



**ATS**  
**BILLET**  
**FLEX PLATES**

**ASSEMBLY/INSTALLATION  
INSTRUCTION MANUAL**



**5R110 · ATS BILLET FLEX PLATE**

**FORD 2003-2007 6.0L / 2008-2010 6.4L POWER STROKE**

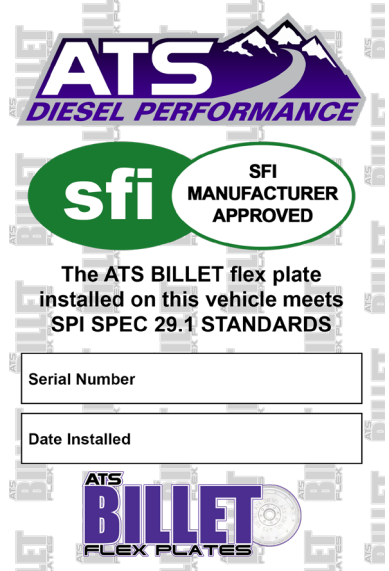


# ATS BILLET FLEX PLATES

Installation Manual v1.0 | ATS P/N: 305-900-3278/3326

5R110 - Billet Flex Plate Kit

Fitment: 2003-2007 Ford 6.0L / 2008-2010 Ford 6.4L Power Stroke



**NOTE:** ATS Billet Flex Plate installation instructions operate under the assumption that the transmission has been removed.

## Please read all instructions before attempting installation.

SFI approved billet flexplates from ATS will hold up under the most extreme conditions. ATS billet flexplates are SFI approved, meaning that they stand up to the toughest race application standards. These are crafted out of strong billet steel allowing your transmission to shift faster and harder with out running the risk of breaking the flexplate.

## BILL OF MATERIALS

1. (1) ATS Billet Flex Plate (305-900-3278 / 305-900-3326)

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Transmission Installation Procedure Manual



## INSTRUCTIONS

1. Remove the ten bolts securing the factory flex plate to the crankshaft.
2. Install the ATS Billet Flexplate using the 10-factory bolts. Make sure to place the flex plate over the alignment pin on the crankshaft. If the pin is missing, it must be replaced with a new pin from a Ford dealer. The pin ensures correct alignment of the counterbalance on the flex plate to prevent bearing failure.
3. Torque (10) crankshaft bolts **first to 44 in-lbs** in the numbered sequence as shown on the following page. (See Fig 1).

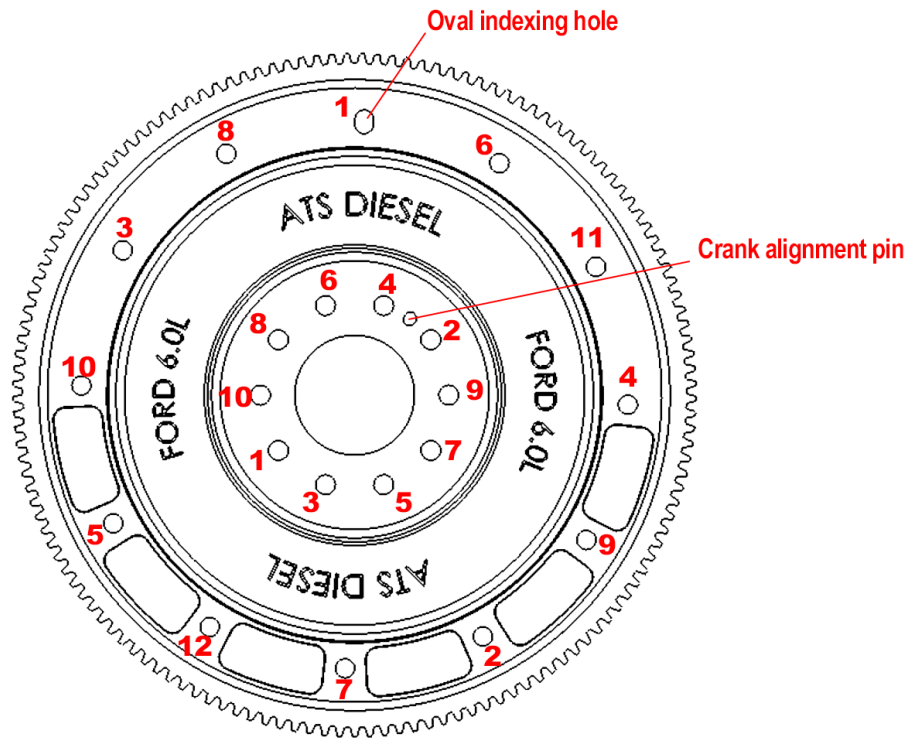


Figure 1: Oval Index Hole and Torque Sequence

4. Torque (10) crankshaft bolts **last to 69 ft-lbs** in the number sequence as shown above. (See Fig 1).
5. With the transmission reinstalled, thread the first torque converter bolt/nut through the oval shaped hole (See Fig. 1). This hole will line up the rest of the torque converter bolts and will make installation easier.
6. If using a factory torque converter with 6 threaded studs, only 6 of the 12 holes are needed. (See Fig. 1, use torque sequence 1-7-3-9-5-11). Torque the nuts to **26 ft-lbs** (6.0L) or **35 ft-lbs** (6.4L).
7. If using an ATS TripleLok Torque Converter, torque the bolts to 35 ft-lbs using a 1-7-3-9-6-11 sequence.
8. If using an ATS 5-Star Torque Converter, torque the bolts to **35 ft-lbs** using the bolt sequence (1 thru 12) shown in Fig. 1.
9. Re-torque each bolt the correct ft-lb as noted above in steps 6 thru 9 using the specified sequence.
10. Reinstall the cover plate.





#### LIMITED WARRANTY STATEMENT:

ATS Diesel Performance warrants the original purchaser that any parts purchased shall be free from defects in material and workmanship. ATS Diesel Performance is the warrantor of this product, in the event this product is purchased from a distributor or retailer other than ATS Diesel Performance the customer must contact ATS Diesel Performance for any warranty concerns, not the purchasing dealer. A defect is defined as a condition that would render the product inoperable. This warranty does not cover deteriorating of plating, paint or any other coating. ATS liability is limited to the repair or replacement, at ATS's option, of any warrantable product returned prepaid with a complete service history and proof of purchase to the factory. A valid proof of purchase is a dated bill of sale. Repaired or replaced, product will be returned to the customer, freight collect on a like-for-like part number basis. Accepted warranty units, which have been replaced, become the sole property of ATS.

A Return Product Authorization number obtained in advance from an ATS customer service representative must accompany products returned for warranty determination. ATS will be the final authority on all warranty decisions.

This warranty shall not apply to any unit which has been improperly stored or installed, subjected to misapplication, improper operating conditions, accidents, or neglect; or which has been improperly repaired, altered or otherwise mistreated by the owner or his agent.

This warranty shall terminate at the end of 12 months in service with the original user. Labor cost incurred by the removal and replacement of an ATS product, while performing warranty work, will be the responsibility of the vehicle owner; in no case does the obligation of ATS Diesel Performance exceed the original purchase price of the product as indicated on the original bill of sale.

Except as set forth in this warranty, ATS disclaims any implied warranty, including implied warranties of merchantability and fitness for a particular purpose. ATS also disclaims any liability for incidental or consequential damages including, but not limited to, repair labor, rental vehicles, hotel costs or any other inconvenience costs. This warranty is in lieu of all warranties or guarantees, either expressed or implied, and shall not extend to any customer or to any person other than the original purchaser residing within the boundaries of the continental US or Canada.



**NOTE:** We strive to make our instructions as clear and complete as possible. To achieve this, our instructions are under constant construction. We encourage you to visit our Technical Support Website (<http://www.atsdiesel.com/ATSWebSite/Technical.asp>) to check for the most up-to-date manuals and diagrams as well as other information. If you have any suggestions as to how we can improve this installation manual, let us know at: [suggestions@atsdiesel.com](mailto:suggestions@atsdiesel.com)



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#### TROUBLESHOOTING:

Thank you for purchasing the ATS Billet Flex Plate for the Ford 5R110 transmission. This manual is to assist you with your installation and operation of the unit. Please use the contact information below for assistance with any questions regarding this installation. If you are installing the unit for a customer, please pass this manual on to your customer for future reference.