is .325" deep. This allows the new side yokes to be pushed in far enough to install the 12 bolt c-clips during assembly of the differential.
6. Finally, sand or file the hard edges and clean the posi before re-assembling.

