



Catalog No. ATA-05

Replacement Parts for Allison Automatic Transmissions

What's new in this catalog?

- ★ Updated transmission coverage
 - Expanded Sections
 - CT/CLT/CRT 3000 (3340/3461)
 - CLBT 4000 (4460/HT70)
 - TT 2000/3000/4000
 - CLBT 5000/6000/8000
 - Marine M/MH (M10/M45)
- ★ Updated OEM to Transtar part number interchange.
- ★ And . . . MORE NEW PARTS!



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(See inside back cover for complete addresses.)

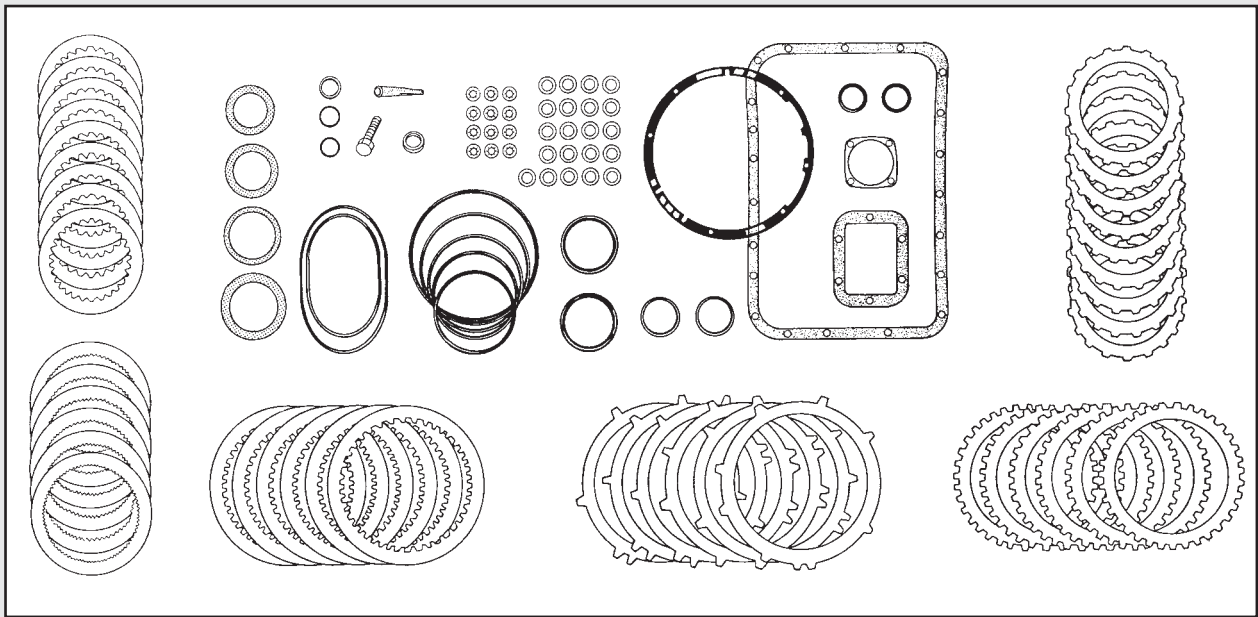
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REPAIR KIT PROGRAM

Designed BY rebuilders FOR rebuilders, the table below explains the contents of each type of kit available, ranging from Minor to Major Overhaul.

	Paper & Rubber Kit	Metal Clad Seals	Ring Kit	Friction Clutches	Steel Plates
Master Overhaul Kit	✓	✓	✓	✓	✓
Less Steels Kit	✓	✓	✓	✓	
Overhaul Kit	✓	✓	✓		
Front Pump Re-Seal Kits (Designed for "In-Vehicle" repair of a leaking Front Pump, it contains the Paper Gasket, Lathe Cut Seal and Bolt Washer Seals.)					



TYPICAL MASTER OVERHAUL KIT

ALLISON TRANSMISSION SECTIONS

Most Allison transmission sections start with an illustration page showing an exploded view of the transmission along with an illustration number. The illustration number is in the first column of each parts section. The parts section always lists kits first, followed by the other commodity sections and is the same way throughout the catalog.

Kits There are three basic levels of Kits. The chart above shows the contents for each level.

Pan Gaskets Two types of pan gaskets may be used depending on transmission type. To order cork/neoprene use a "X" suffix, Armstrong® uses a "W" suffix.

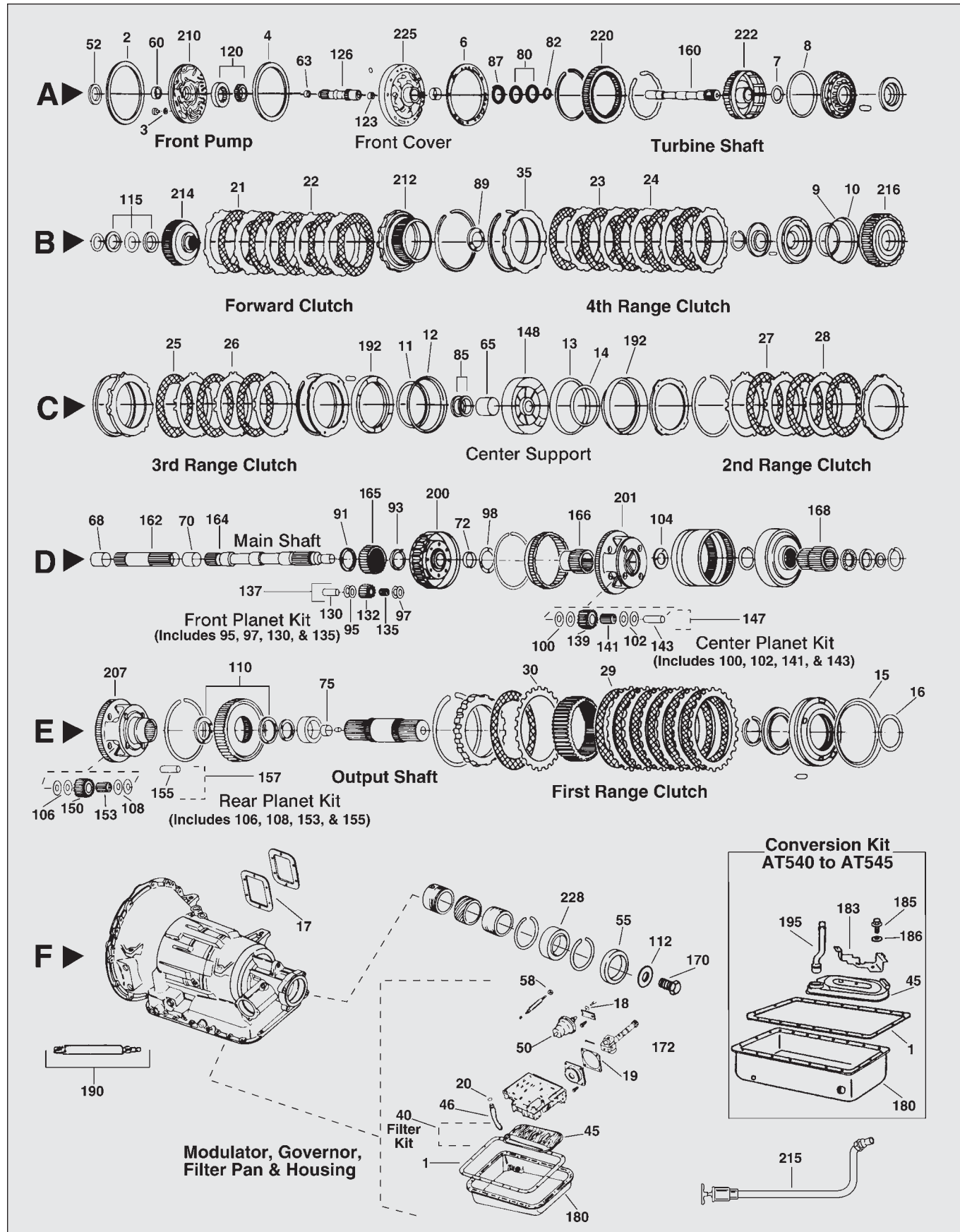
Clutch Plates, and Sealing Rings Parts made by a specific manufacturer or made of a specific material can be ordered by using a specific prefix or suffix. The proper prefix or suffix to use is in each commodity section.

Hard Parts All Hard parts are assigned a base number. Brand designation can be obtained by adding a suffix letter to the base number, (i.e. "-R" suffix = Remanufactured Parts). Applications may only require the base number for OEM/Aftermarket new. A "-R" suffix for remanufactured. Exceptions will be listed individually in each section. A separate column is provided to indicate primary or specific brand/type.

Miscellaneous Items that don't easily fall under the usual commodity headings; i.e., manuals, tools, fittings, etc.

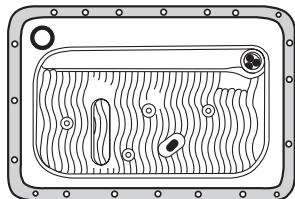
ALLISON AT540, 543, 545

To Get The Correct Parts, You Must Provide The Assembly Number Found On The Transmisson Name Plate.



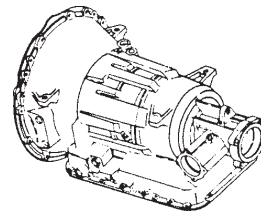
ALLISON AT540, 543, 545

NOTE: Early AT540/545 parts up to serial number 3210775436.
Late AT545 parts from serial number 3210775437.



21 Bolt Pan

Allison Transmissions
AT540, 543, 545



Rear Wheel Drive

REBUILDER KITS

DESCRIPTION	QTY.	YEAR	DELUXE KIT	MASTER O/H KIT	LESS STEELS KIT	OVERHAUL KIT	GASKET & SEAL KIT
Rebuilder Kits - Exc. 543 - w/Armstrong®	1	-		K1100	K1100-LS	K11900W	
Overhaul Kit - Exc. 543 - w/Cork & Neoprene	1	-				K11900 K11900A	
Rebuilder Kits - 543 European	1	-		K1100A			
Front Pump Re-Seal Kit - All (1)	1	-					K11900-2
(1) Contains front pump gasket, rubber lathe-cut seal, o-ring and pump bolt washers.							

ILL.	DESCRIPTION	QTY.	YEAR	PART NO.	REFERENCE NO.
MISCELLANEOUS GASKETS & SEALS/PAN GASKETS					
1F	Gasket - Oil Pan - Cork - Neoprene (23016682)	1	-	13540X	29501160
1F	Gasket - Oil Pan - Update - Armstrong® (23016682)	1	-	13540W	29501160
N.I.	Gasket - Converter Pump Hub - 543 - Bolt On Hub (29524795)	1	-	13150W	29536726
N.I.	Seal - Lathe Cut - Converter Pump - 543	1	-	13151	23016564
2A	Seal - Lathe Cut - Front Pump Body	1	-	3877L	23016559
3A	Seal - Washer - Front Pump Body Bolt	9	-	13268A	8626281
4A	Seal - Lathe Cut - Front Pump Support	1	-	13152	23016600
6A	Gasket - Front Pump To Case	1	-	13153	23015883
7A	Lip Seal - Forward Clutch - Inner (8623102)	1	-	3956L	29520291
8A	Lip Seal - Forward Clutch - Outer (8623101)	1	-	3643L	29520292
9B	Lip Seal - Fourth Clutch - Inner	1	-	3284L	23015880
10B	Lip Seal - Fourth Clutch - Outer	1	-	3643L	8623101
11C	Lip Seal - Third Clutch - Inner	1	-	13154	23011475
12C	Lip Seal - Third Clutch - Outer	1	-	13155	23011456
13C	Lip Seal - Second Clutch - Outer	1	-	13155	23011456
14C	Lip Seal - Second Clutch - Inner	1	-	13154	23011475
15E	Lip Seal - First Clutch - Outer (23011474)	1	-	13156	29509198
16E	Lip Seal - First Clutch - Inner (23011457)	1	-	13157	29509983
17F	Gasket - Power Takeoff Cover - Update - Armstrong®	1	-	13158W	29501161
18F	O-Ring - Modulator (23017367)	1	-	3410L	8658110
19F	Gasket - Governor Cover - Fibre	1	-	3914D	23011670
20F	O-Ring - Oil Filter	1	-	3547L	1363951
N.I.	Washer - Drain Plug (Metal)	1	-	11423	29507909
N.I.	Washer - Drain Plug (Coated)	1	-	11423B	29507909
N.I.	Check Ball - 1/4"	1	-	13924	23045388
N.I.	Check Ball - 5/16"	1	-	13924A	23045386
CLUTCH PLATES					
21B	Friction - Forward Clutch (2)	5	-	R11103	23042197
21B	Friction - Forward Clutch (3)	5	-	W11103	23042197
23B	Friction - Fourth Clutch (2)	5	-	R11103	23042197
23B	Friction - Fourth Clutch (3)	5	-	W11103	23042197
25C	Friction - Third Clutch (2) (29529492)	3	-	R11104	29537887
25C	Friction - Third Clutch (3)	3	-	W11104	29537887
(2) Raybestos brand plate. OEM approved heat-treated paper. (3) S.K. Wellman plate. OEM approved graphitic.					

ALLISON

AT540, 543, 545

To Get The Correct Parts, You Must Provide The Assembly Number Found On The Transmission Name Plate.

ILL.	DESCRIPTION	QTY.	YEAR	PART NO.	REFERENCE NO.
CLUTCH PLATES (Cont.)					
27C	Friction - Second Clutch (2) (29529492)	3	-	R11104	29537887
27C	Friction - Second Clutch (3)	3	-	W11104	29537887
29E	Friction - First Clutch (2)	7	-	R11106	23042198
29E	Friction - First Clutch (3)	7	-	W11106	23042198
22B	Steel - Forward Clutch (6836518)	5	-	34305C	29530330
24B	Steel - Fourth Clutch (6836518)	5	-	34305C	29530330
26C	Steel - Third Clutch (23045554)	3	-	11105	29515399
28C	Steel - Second Clutch (23045554)	3	-	11105	29515399
30E	Steel - First Clutch	7	-	11107	6831705
35B	Plate - Backing - 4th Clutch	1	-	11763	23017763
N.I.	Plate - Waved - Forward Clutch	1	-	11875	29505875
(2) Raybestos brand plate. OEM approved heat-treated paper. (3) S.K. Wellman plate. OEM approved graphitic.					
FILTERS/FILTER KITS					
40F	Filter Kit - Screen - with Cork - Neoprene	1		FK11800	6884270
40F	Filter Kit - Screen - Armstrong®	1	-	FK11800W	29502295
40F	Filter Kit - Treated Paper - with Cork - Neoprene	1	-	FK11800A	PF-168
40F	Filter Kit - Treated Paper - Armstrong®	1	-	FK11800AW	29506392
40F	Filter Kit - Screen - Late AT Deep Pan (29513271)	1	-	FK34661SW	29540976
N.I.	Filter Kit - Deep Pan Design (contains tube, bracket)	1	-	UDK-545-1	29538490
45F	Filter - External Spin on Cartridge - One Quart (PH35109)	1	-	PF897	25611122
45F	Filter - Metal Screen (6884270)	1	-	11800	29502295
45F	Filter - Brass Screen	1	-	34661S	29500365
45F	Filter - Treated Paper	1	-	11800A	N.L.
45F	Filter - 545 Update	1	-	21800	6883044
N.I.	Screen - Governor Tube	1	-	11712	23045247
VACUUM MODULATORS					
50F	Modulator - w/ O-Ring - Lg Can	1	-	11820	3039092
	Modulator - w/ O-Ring - Sm Can	1	-	11820A	29501199
METAL CLAD SEALS					
52A	Front Pump - Vamac Material	1	-	38151V	8641300
55F	Extension Housing	1	-	11850	6778050
58F	Selector Shaft	1	-	38511	23010610
BUSHINGS					
N.I.	Bushing Kit - 7 Bushings - AT540/ Early 545	1	-	K11902	N.L.
	Bushing Kit - 7 Bushings - Late 545	1	-	K11902A	N.L.
60A	Front Pump Body - Babbitt - Update Version (23018806)	1	-	8005	29511860
63A	Stator Shaft - Front - Bronze Lined (6836272)	1	-	34002	23015807
65C	Center Support - 1.540 O.D.	1	-	11000	23012990
	Center Support - 1.600 O.D.	1	-	11000A	29506468
68D	Sun Gear Shaft - Front - 1st Design - 1.125 O.D. (6836272)	1	-	34002	23015807
	Sun Gear Shaft - Front - 2nd Design - 1.190 O.D.	1	-	11007	29522949
70D	Sun Gear Shaft - Rear (6836272)	1	-	34002	23015807
72D	Front Planetary Carrier	1	-	11001	23045072
75E	Output Shaft - .775 O.D.	1	-	11002	8622947
	Output Shaft - .815 O.D.	1	-	11002A	29502231
SEALING RINGS/RING KITS					
N.I.	Sealing Ring Kit - Complete - 5 Rings	1	-	K11901	N.L.
80A	Front Pump	2	-	11302	23046598
82A	Turbine Shaft	1	-	11301	8616052
85C	Center Support	2	-	11302	23046598

ALLISON

AT540, 543, 545

To Get The Correct Parts, You Must Provide The Assembly Number Found On The Transmisson Name Plate.

ILL.	DESCRIPTION	QTY.	YEAR	PART NO.	REFERENCE NO.	
THRUST WASHERS/NEEDLE BEARINGS						
N.I.	Spacer - Turbine:					
	- .015" - Gold - 543	AR	-	11403	6837429	
	- .030" - Silver - 543	AR	-	11403A	6837430	
	- .042" - Plain - 543	AR	-	11403B	6837431	
	- .060" - Black - 543	AR	-	11403C	6837432	
	- .075" - Copper - 543	AR	-	11403D	6837433	
87A	Washer - Front Cover:					
	- .056"-.060" No. "0"	AR	-	11407	6831620	
	- .072"-.076" No. "1"	AR	-	11407A	6831621	
	- .089"-.093" No. "2"	AR	-	11407B	6831622	
	- .105"-.109" No. "3"	AR	-	11407C	6831623	
	- .121"-.125" No. "4"	AR	-	11407D	6831624	
	- .138"-.142" No. "5"	AR	-	11407E	6831625	
89B	Washer - Fourth Clutch Driving Hub	1	-	34301	23013454	
	Washer - Front Sun Gear:					
91D	- Front (up to serial number 3210775436).	1	-	11411	6831658	
	- Front (from serial number 3210775437)	1	-	11411A	29506146	
93D	- Rear .064 -.068" - Color Code Red	AR	-	11412	23013451	
	Washer - Front Planetary:					
95D	- Bronze - Pinion Gear	8	-	11413	6839514	
97D	- Steel - Pinion	8	-	11414	6833991	
98D	- Rear - Carrier	1	-	11415	6831673	
	Washer - Center Planetary:					
100D	- Bronze - Pinion	8	-	11416	6839376	
102D	- Steel - Pinion	8	-	11417	6831680	
104D	- Rear - Carrier (up to serial number 3210775436)	1	-	11418	6831692	
	- Rear - Carrier (from serial number 3210775437)	1	-	11418A	29506147	
	Washer - Rear Planetary:					
106E	- Bronze - Pinion	8	-	11416	6839376	
108E	- Steel - Pinion	8	-	11417	6831680	
110E	Washer - Rear Planet Carrier - Front & Rear	2	-	11419	6831697	
112F	Washer - Output Flange Bolt	1	-	11421	29500739	
N.I.	Washer - Center Support Bolt	1	-	11422	23014094	
N.I.	Washer - Drain Plug (Metal)	1	-	11423	29507909	
N.I.	Washer - Drain Plug (Coated)	1	-	11423B	29507909	
BEARINGS						
115B	Bearing Package - Forward Hub - Front - (3 Piece)	1	-	11503BK	9414211	
N.I.	Bearing/Race Kit	1	-	11500BK	N.L.	
N.I.	Roller Bearing - Converter Stator - 543	1	-	11404	23016866	
HARD PARTS						
Hard Parts may only require the base number for OEM/Aftermarket New or a "-R" suffix for remanufactured. Exceptions are listed individually. NOTE: A separate column is provided to indicate a primary or specific brand/type.						
ILL.	DESCRIPTION	BRAND	QTY.	YEAR	PART NO.	REF NO.
120A	Kit - Front Pump Gear - Oversized		1	-	K11201B	N.L.
120A	Kit - Front Pump Gear .727 Thick		1	-	K11201	N.L.
123A	Roller Bearing - Ground Sleeve		1	-	11221	148415
126A	Ground Sleeve (Finished I.D. - Bearing Inst.)		1	-	11202	23014304
130D	Pin - Front Planetary		4	-	11215	6834309
135D	Needle Roller - Front Planetary		80	-	11919	9426919
137D	Kit - Front Planetary Repair		1	-	K11215	N.L.
141D	Needle Roller - Center Planetary 9426920		76	-	11920	29501499
143D	Pin - Center Planetary		4	-	11216	6831679
147D	Kit - Center Planetary Repair		4	-	K11216	N.L.

ALLISON

AT540, 543, 545

To Get The Correct Parts, You Must Provide The Assembly Number Found On The Transmisson Name Plate.

ILL.	DESCRIPTION	BRAND	QTY.	YEAR	PART NO.	REF NO.
HARD PARTS (Cont.)						
148C	Center Support - Early (7)		1	-	11229	23013015
148C	Center Support - Late - Large Hole (8)		1	-	11229A	29525518
153E	Needle Roller - Rear Planetary		76	-	11920	9426920
155E	Pin - Rear Planetary		4	-	11216	6831679
157E	Kit - Rear Planetary Repair		1	-	K11216	N.L.
160A	Turbine Shaft - Early - All		1	-	11939	6835939
160A	Turbine Shaft - Late - All		1	-	11939B	29525516
162D	Shaft - Sun Gear - Early (7)		1	-	11225	6835937
162D	Shaft - Sun Gear - Late (8)		1	-	11225A	29506158
164D	Shaft - Main - 1" Journal - Early (7)		1	-	11226	23013474
164D	Shaft - Main - Reinforced - 1.060 Journal - Late (8)		1	-	11226B	29524363
165D	Sun Gear - Front - Early (7)		1	-	11232	6835732
165D	Sun Gear - Front - Late (8)		1	-	11232A	29506151
166D	Sun Gear - Center - Early		1	-	11227	6835936
166D	Sun Gear - Center - Late		1	-	11227B	29506150
168D	Sun Gear - Rear - (Low) - Early (7)		1	-	11228	6884902
168D	Sun Gear - Rear - (Low) - Late (8)		1	-	11228A	29506149
170F	Bolt - Output Flange (23014159)		1	-	11222	29510838
172F	Governor Assembly I.D. No. 460		1	-	11410	6881466
172F	Governor Assembly I.D. No. 461		1	-	11410A	6885570
172F	Governor Assembly I.D. No. 462		1	-	11410B	6885571
180F	Oil Pan - Deep - Offset Threaded Inlets		1	-	11545	23045906
180F	Oil Pan - Deep - Even Threaded Inlets		1	-	11545A	29501358
190F	Kit - Manual Selector Shaft		1	-	K11235	23017610
192C	Piston - Center Support		2	-	11817	6834817
200D	Front Planet Assembly (6835768)	R	1	-	11768	23046074
201D	Center Planet Assembly	R	1	-	11676	6831676
207E	Rear Planet Assembly	R	1	-	11719	6837719
210A	Pump Body & Gears - AT540 Only (9)	R	1	-	34200C	23018811
210A	Pump Body & Gears - AT545	R	1	-	34200D	29537354
212B	Hub - 4th Clutch - Early (7)		1	-	11732	23015732
	Hub - 4th Clutch - Late (8)		1	-	11732A	29509661
214B	Hub - Forward Clutch - Early (7)		1	-	11634	6831634
	Hub - Forward Clutch - Late (8)		1	-	11634A	29506145
215F	Tube & Dip Stick Assembly - Universal		1	-	11999U	N.L.
216B	Housing - 4th Clutch - Early (7)		1	-	11769	29510769
216B	Housing - 4th Clutch - Late (8)		1	-	11769A	29506156
220A	P.T.O. Gear	R	1	-	11915	6885145
222A	Housing - w/o Turbine Shaft - Forward Clutch - Early (7) (6838298)	R	1	-	11298	29509660
222A	Housing - w/ Turbine Shaft - Forward Clutch - Late (8)		1	-	11298B	29506185
225A	Support - Front Pump - AT540 - Body Cast #895	R	1	-	11921	23014020
225A	Support - Front Pump - AT545 - Body Cast #919	R	1	-	11921B	29509636
228F	Bearing - Output - Early		1	-	11925	23047959
228F	Bearing - Output - Late		1	-	11925A	23047970
N.I.	Bolt - Torque Converter		1	-	96-178	23014542
N.I.	Center Support Repair Sleeve - Early		1	-	DF636B	N.L.
N.I.	Conversion Kit - (Deep Pan) AT540 To AT545		1	-	UDK-545	23012575
N.I.	Drain Plug - Oil Pan		1	-	DP-789	N.L.
N.I.	Housing & Flex Plate Package - 545		1	-	CK-545	N.L.
N.I.	Housing & Flex Plate package - w/Tower - 545		1	-	CK-545A	N.L.

(7) Early AT540/545 parts up to serial number 3210775436.

(8) Late AT545 parts from serial number 3210775437.

(9) Reference No. 23014020 old style support will work in late 545 applications when mated with charging pump with casting #895. Casting #919 pump only mates to late style support reference no. 29509636.

ALLISON AT540, 543, 545

To Get The Correct Parts, You Must Provide The Assembly Number Found On The Transmisson Name Plate.

ILL.	DESCRIPTION	BRAND	QTY.	YEAR	PART NO.	REF NO.
HARD PARTS (Cont.)						
N.I.	Kit - Governor Gear		1	-	K34411A	23045382
N.I.	Lock Nut - Second Clutch Spring Retainer (Push On)		4	-	11213	3909063
N.I.	Lock Nut - Third Clutch Spring Retainer (Push On)		4	-	11213	3909063
N.I.	Nut - Flex Disc - 543		6	-	21214	23014462
N.I.	P.T.O. Cover		1	-	11147	6774322
N.I.	Reverse Signal Switch - Backup Light (AS36-033)		1	-	11610	29503665
N.I.	Strip Lock - Converter Pump Hub - 543		4	-	11212	6769631
MISCELLANEOUS PRODUCTS						
N.I.	Bolt - Pan		21	-	96-175A	29500738
N.I.	Bolt - Torque Converter (1261968)		1	-	96-178	23014542
N.I.	Governor Bore Tool (w/2 Sleeves)		1	-	T-9119	N.L.
N.I.	Governor Sleeve Only - Aluminum (Aluminum Case)		1	-	T-119A	N.L.
N.I.	Governor Sleeve Only - Bronze (Cast Iron Case)		1	-	T-119B	N.L.
N.I.	Torque Converter - Gas - (270)		1	-	DC-540	29514487
N.I.	Torque Converter - Diesel - (290)		1	-	DC-545	29514486

MT30/42

REBUILDER KITS

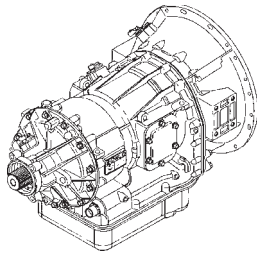
DESCRIPTION	QTY.	YEAR	DELUXE KIT	MASTER O/H KIT	LESS STEELS KIT	OVERHAUL KIT	GASKET & SEAL KIT
MT 6 Spd. Series, MT30/40/41/42,	1	-				AK10900	

GOVERNOR APPLICATION CHART

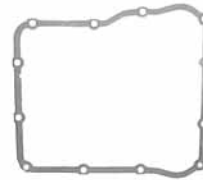
TRANSMISSION	CODE ON GOVERNOR	USE GOVERNOR NO.
AT 500 SERIES		
Up to and including - 2800 RPM Range	461	11410A
3000 - 3400 RPM Range	462	11410B
Gas Engine - 3600 - 3800 RPM Range	460	11410
AT643		
2200 - 2600 RPM Range	461	11410A
3000 - 3400 RPM Range	463	21410
MT653		
2400 - 2600 RPM Range	462	11410B
2800 RPM Range	463	21410
3000 RPM Range	465	21410A
3200 - 3800 RPM Range - Bronze Gear	738	21410B
3600 - 3800 RPM Range - Bronze Gear	739	21410C
Caterpillar Engine w/Blower - 2600 RPM Range	-	21410B
Caterpillar Engine w/o Blower - 2800 RPM Range	-	21410C

ALLISON (M74) 1000/2000/2400

To Get The Correct Parts, You Must Provide The Assembly Number Found On The Transmission Name Plate.



Allison Transmissions
LCT 1000, 2000, 2400



12 Bolt Pan Gasket
13200R

DESCRIPTION	QTY.	YEAR	DELUXE KIT	MASTER O/H KIT	LESS STEELS KIT	OVERHAUL KIT	GASKET & SEAL KIT
REBUILDER KITS							
Kits - OEM reference #29541007	1	00-Up		K1500	K1500-LS	K15900	
VALVE BODY KITS							
N.I. TRANSGO® Shift Kit™	1	00-Up		K15908		N.L.	
MISCELLANEOUS GASKETS & SEALS/PAN GASKETS							
N.I. Gasket - Oil Pan - Molded	1	00-Up		13200R		29536526	
CLUTCH PLATES							
N.I. Friction:							
- C1 - External Tooth	6	00-Up		15100		29530312	
- C2	6	00-Up		15101		29530313	
- C3	4	00-Up		15102		29531049	
- C4	5	00-Up		15102		29531049	
- C5	6	00-Up		15103		29537393	
N.I. Steel:							
- C1 - Internal Tooth	6	00-Up		15105		29530314	
- C2	7	00-Up		15106		29530315	
- C3	3	00-Up		15107		29531048	
- C4	4	00-Up		15107		29531048	
- C5	6	00-Up		15108		29536482	
FILTERS/FILTER KITS							
N.I. Filter Kit - Shallow	1	00-Up		FK15800		N.L.	
N.I. Filter Kit - Deep	1	00-Up		FK15800A		N.L.	
N.I. Filter - Internal Shallow Pan 29537514	1	00-Up		15800		29537965	
N.I. Filter - Internal Deep Pan 29537617	1	00-Up		15800A		29537966	
N.I. Filter - External Spin On 29537268	1	00-Up		14802		29539579	
METAL CLAD SEALS							
N.I. Front Pump	1	00-Up		15200		29536299	
N.I. Extension Housing	1	00-Up		15850		29536379	

ALLISON (M74)

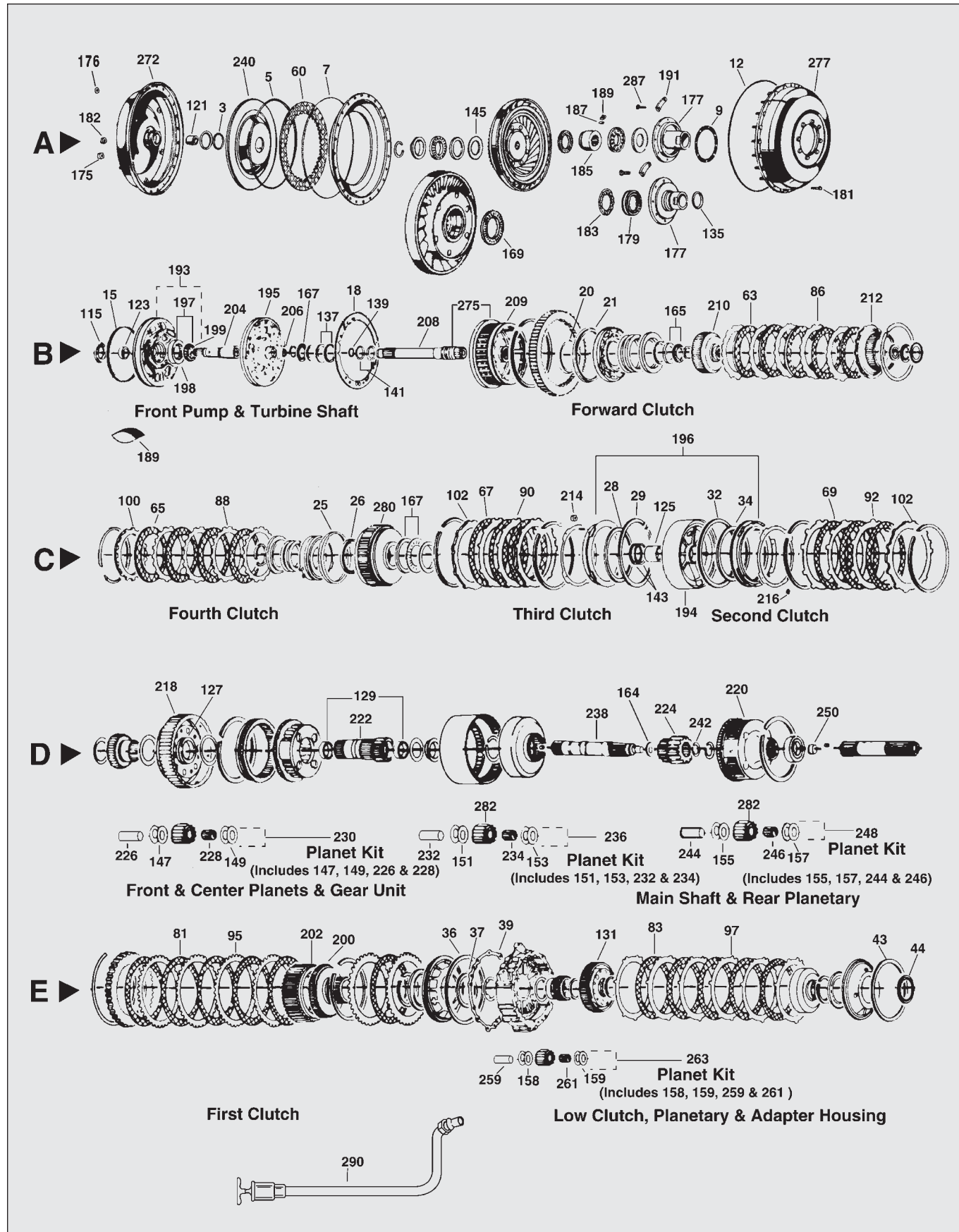
1000/2000/2400

To Get The Correct Parts, You Must Provide The Assembly Number Found On The Transmisson Name Plate.

ILL.	DESCRIPTION	BRAND	QTY.	YEAR	PART NO.	REF NO.
HARD PARTS						
Hard Parts may only require the base number for OEM/Aftermarket New or a "-R" suffix for remanufactured. Exceptions are listed individually. NOTE: A separate column is provided to indicate a primary or specific brand/type.						
N.I.	Piston - Bonded C3/C4		2	03-Up	15528	29537394
N.I.	Piston - Bonded - Balance - C1		1	00-Up	15530	29537993
N.I.	Piston - Bonded - Balance - C2 - w/ Bleed Hole		1	00-02	15531	29536105
N.I.	Piston - Bonded - Balance - C2 - w/o Bleed Hole		1	03-Up	15531A	29539653
N.I.	Pump Body		1	00-Up	15920	N.L.
N.I.	Pump Wear Plate		1	00-Up	15922	N.L.
N.I.	Pump Cover		1	00-Up	15925	N.L.
N.I.	Turbine Shaft		1	00-Up	15930	N.L.
N.I.	C1/C2 Drum w/ PTO Gear		1	00-Up	15950	N.L.
N.I.	C1 Hub		1	00-Up	15953	N.L.
N.I.	C2 Hub		1	00-Up	15955	N.L.
N.I.	Front Planet Package - P1		1	00-Up	15962	N.L.
N.I.	Center Planet Package - P2		1	00-Up	15964	N.L.
N.I.	Rear Planet Package - P3		1	00-Up	15966	N.L.
N.I.	Main Shaft		1	00-Up	15970	N.L.
N.I.	Output Shaft - 2WD		1	00-Up	15972	N.L.
N.I.	Output Shaft - 4WD		1	00-Up	15972B	N.L.
N.I.	Valve Body		1	00-Up	15990	N.L.
ELECTRICAL PRODUCTS						
N.I.	Solenoid:					
	- Shift C,D,E		3	00-Up	5A-192	29536833
	- TCC - PWM		1	00-Up	5A-187	8683187
	- Trim A		1	00-Up	5A-198	29533074
	- Trim B		1	00-Up	5A-199	29533075
	- Modulated Pressure Control G		1	04-Up	5A-192	29536833
N.I.	Switch - Pressure Manifold		1	00-Up	15D-176	24222079
N.I.	MLPS - Brown - 2 Connector		1	00-03	15A-199	29540479
N.I.	MLPS - 1 Connector		1	03-Up	15A-199A	29541852
N.I.	Sensor - Input/Turbine/Output		3	00-Up	20A-199	29536408
N.I.	Harness - Internal - 6 Solenoid		1	00-03	35A-199	29541371
N.I.	Harness - Internal - 7 Solenoid		1	03-Up	35A-199A	29539792
MICELLANEOUS						
N.I.	Service Manual - Aftermarket		1	00-Up	15Y01	NL
N.I.	Service Manual - OEM		1	00-Up	TM-1000M	NL
N.I.	Parts Manual - OEM		1	00-Up	TM-1000P	NL
N.I.	Troubleshooting Manual - OEM		1	00-Up	TM-1000T	NL
NOTES						

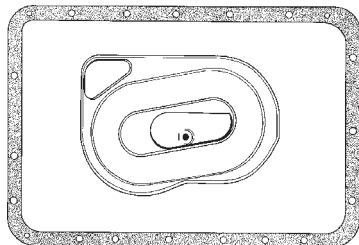
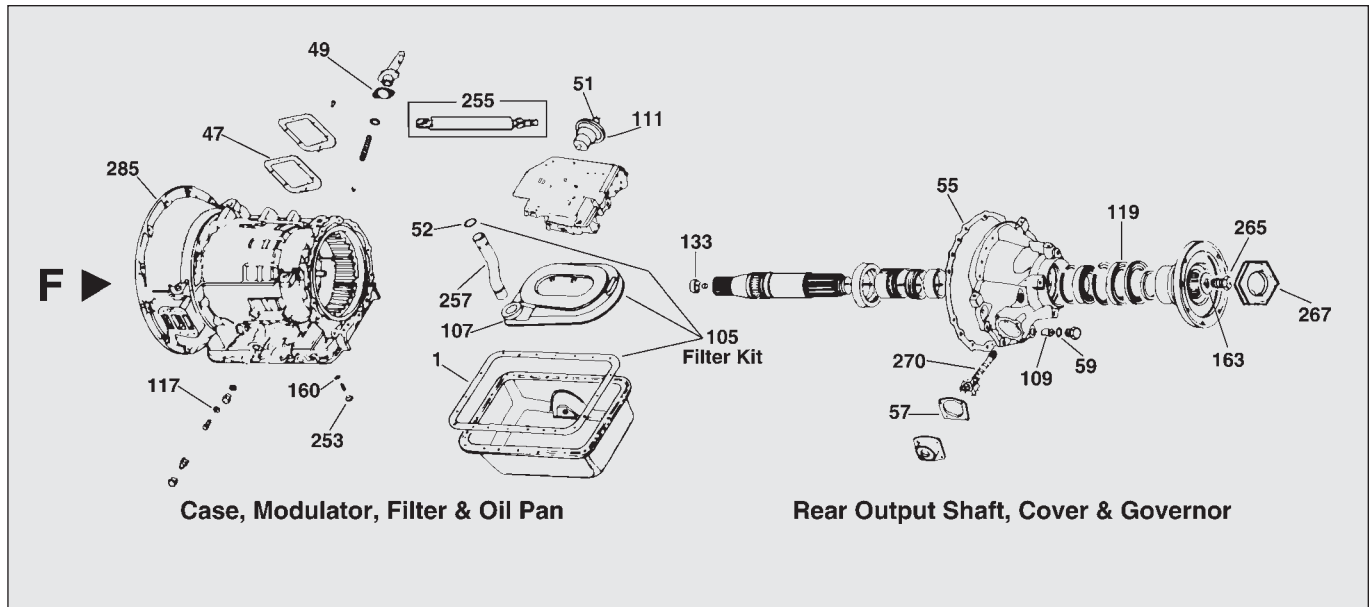
ALLISON MT/B 640, 643, 644, 647, 650, 653, 654

To Get The Correct Parts, You Must Provide The Assembly Number Found On The Transmisson Name Plate.



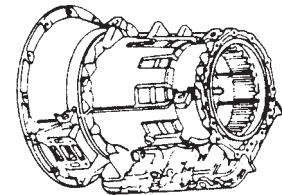
ALLISON MT/B 640, 643, 644, 647, 650, 653, 654

To Get The Correct Parts, You Must Provide The Assembly Number Found On The Transmisson Name Plate.



21 Bolt Pan

Allison Transmissions
MT/B 640, 643, 644, 647, 650, 653, 654



REBUILDER KITS

DESCRIPTION	QTY.	YEAR	DELUXE KIT	MASTER O/H KIT	LESS STEELS KIT	OVERHAUL KIT	GASKET & SEAL KIT
Kits - 640-643 (1)	1	-		K2100	K2100-LS		
Kits - 650-653 (2)	1	-		K2100A	K2100A-LS		
Kits - 644 - PH1,2	1	-		K2100B	K2100B-LS		
Kits - 654 - PH1,2	1	-		K2100D	K2100D-LS		
Kit - 640-643/650-653 - w/Cork Neo - w/Teflon Seal Kit	1	-				K21900	
Kit - 640-643/650-653 - w/Victopac - Vespel Ring Kit	1	-				K21900FW	
Kit - 644/654 - w/Cork/Neo - Standard Ring Kit	1	-				K21900B	
Kit - 644/654 - w/Victopac - Vespel Ring Kit (29530326)	1	-				K21900HW	
Front Pump Reseal Kit (3)	1	-					K21900-2
Kit - w/o Pan Gasket - 640/643/650/653	1	-				K21900NP	

(1) To replace 29502306 Factory Master Kit, also order K21950 bearing kit and 21800 filter.

(2) To replace 29502307 Factory Master Kit, also order K21950 bearing kit and 21800 filter.

(3) Contains front pump gasket, rubber lathe cut seal, o-ring and pump bolt washers.

ALLISON

MT/B 640, 643, 644, 647, 650, 653, 654

To Get The Correct Parts, You Must Provide The Assembly Number Found On The Transmission Name Plate.

ILL.	DESCRIPTION	QTY.	YEAR	PART NO.	REFERENCE NO.
MISCELLANEOUS GASKETS & SEALS/PAN GASKETS					
1F	Gasket - Oil Pan - Cork & Neoprene	1	-	13540X	29501160
1F	Gasket - Oil Pan - Update - Armstrong® (23016682)	1	-	13540W	29501160
3A	O - Ring - Lockup Clutch - Inner - Polyacrylate - exc. 644,654	1	-	3366PL	6770820
3A	Seal - Lathe Cut - Lockup Clutch - Inner - 644, 654	1	-	13176	6770492
5A	Seal - Lathe Cut - Lockup Clutch - Outer - exc. 644, 654	1	-	13159	6758036
5A	Seal - Lathe Cut - Lockup Clutch - Outer - 644, 654	1	-	13177	6758740
7A	Seal - Lathe Cut - Lockup Clutch Backing Plate (Yellow Stripe)	1	-	13151	23016564
9A	Gasket - Converter Pump Hub - 640,650	1	-	13150W	29536726
9A	Gasket - Converter Pump Hub - 644, 654	1	-	13174	6771366
12A	Seal - Lathe Cut - Converter Pump Cover - exc. 644, 654 (Yellow Stripe)	1	-	13151	23016564
12A	Seal - Lathe Cut - Converter Pump Cover - 644, 654 (Green Stripe)	1	-	13175	6880389
15B	Seal - Lathe Cut - Front Pump (Green Stripe)	1	-	13160	23016347
N.I.	Seal - Washer - Front Pump Bolt (6834908)	12	-	13161	29512113
18B	Gasket - Front Pump To Case	1	-	13162	23046344
20B	Lip Seal - Forward Clutch - Inner (8623121)	1	-	3284L	23015880
21B	Lip Seal - Forward Clutch - Outer	1	-	13163	6833981
25C	Lip Seal - Fourth Clutch - Outer	1	-	13163	6833981
26C	Lip Seal - Fourth Clutch - Inner	1	-	3284L	23015880
28C	Lip Seal - Third Clutch - Inner	1	-	13164	23011471
29C	Lip Seal - Third Clutch - Outer	1	-	13165	6883035
N.I.	O-ring - Center Support (Starting With Serial No. 100432)	1	-	13172	6761244
32C	Lip Seal - Second Clutch - Outer	1	-	13165	6883035
34C	Lip Seal - Second Clutch - Inner	1	-	13164	23011471
47F	Gasket - Power Takeoff Cover - Update - Armstrong® (23016683)	1	-	13158W	29501161
49F	Gasket - Lube Valve Adapter	1	-	13166	6884872
52F	O-ring - Oil Filter Tube (Polyacrylate)	1	-	3435PL	6762127
51F	O-ring - Modulator (23017367)	1	-	3410L	8658110
36E	Lip Seal - First Clutch - Outer	1	-	13169	6883033
37E	Lip Seal - First Clutch - Inner	1	-	13170	6883031
39E	Gasket - Adapter Housing (6837442)	1	-	13171	23045099
43E	Lip Seal - Low Clutch - Outer	1	-	13165	6883035
44E	Lip Seal - Low Clutch - Inner	1	-	13170	6883031
55F	Gasket - Rear Cover	1	-	13171	23045099
57F	Gasket - Governor Cover - Fibre	1	-	3914D	23011670
57F	Gasket - Governor Cover - Update - Armstrong® (23011670)	1	-	3914LW	23018625
59F	O-ring - Governor Filter/Cooler Fitting	1-2	-	13173	6882689
N.I.	Washer - Drain Plug - Coated	1	-	11423B	29507909
N.I.	Washer - Cover - Coated	1	-	21154	N.L.
N.I.	O-Ring - Converter Plug/Cooler Fitting (Brown)	1	-	13180	N.L.
CLUTCH PLATES					
60A	Friction - Lockup Clutch - Graphitic - 640, 643,650, 653 - Not In Kits (4)	1	-	R21106	23046108
60A	Friction - Lockup Clutch - 644, 654 - Not In Kits (5)	1	-	W31102	23048511
63B	Friction - Forward Clutch (4)	5/6	-	R21103	23042200
63B	Friction - Forward Clutch (5)	5/6	-	W21103	23042200
65C	Friction - Fourth Clutch (4)	4/5	-	R21103	23042200
65C	Friction - Fourth Clutch (5)	4/5	-	W21103	23042200
67C	Friction - Third Clutch (4)	3	-	R21104	23042201
67C	Friction - Third Clutch (5)	3	-	W21104	23042201
69C	Friction - Second Clutch (4)	3/4	-	R21104	23042201
69C	Friction - Second Clutch (5)	3/4	-	W21104	23042201
81E	Friction - First Clutch (4) (23042199)	6	-	R11104	29529492
81E	Friction - First Clutch (5)	6	-	W11104	23042199
(4) Raybestos brand plate. OEM approved heat-treated paper. (5) S.K. Wellman plate. OEM approved graphitic.					

ALLISON

MT/B 640, 643, 644, 647, 650, 653, 654

To Get The Correct Parts, You Must Provide The Assembly Number Found On The Transmisson Name Plate.

ILL.	DESCRIPTION	QTY.	YEAR	PART NO.	REFERENCE NO.
CLUTCH PLATES (Cont.)					
83E	Friction - Low Clutch - 654 Phase 1 & 2 (4)	7	-	R21101	23042210
83E	Friction - Low Clutch - 654 Phase 1 & 2 (5)	7	-	W21101	23042210
83E	Friction - Low Clutch - exc. 654 Phase 1 & 2 (5)	5/6	-	W21104	23042201
83E	Friction - Low Clutch - exc. 654 Phase 1 & 2 (4)	5/6	-	R21104	23042201
86B	Steel - Forward Clutch	5/6	-	21100	23016610
88C	Steel - Fourth Clutch	4/5	-	21100	23016610
90C	Steel - Third Clutch (23016608)	3	-	21105	29516333
92C	Steel - Second Clutch (23016608)	3/4	-	21105	29516333
95E	Steel - First Clutch	6	-	21107	23016606
97E	Steel - Low Clutch (654 Phase 1 & 2)	8	-	21102	23045054
97E	Steel - Low Clutch (Exc. 654 Phase 1 & 2)	6/7	-	21105	23016608
(4) Raybestos brand plate. OEM approved heat-treated paper. (5) S.K. Wellman plate. OEM approved graphitic.					
BACKING PLATES					
100C	Fourth Clutch	1	-	21108	29516333
102C	2-3 Clutch - .463 - .473	AR	-	21718-R	23046718
102C	2-3 Clutch - .476 - .486	AR	-	21745-R	23046745
102C	2-3 Clutch - .450 - .460	AR	-	21746-R	23046746
FILTERS/FILTER KITS					
105F	Filter Kit - Cork & Neoprene	1	-	FK21800	23019201
105F	Filter Kit - Armstrong®	1	-	FK21800W	29502302
105F	Filter Kit - Stainless Steel Wire Mesh - 5" Pan (6)	1	-	FK21800L	29528215
107F	Filter - Paper (6883044)	1	-	21800	29527373
107F	Filter - Stainless Steel Wire Mesh - 5" Pan (6) (29527373)	1	-	21800L	29532584
N.I.	Filter - External Spin on Cartridge	1	-	HD-223	25010643
N.I.	Screen - Center Support	1	-	21713	23010654
109F	Screen - Governor - Early - Prior To S/N 58071	1	-	11712	23045247
109F	Screen - Governor - Late - Start With S/N 58071	1	-	21712	6882687
(6) Use with auxiliary filter only.					
VACUUM MODULATORS					
111F	Modulator w/O-Ring (Large Can)	1	-	11820	3039092
	Modulator w/O-Ring (Small Can)	1	-	11820A	29501199
METAL CLAD SEALS					
115B	Front Pump - 3.355" O.D.	1	-	21200	6837228
115B	Front Pump - 3.881" O.D. - Update - Brown Viton	1	-	21200A	23016643
115B	Front Pump - 3.380" O.D. - Viton - Shielded	1	-	21200B	23045556
117F	Selector Shaft	1	-	38511	23010610
119F	Rear Cover 3.628" O.D.	1	-	11850	6778050
119F	Rear Cover 4.751" O.D.	1	-	21850	6773311
BUSHINGS					
N.I.	Bushing Kit	1	-	K21902	N.L.
121A	Converter Cover	1	-	21000	6756782
123B	Front Pump Body - MT640, 650, 653 (Not Included In Kit) - 2.530 (23046153)	1	-	21007	29527101
123B	Front Pump Body - MT644, 654 (Not Included In Kit) - 2.580	1	-	21008	23046152
123B	Front Pump Body	1	-	21005	6881926
125C	Center Support	1	-	21003	23011924
127D	Front Planetary Carrier - (I.D. Must Be Finished In Place)	1	-	21001	6835385
129D	Center Sun Gear - (I.D. Is Finished, No Further Machining Required)	2	-	21002	29516211
129D	Center Sun Gear - (I.D. Must Be Finished In Place)	2	-	21002X	6834503

ALLISON

MT/B 640, 643, 644, 647, 650, 653, 654

To Get The Correct Parts, You Must Provide The Assembly Number Found On The Transmission Name Plate.

ILL.	DESCRIPTION	QTY.	YEAR	PART NO.	REFERENCE NO.
BUSHINGS (Cont.)					
131E	Low Planetary Carrier - (I.D. Must Be Finished In Place)	1	-	21004	6835398
133F	Rear Output Shaft Bushing (Replaces Bearing 21219 In R. Output Shaft)	1	-	21006	23016859
SEALING RINGS/RING KITS					
N.I.	Sealing Ring Kit - Complete - 8 Rings	1	-	K21901	N.L.
N.I.	Sealing Ring Kit - Complete - 8 Rings - Vespel	1	-	K21901V	N.L.
135A	Converter Pump Hub	1	-	21300	6830187
137B	Pump Support - Front	2	-	21301T	23015617
137B	Pump Support - Front - Vespel	1	-	K21301V	23014632
139B	Turbine/Converter	1	-	21302	6839163
139B	Turbine/Converter - Vespel	1	-	21302V	23019653
141B	Front - Turbine Shaft	2	-	21303	6833999
143C	Center Support	2	-	21301T	23015617
THRUST WASHERS/NEEDLE BEARINGS					
145A	Spacer - Turbine:				
	- .015" - Gold - exc. 644, 654	AR	-	11403	6837429
	- .015" - Gold - 644, 654	AR	-	21403	6839976
	- .030" - Silver - exc. 644, 654	AR	-	11403A	6837430
	- .030" - Silver - 644, 654	AR	-	21403A	6839977
	- .042" - Plain - exc. 644, 654	AR	-	11403B	6837431
	- .042" - Plain - 644, 654	AR	-	21403B	6839978
	- .060" - Black - exc. 644, 654	AR	-	11403C	6837432
	- .060" - Black - 644, 654	AR	-	21403C	6839979
	- .075" - Copper - exc. 644, 654	AR	-	11403D	6837433
	- .075" - Copper - 644, 654	AR	-	21403D	6839980
	Washer - Front Planetary:				
147D	- Bronze	12	-	11413	6839514
149D	- Steel	12	-	11414	6833991
	Washer - Center Planetary:				
151D	- Bronze	8	-	21415	6839375
153D	- Steel	8	-	21416	23018960
	Washer - Rear Planetary:				
155D	- Bronze	8	-	21415	6839375
157D	- Steel	8	-	21416	23018960
160F	Washer - Center Support Bolt	1	-	11422	23014094
	Washer - Low Planetary:				
158E	- Bronze (Exc. 644, 654)	12	-	11416	6839376
159E	- Steel (644, 654)	8	-	21424	23018961
163F	Washer - Output Flange	1	-	11421	29500739
N.I.	Washer - Drain Plug - Coated	1	-	11423B	29507909
164D	Washer - Rear Sun Gear (Plastic)	1	-	21418	29524362
BEARINGS					
N.I.	Bearing Kit (Contains 2 Ea - 21782, 21799 & one 11404)	1	-	K21950	N.L.
N.I.	Bearing Kit - Complete - 643	1	-	K21950C	N.L.
N.I.	Bearing Kit - Complete - 653	1	-	K21950D	N.L.
165B/C	Thrust Bearing Assembly - Forward Clutch	2	-	21799	23015799
167B/C	Front & Center Support Bearing	2	-	21782	23019782
169A	Thrust Bearing - Converter Stator	1	-	11404	23016866
179A	Bearing - Converter Hub - 640, 650	1	-	21883	23048030
287A	Bolt - Torque Converter Hub	1	-	96-178	23014542

ALLISON

MT/B 640, 643, 644, 647, 650, 653, 654

To Get The Correct Parts, You Must Provide The Assembly Number Found On The Transmisson Name Plate.

ILL.	DESCRIPTION	BRAND	QTY.	YEAR	PART NO.	REF NO.
HARD PARTS						
Hard Parts may only require the base number for OEM/Aftermarket New or a "-R" suffix for remanufactured. Exceptions are listed individually. NOTE: A separate column is provided to indicate a primary or specific brand/type.						
133F	Roller Bearing - See 21006 Under Bushings					
175A	Nut - Flex Plate		6	-	21214	23046154
176A	Washer - Flex Plate		6	-	21154	23014462
177A	Converter Hub:					
	- 1st Design - 640, 650 - Bushing Style - 8 Bolt		1	-	21206	6837203
	- 2nd Design - 640, 650 - Bearing Style (w/bearing) 8 Bolt		1	-	21204A	23013906
	- 2nd Design - 640, 650 - Bearing Style (w/o bearing) 8 Bolt		1	-	21204	23013906
	- 3rd Design - .683 Gear - Bushing Style - 8 Bolt (23016722)		1	-	21204C	29507140
	- 4th Design - 1.00 Gear - MT644, 647, 654 - Bearing Style - 12 Bolt(23017446)		1	-	21204E	23046638
	- 4th Design - MT644, 647, 654 - Bushing Style - 12 Bolt		1	-	21204D	23016723
179A	Bearing - Converter Hub - 640, 650		1	-	21883	23048030
181A	Converter Cover Stud		6	-	21508	6839508
182A	Converter Cover Nut		24	-	21139	190139
183A	Race, Converter Hub Bearing - H.D. - 640, 650 (Bearing Style Hub)		1	-	21907	23013907
183A	Race, Converter Hub Bearing - H.D. - 640, 650 (Bushing Style Hub)		1	-	21907A	9440257
185A	Race, Converter Stator - MT643		1	-	21226	6837206
187A	Converter Stator Roller		10	-	11211	6774968
189C	Converter Stator Spring		10	-	11210	29513517
190B	Locking Key, Converter Cover - Football Key		1	-	21209	6772552
191A	Strip Lock - Converter Hub - 644, 654		6	-	21212	6880899
191A	Strip Lock - Converter Hub - exc. 644, 654		4	-	11212	6769631
193B	Pump Body w/Gears:					
	- .683 Gears - 640, 650 (23046636)		1	-	K21636	29527499
	- .683 Gears - Late 640, 650 (23016889)		1	-	K21636A	29527490
	- .818 Gears - MT654		1	-	K21637	23046638
	- 1.00 Gears - Bushing Design - Late MT644, 647, 654		1	-	K21637A	23017114
194C	Support - Center - w/ bushing	R	1	-	21940	23018593
195B	Pump Support:					
	- Early - MT643,653 (23015871)	R	1	-	21871	29515355
	- Early - MT644,654 - (Mates w/ Ref. #23046638 Body & Gears)	R	1	-	21872	23015872
	- Late - MT643,653 - (Mates w/1" Pump Body Gear)	R	1	-	21751	23016751
	- Late - MT644,654 - (Mates w/1" Pump Body Gear)	R	1	-	21763	23016763
196C	Piston - Center Support - 2nd/3rd Clutch	R	2	-	21942	6834230
197B	Kit - Front Pump Gears:					
	- exc. 644/654 - Standard. O.D. - .6835 - .6845		1	-	K21201	N.L.
	- 644/654 - Standard. O.D. - .8185 - .8190		1	-	K21201C	N.L.
	- 647 - Standard. O.D. - 1.00 Gears		1	-	K21201D	N.L.
198B	Driven Gear Only:					
	- exc. 644/654 - Standard O.D. - .6835		1	-	21201-2	N.L.
	- exc. 644/654 - .060 Oversize O.D. - .6835		1	-	21201-4	N.L.
	- 644/654 - Standard O.D. - .8185		1	-	21201-7	N.L.
	- 644/654 - .060 Oversize O.D. - .8185		1	-	21201-9	N.L.
	- 647 - Standard O.D. - 1.00		1	-	21201-11	N.L.
	- 647 - .060 Oversize O.D. - 1.00		1	-	21201-13	N.L.
199B	Drive Gear Only:					
	- exc. 644/654 - Standard O.D. - .6835 (23015392)		1	-	21201-1	N.L.
	- exc. 644/654 - .060 Oversize O.D. - .6835		1	-	21201-3	N.L.
	- 644/654 - Standard O.D. - .8185		1	-	21201-6	N.L.
	- 644/654 - .060 Oversize O.D. - .8185		1	-	21201-8	N.L.
	- 647 - Standard O.D. - 1.00		1	-	21201-10	N.L.
	- 647 - .060 Oversize O.D. - 1.00		1	-	21201-12	N.L.

ALLISON

MT/B 640, 643, 644, 647, 650, 653, 654

To Get The Correct Parts, You Must Provide The Assembly Number Found On The Transmission Name Plate.

ILL.	DESCRIPTION	BRAND	QTY.	YEAR	PART NO.	REF NO.
HARD PARTS (Cont.)						
200E	Ring Gear Hub - (Hardened) - MT653	R	1	-	21325	29506325
202E	Ring Gear - 1st Clutch - MT653		1	-	21568	6835568
204B	Ground Sleeve - Finished I.D. Bearing Installed:					
	- 640, 650 Early Style - Silver Single Spline w/o Step		1	-	21202	23014527
	- 640/650 Late Style - Silver Single Spline w/ Step		1	-	21202A	23040476
	- 644, 654 Early Style - Silver Dual Spline w/o Step (23014306)		1	-	21203	29507674
	- 644/654 Late Style - Black Dual Spline w/ Step		1	-	21203A	29507673
206B	Roller Bearing - Front Pump (Ina Brand) (9438017)		1	-	21223A	29503987
206B	Roller Bearing - Front Pump (Torrington Brand) (9438017)		1	-	21223	29503987
208B	Turbine Shaft		1	-	21785	23012785
208B	Turbine Shaft - 654	R	1	-	21785B	23019222
209B	Housing - Forward - w/o Shaft - MT643, 653		1	-	21172	23017172
210B	Hub - Forward Clutch - exc. 644, 654		1	-	21222	6834222
212B	Hub - Fourth Clutch Driving - exc. 644, 654		1	-	21221	6834221
	Hub - Fourth Clutch Driving - 644, 654		1	-	21221B	23017267
214C	Lock Nut - Third Clutch Spring Retainer - Push On		4	-	11213	3909063
216C	Lock Nut - Second Clutch Spring Retainer - Push On		4	-	11213	3909063
218D	Front Carrier Replacement Housing w/6 Pins		1	-	RH21565	6882564
220D	Rear Carrier - MT653		1	-	21642	6835642
222D	Sun Gear - Center w/Bushings Installed	R	1	-	21606	29516215
224D	Sun Gear - Rear		1	-	21901	6883901
226D	Pin - Front Planetary		6	-	11215	6834309
228D	Needle Roller - Front Planetary		120	-	11919	9426919
230D	Kit - Front Planetary Repair		1	-	K21215	N.L.
232D	Pin - Center Planetary		4	-	21216	6835567
234D	Needle Roller - Center Planetary		72	-	21920	6834915
236D	Kit - Center Planetary Repair		1	-	K21216	N.L.
238D	Main Shaft - 643, 653		1	-	21456	23013456
238D	Main Shaft - 644/654		1	-	21456B	23017699
240A	Piston - L/U - 640, 650	R	1	-	21845	6770845
242D	Spiral Ring - Rear Sun Gear To Planetary		1	-	21224	6834583
244D	Pin - Rear Planetary		4	-	21216	6835567
246D	Needle Roller - Rear Planetary		72	-	21920	6834915
248D	Kit - Rear Planetary Repair		1	-	K21216	N.L.
250D	Roller Bearing - Output Shaft - 640, 643		1	-	21219	9418483
253F	Bolt - Case To Center Support - Anchor 2-1/4"		1	-	21220	23013398
253F	Bolt - Case To Center Support - Anchor 3"		1	-	31220	23045343
255F	Manual Selector Shaft Kit		1	-	K11235	23017610
257F	Tube - Oil Filter - Updates Prior To S/N 58071		1	-	21225	6883045
259E	Pin - Low Planetary - exc. 644, 654	R	6	-	11216	6831679
	Pin - Low Planetary - 644, 654		4	-	21211A	6880019
261E	Needle Roller - Low Planetary - exc. 644, 654		114	-	11920	9426920
	Needle Roller - Low Planetary - 644, 654		124	-	21920	6834915
263E	Kit - Low Planetary Repair - exc. 644, 654		1	-	K21217	N.L.
	Kit - Low Planetary Repair - 644, 654		1	-	K21211A	N.L.
265F	Bolt - Output Flange -23014159		1	-	11222	29510838
267F	Nut - Self-lock Hex - Rear Output Shaft		1	-	21956	6771144
270F	Governor:					
	- I.D. No. 461		1	-	11410A	6885570
	- I.D. No. 462	R	1	-	11410B	6885571
	- I.D. No. 463		1	-	21410	6885572
	- I.D. No. 465		1	-	21410A	6881471
	- I.D. No. 738		1	-	21410B	6882737
	- I.D. No. 739		1	-	21410C	6882736

ALLISON

MT/B 640, 643, 644, 647, 650, 653, 654

To Get The Correct Parts, You Must Provide The Assembly Number Found On The Transmisson Name Plate.

ILL.	DESCRIPTION	BRAND	QTY.	YEAR	PART NO.	REF NO.
HARD PARTS (Cont.)						
272A	Converter Cover (23046294)	R	1	-	21294	29524116
277A	Converter/Pump Assembly - (Impeller) - MT643, 653:					
	- Ratio TC350	R	1	-	21596	23018596
	- Ratio TC360	R	1	-	21594	23018594
	- Ratio TC370	R	1	-	21598	23018598
280C	Housing - 4th Clutch - MT643, 653	R	1	-	21825	23011825
280C	Housing - 4th Clutch - MT644, 654	R	1	-	21257	23017257
282D	Gears - Pinion - Center/Rear - MT643, 653 - (4 Per Set)		1	-	21804	6882804
285F	Main Case		1	-	650M-CASE	23011779
287A	Bolt - Torque Converter Hub		1	-	96-178	23014542
290E	Tube & Dip Stick Assembly - Universal		1	-	11999U	N.L.
N.I.	Carrier Replacement Pins		6	-	565P	N.L.
N.I.	Drain Plug - Oil Pan		1	-	DP-789	N.L.
N.I.	Kit - Governor Gear - Exc. Bronze		1	-	K34411A	6883938
N.I.	Pan Bolt		21	-	96-175A	29500738
N.I.	Reverse Signal Switch - Backup Light		1	-	11610	29503665
N.I.	Sleeve - Front Pump - Support - MT640		1	-	21870	23045870
N.I.	Support Repair Sleeve - Center - MT643		1	-	DF593B	N.L.
N.I.	Spring & Roller Kit, Converter Stator - 10 Springs & Rollers		1	-	K11250	6775657
NOTES						

TIP

Use this chart to identify front support and charging pump applications for MT600 Series Allison Transmissions:

	MT640, 643, 650, 653	MT644, 647, 654
Front Support, Early Models:	29515355 (23015871)	23015872 (23015872)
Front Support, Late Models:	29514491 (23016751)	23016763 (23016763)
Pump Assembly, Early Models:	29527499 (23046636)	29527509 (23046638)
Pump Assembly, Late Models:	29527490 (23016889)	29527481 (23017114)

NOTE:

To correctly identify which application YOUR transmission requires, the assembly number on each unit must be provided. The old numbers are in parenthesis, the new ones are in bold.

ALLISON

MD3060/3560/B300/B400

To Get The Correct Parts, You Must Provide The Assembly Number Found On The Transmisson Name Plate.

DESCRIPTION	QTY.	YEAR	DELUXE KIT	MASTER O/H KIT	LESS STEELS KIT	OVERHAUL KIT	GASKET & SEAL KIT
REBUILDER KITS							
Kits	1	-		K1400	K1400-LS	K14900M	
Kits - #29541087- OVH	1	-				K14900	
Kits - #29537068 - VB Sub	1	-				K14900-2	

ILL.	DESCRIPTION	QTY.	YEAR	PART NO.	REFERENCE NO.	
MISCELLANEOUS GASKETS & SEALS/PAN GASKETS						
N.I.	Gasket - Rear Cover	1	-	13287	29534354	
N.I.	Gasket - Front Housing	1	-	13288	29503288	
N.I.	Gasket - Oil Pan - Channel Plate - Upper	1	-	13472	29503283	
N.I.	Gasket - Oil Pan - Channel Plate - Lower	1	-	13473	29535230	
N.I.	Seals - Face - Valve Body	5	-	13376	23041376	
CLUTCH PLATES						
N.I.	Friction:	6	-	R14100	29536334	
	C1 - External Tooth	6	-	R14102	29536335	
	C2 29516170	5	-	R14104	29536336	
	C3	5	-	R14104	29536336	
	C4	7	-	R14106	29536337	
	C5 29532371					
N.I.	Steel:	6	-	14101	29536343	
	C1 - Internal Tooth	6	-	14103	29536344	
	C2	4	-	14105	29536345	
	C3	5	-	14105	29536345	
	C4	8	-	14107	29536346	
	C5	2	-	14110	29501424	
	Plate - Return - C3/C4					
FILTERS/FILTER KITS						
N.I.	Filter - Cartridge 4"	1	-	14800	29526899	
N.I.	Filter - Cartridge 6"	1	-	14800A	29526898	
N.I.	Filter - Suction	1	-	14803	29537067	
N.I.	Filter - External Spin On 29537268	1	-	14802	29539579	
METAL CLAD SEALS						
N.I.	Front Pump	1	-	14200	29507528	
N.I.	Extension Housing 29515690	1	-	14850	29541736	
BUSHINGS						
N.I.	Bushing Kit	1	-	K14902	N.L.	
SEALING RINGS/RING KITS						
N.I.	Sealing Ring Kit	1	-	K14901	N.L.	
HARD PARTS - NEW						
ILL.	DESCRIPTION	BRAND	QTY.	YEAR	PART NO.	REF NO.
N.I.	Ground Sleeve - w/o PTO - 3060		1	-	14984	29516484
N.I.	Ground Sleeve - w/ PTO - 3560		1	-	14984B	29516486
N.I.	Piston - Bonded - C3/C4		2	-	14528	29540483

ALLISON

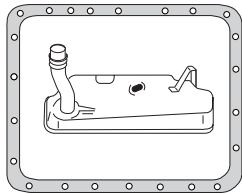
HD4560/B500

To Get The Correct Parts, You Must Provide The Assembly Number Found On The Transmission Name Plate.

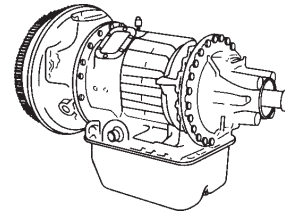
DESCRIPTION	QTY.	YEAR	DELUXE KIT	MASTER O/H KIT	LESS STEELS KIT	OVERHAUL KIT	GASKET & SEAL KIT
REBUILDER KITS							
Kits - HD4560	1	-		K1400R	K1400R-LS	K14900R	
Kits - HD4560 - OVH (29539672)	1	-				K14900S	
Kits - HD4560 - VB Sub (29537070)	1	-				K14900S-2	

ILL.	DESCRIPTION	QTY.	YEAR	PART NO.	REFERENCE NO.	
MISCELLANEOUS GASKETS & SEALS/PAN GASKETS						
N.I.	Gasket - Oil Pan - Channel Plate - Upper	1	-	13350	29501099	
N.I.	Gasket - Oil Pan - Channel Plate - Lower	1	-	13351	29530531	
CLUTCH PLATES						
N.I.	Friction:	7	-	R14100M	29536338	
	C1 - External Tooth	7	-	R14102M	29536339	
	C2	10	-	R14104M	29536340	
	C3/C4	8	-	R14106M	29536341	
	C5	8	-	R14108M	29530496	
	C6					
N.I.	Steel:					
	C1 - Internal Tooth	6	-	14101M	29536347	
	C2	7	-	14103M	29536348	
	C3C4	9	-	14105M	29536349	
	C5	9	-	14107M	29536350	
	C6	9	-	14109M	29530495	
FILTERS/FILTER KITS						
N.I.	Filter - Cartridge 4"	1	-	14800	29526899	
N.I.	Filter - Cartridge 6"	1	-	14800A	29526898	
N.I.	Filter - Suction	1	-	14803	29537067	
METAL CLAD SEALS						
N.I.	Front Pump	1	-	14200P	29505859	
N.I.	Extension Housing	1	-	14850P	29515691	
BUSHINGS						
N.I.	Bushing Kit	1	-	K14902P	N.L.	
SEALING RINGS/RING KITS						
N.I.	Sealing Ring Kit	1	-	K14901R	N.L.	
HARD PARTS - NEW						
ILL.	DESCRIPTION	BRAND	QTY.	YEAR	PART NO.	REF NO.
N.I.	Ground Sleeve - w/o PTO		1	-	14984M	29516488
N.I.	Ground Sleeve - w/ PTO		1	-	14984P	29516490

ALLISON HT740, 750, 754



Allison Transmissions
HT740, 750, 754



DESCRIPTION	QTY.	YEAR	DELUXE KIT	MASTER O/H KIT	LESS STEELS KIT	OVERHAUL KIT	GASKET & SEAL KIT
REBUILDER KITS							
Kits - HT740/754 (1) (2)	1	-			K3100-LS	K31900X	
Kits - CT700 - Hydraulic (23012606)	1	-				K31900C	
Kits - CT700 - Electronic (ATEC) (29508019)	1	-				K31900D	
(1) Does not contain steel front support gaskets. See gasket component listing below for support gasket listing. (2) Reference No. for O/H Kit K31900X is 29532370 (supersedes 23019327).							

ILL.	DESCRIPTION	QTY.	YEAR	PART NO.	REFERENCE NO.
MISCELLANEOUS GASKETS & SEALS/PAN GASKETS					
N.I.	Gasket - Oil Pan - Cork & Neoprene	1	-	13740X	23016681
N.I.	Gasket - Oil Pan - Armstrong®	1	-	13740W	23016681
N.I.	Gasket - Oil Pan - Refuse Service - HT740	1	-	13740R/S	23045042
N.I.	Gasket - Converter Pump Hub	1	-	13174A	6880901
N.I.	Gasket - Rear Cover	1	-	13185	6839213
N.I.	Gasket - Front Support - Steel - 1976 or Later Models - DRD	1	-	13196	6880912
N.I.	Gasket - Front Support - Steel - Exc. 1976 or Later Models - DRD	1	-	13196A	23046658
N.I.	O-Ring - Filler Tube	1	-	13178	23013114
N.I.	Seal - Converter Pump - Lathe Cut	1	-	13175	6880389
N.I.	Seal - Lockup - Inner - Lathe Cut	1	-	13176	6770492
N.I.	Seal - Lockup - Outer - Lathe Cut	1	-	13177	6758740
N.I.	Seal - Front Pump - Lathe Cut	1	-	13184	6837255
N.I.	Seal - Converter Hub - Lathe Cut	1	-	13519	23045519
N.I.	Seal - Lip - 2-3 Outer	1	-	13190	23011454
N.I.	Seal - Lip - 1st Inner	1	-	13192	23011458
N.I.	Washer - Drain Plug - Coated	1	-	11423B	29507909
N.I.	Washer - Center Support	1	-	31422	6880077
N.I.	Washer - Neutral Switch	1	-	31425	6839761
CLUTCH PLATES					
N.I.	Friction - Lockup Clutch - Not in Kits (4)	1	-	W31102	23048511
N.I.	Friction - Forward Clutch (3) (23042199)	5	-	R11104	29529492
N.I.	Friction - Forward Clutch (4)	5	-	W11104	23042199
N.I.	Friction - Fourth Clutch (3) (23042199)	5	-	R11104	29529492
N.I.	Friction - Fourth Clutch (4)	5	-	W11104	23042199
N.I.	Friction - Third Clutch (3)	4	-	R31104	23010439
N.I.	Friction - Second Clutch (3)	6	-	R31104	23010439
N.I.	Friction - First Clutch (3)	6	-	R31104	23010439
N.I.	Friction - Low Clutch (4)	6	-	W31101	23041786
N.I.	Steel - Forward Clutch	5	-	31100	6834679
N.I.	Steel - Fourth Clutch	5	-	31100	6834679
N.I.	Steel - Third Clutch - .0993 - .1063" - Red	AR	-	31105	6834488
N.I.	Steel - Second Clutch - .0993 - .1063" - Red	AR	-	31105	6834488
N.I.	Steel - Second Clutch - .1161 - .1231"	AR	-	31106	6834720
(3) Raybestos brand plate. OEM approved heat-treated paper. (4) S.K. Wellman plate. OEM approved graphitic.					

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To Get The Correct Parts, You Must Provide The Assembly Number Found On The Transmisson Name Plate.

ILL.	DESCRIPTION	QTY.	YEAR	PART NO.	REFERENCE NO.	
CLUTCH PLATES (cont.)						
N.I.	Steel - First Clutch - .0995 - .1025" - Red	AR	-	31107	23047771	
N.I.	Steel - First Clutch - .1161 - .1231"	AR	-	31108	23047772	
N.I.	Steel - Low Clutch - .0995 - .1025" - Red	AR	-	31107	23047771	
N.I.	Steel - Low Clutch - .1161 - .1231"	AR	-	31108	23047772	
N.I.	Backing Plate - Lockup Clutch - Not in Kit	1	-	31957	23016957	
N.I.	Backing Plate - 3rd Clutch (6834319)	1	-	31731	29500731	
N.I.	Backing Plate - 4th Clutch	1	-	31715	23011235	
FILTERS/FILTER KITS						
N.I.	Filter Kit - w/6" Pickup Tube - Early	1	-	FK31800	6839945	
N.I.	Filter Kit - w/7" Pickup Tube	1	-	FK31800A	29530564	
N.I.	Filter - w/6" Pickup Tube - Early (23013624)	1	-	31800	29505562	
N.I.	Filter - w/7" Pickup Tube (23013625)	1	-	31800A	29505563	
N.I.	Filter - Spin-On - 2 Qt. Capacity	1	-	31801	N.L.	
N.I.	Filter - Spin-On - 2 Qt. Capacity - w/ Adapter	1	-	31801K	N.L.	
N.I.	Screen - Governor	1	-	11712	23045247	
METAL CLAD SEALS						
N.I.	Front Pump	1	-	31200	23016947	
N.I.	Rear Cover	1	-	21850	6773311	
N.I.	Manual Lever	1	-	38511	23010610	
BUSHINGS						
N.I.	Support Housing - Center	1	-	31003	6883005	
N.I.	Front Planetary	1	-	31001	6835322	
N.I.	Sun Gear - Center - Front & Rear	2	-	31002	29506041	
N.I.	Sun Gear - Low Clutch	1	-	31004	6883007	
N.I.	Output Shaft	1	-	34002	23015807	
SEALING RINGS/RING KITS						
N.I.	Sealing Ring Kit - Complete	1	-	K31901	N.L.	
THRUST WASHERS/NEEDLE BEARINGS						
N.I.	Washer - Center Carrier - Steel	8	-	31415	6837630	
N.I.	Washer - Center Carrier - Bronze	8	-	31416	6839511	
N.I.	Washer - Rear Carrier - Steel	8	-	31417	6837629	
N.I.	Washer - Rear Carrier - Bronze	8	-	31418	6839512	
N.I.	Washer - Center Support	1	-	31422	6880077	
N.I.	Washer - Neutral Switch	1	-	31425	6839761	
HARD PARTS - NEW						
ILL.	DESCRIPTION	BRAND	QTY.	YEAR	PART NO.	REF NO.
N.I.	Pump Assembly - Two Gear (6834749)		1	-	31206	29510666
N.I.	Pump Assembly - Three Gear (3 Udder) (6838843)		1	-	31206A	29508022
N.I.	Pump Hub		1	-	31204	6834741
N.I.	Pump Hub - New O-Ring Style		1	-	31204A	23045371
N.I.	Pump Plate - Two Gear		1	-	31201	6834739
N.I.	Pump Plate - (3 Udder)		1	-	31201A	6838844
N.I.	Pump Gear - Bearing - HT740		1	-	31210	23012921
N.I.	Pump Gear - Shaft Pin - HT740 - Threaded hole for easy removal.		1	-	31888	6834888
N.I.	Pump Support - w/Ground Sleeve - HT740 (6883950)		1	-	31950	23047298
N.I.	Stator Spring - (10 Per Stator)		10	-	31535	23018535
N.I.	Stator Roller - (10 Per Stator)		10	-	31976	6837976
N.I.	Stator Race - Freewheel Rotor		1	-	31293	6772293
N.I.	Stator Assembly - (740 Series)		1	-	31462	6772462

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To Get The Correct Parts, You Must Provide The Assembly Number Found On The Transmission Name Plate.

ILL.	DESCRIPTION	BRAND	QTY.	YEAR	PART NO.	REF NO.
HARD PARTS - NEW (Cont.)						
N.I.	Stator Repair Kit (Inc. 1 Ea. 23017442 Plate and 29506485 Plate; and 10 Ea. 6771018 Rivet)		1	-	7-SRK	N.L.
N.I.	Roller		1	-	31976	6837976
N.I.	Center Support Repair Sleeve		1	-	31446	23011446
N.I.	Driven Gear - Small - w/o Bearing		1	-	31301-1	6834976
N.I.	Driven Gear - Small - w/Bearing		1	-	31301-2	6834979
N.I.	Drive Gear - Large - HT740 Drive Lugs		1	-	31301-3	6771084
N.I.	Drive Gear - Large - HT740 Drive Lugs - Oversize on O.D.		1	-	31301-4	6771084
N.I.	Ground Sleeve - Finished I.D. - Bearing Installed		1	-	31202	23047199
N.I.	Ground Sleeve - Bearing		1	-	31209	9441863
N.I.	Bearing - Front Support - Torrington Brand		1	-	31209	9441863
N.I.	Bearing Retainer - Converter		1	-	31436	6880436
N.I.	Locking Key - Converter Cover (Football Key)		1	-	21209	6772552
N.I.	Sun Gear - 31 Teeth		1	-	31225	6883935
N.I.	Sun Gear - 32 Teeth		1	-	31225A	29506042
N.I.	Sun Gear - Front		1	-	31183	6835183
N.I.	Caged Bearing - Front Planet - (6 Per)		6	-	31920	9429635
N.I.	Caged Bearing - Center Planet - (8 Per)		8	-	31921	9422966
N.I.	Caged Bearing - Rear Planet - (8 Per)		8	-	31922	9423442
N.I.	Main Shaft - HT740		1	-	31684	6834684
N.I.	Main Shaft - HT750		1	-	31684A	6837484
N.I.	Turbine Shaft		1	-	31785	6836404
N.I.	Pin - Front Planet - Use in Planet 8635579 - HT740-750		6	-	11216	6831679
N.I.	Pin - Center Planet - Use in Planet 6835073 - HT740-750		4	-	31217	6835182
N.I.	Pin - Rear Planet - Use in Planet 6835628 - HT740		4	-	31216	6834662
N.I.	Pin - Rear Planet - Use in Planet 6837501 - HT750		4	-	31216A	6837478
N.I.	Speedometer Drive Gear		1	-	31455	6835455
N.I.	Gear Set - Center Pinion - (4 Per Set)		4	-	31777	6838417
N.I.	Gear Set - Front Pinion - (6 Per Set)		6	-	31778	6838418
N.I.	Gear Set - Rear Pinion - (4 Per Set)		4	-	31419	6838419
N.I.	Ring Gear - Front Planetary		1	-	31327	6834327
N.I.	Housing - 4th Clutch		1	-	31556	23046556
N.I.	Governor - I.D. - 461		1	-	11410A	6885570
N.I.	Governor - I.D. - 462		1	-	11410B	6885571
N.I.	Governor - I.D. - 463		1	-	21410	6885572
N.I.	Governor Gear Kit	(8624939)	1	-	K34411A	6883938
N.I.	Output Shaft - Nut - Self Lock Hex - Rear		1	-	21956	6771144
N.I.	Manual Selector Shaft Kit		1	-	K11235	23017610
N.I.	Carrier - Center - (Also Used In V730, Rear Carrier)		1	-	31073	6835073
N.I.	Front Carrier Replacement Flange - w/6 Pins		1	-	RF31580	6835580
N.I.	Front Carrier Replacement Flange Pins Only		6	-	31580P	N.L.
N.I.	Hub - Forward Clutch		1	-	31021	6839021
N.I.	Hub - 4th Clutch Drive		1	-	31605	6835605
N.I.	Hub - 4th Clutch - Early - (Housing) - 5 Pad (6)		1	-	31486	6834486
N.I.	Hub - 4th Clutch - Late - (Housing) - 10 Pad (6)		1	-	31485A	29506485
N.I.	Hub - Turbine		1	-	31034	6837034
N.I.	Piston - Lockup		1	-	31808	29503808
N.I.	Lockup Plate - 2 Key		1	-	31957	23016957
N.I.	Regulator Valve - Main Pressure		1	-	31453	6834453
N.I.	Tube & Dip Stick Assembly - Universal		1	-	11999U	N.L.
(6) Check to see if lip seal sets on housing or piston to get correct housing.						
ELECTRICAL PRODUCTS						
N.I.	Solenoid - White - 6 per		1	-	5A-439	23019308
N.I.	Solenoid - Black - 3 per		1	-	5A-439A	23019309

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ALLISON

CT/CLT/CRT3000 (3340/3461)

To Get The Correct Parts, You Must Provide The Assembly Number Found On The Transmisson Name Plate.

REBUILDER KITS

DESCRIPTION	QTY.	YEAR	DELUXE KIT	MASTER O/H KIT	LESS STEELS KIT	OVERHAUL KIT	GASKET & SEAL KIT
CRT3000 Series (6775438) -	1	-				AK33900	
CT/CLT/ 3340-3461 Series (6775434) -	1	-				AK33900A	

ILL.	DESCRIPTION	QTY.	YEAR	PART NO.	REFERENCE NO.
CLUTCH PLATES					
	CRT 3000:				
N.I.	Friction - All - 3000 Series	AR	-	33103	6768446
N.I.	Steel - 6T Wide - 3000 Series	AR	-	33100	6837690
N.I.	Steel - 21T Narrow - Various - 3000 Series	AR	-	33102	6837442
	CT/CLT/ 3340-3461:				
N.I.	Friction - Splitter Overdrive	2	-	33105B	6759048
N.I.	Friction - Splitter Direct/Hi-Range	AR	-	33107B	6830950
N.I.	Friction - Low, Reverse, Intermediate	AR	-	33103B	6835996
N.I.	Friction - L/U	1	-	33110B	6770647
N.I.	Steel - Splitter Overdrive	2	-	33104B	6771349
N.I.	Steel - Splitter Direct/Hi-Range	AR	-	33106B	6770917
N.I.	Steel - Low, Reverse, Intermediate	AR	-	33102B	6770264
N.I.	Backing Plate - Splitter Direct	AR	-	33715B	6771348
N.I.	Backing Plate - Hi-Range	AR	-	33715D	6770765
FILTERS/FILTER KITS					
N.I.	Filter - Steel Screen - 3000 Series	1	-	33800	6769996
N.I.	Filter - Steel Screen - 3340 Series	1	-	33800B	6768472
N.I.	Filter - Paper Screen - 3340 Series	1	-	33800C	5578261

HARD PARTS - NEW

ILL.	DESCRIPTION	BRAND	QTY.	YEAR	PART NO.	REF NO.
N.I.	Charging Pump		1	-	33920	23046402
N.I.	Ground Sleeve		1	-	33923	6775868
N.I.	Ground Sleeve (Repair Sleeve)		1	-	33923S	6775857
N.I.	Converter Turbine		1	-	33930	6779941
N.I.	Splitter Carrier - w/Turbine Shaft		1	-	33964	6775859
N.I.	Splitter Shaft Assembly		1	-	33965	6775877
N.I.	Sun Gear - Low		1	-	33958	6779667
N.I.	Input Gear - Terex		1	-	33981	9209334
N.I.	Output Gear - Terex		1	-	33982	9157334
N.I.	Idler Gear - Terex		1	-	33983	9232489
N.I.	Pin Gear - Splitter Carrier		1	-	33216	6754852
N.I.	Pin Gear - Output Shaft Carrier		1	-	33216B	6756102
N.I.	Hub Converter		1	-	33204	6758781
N.I.	Race Stator		1	-	33907	6768829
N.I.	Diaphragm Assembly/Late Style		1	-	33714	6836936
N.I.	Bushing - Selector Shaft		1	-	33009	6837124
N.I.	Cap - Drop Box		1	-	33130	9232490

ALLISON TT2000/3000/4000

To Get The Correct Parts, You Must Provide The Assembly Number Found On The Transmisson Name Plate.

REBUILDER KITS

DESCRIPTION	QTY.	YEAR	DELUXE KIT	MASTER O/H KIT	LESS STEELS KIT	OVERHAUL KIT	GASKET & SEAL KIT
Rebuilder Kits - TT2000 (6838897)	1	-				AK33900M	
Rebuilder Kits - TRT2000 (6838902)	1	-				AK33900N	
Rebuilder Kits - TT3000 (23012131)	1	-				AK33900P	
Rebuilder Kits - TT/TRT4000 (6880399)	1	-				AK33900R	

ILL.	DESCRIPTION	QTY.	YEAR	PART NO.	REFERENCE NO.	
CLUTCH PLATES						
N.I.	Friction - Bronze - Early	1	-	33103M	6775541	
N.I.	Friction - Graphtic - Late	1	-	33103N	23010122	
N.I.	Friction - High - Range Transfer	1-2	-	33103P	23010871	
N.I.	Steel - 6T Wide	1	-	33100	6837690	
N.I.	Steel - 21T Narrow - Various - Low	1	-	33102	6837422	
THRUST WASHERS/NEEDLE BEARINGS						
N.I.	Bearing Kit - TT2000	1	-	K33400P	N.L.	
HARD PARTS - NEW						
ILL.	DESCRIPTION	BRAND	QTY.	YEAR	PART NO.	REF NO.
N.I.	Pump Gear - Set - TT2000		1	-	K33201A	N.L.
N.I.	Charging Pump:					
	- w/ 2 Bolt Pad - Early TT2000		1	-	33920M	6885175
	- w/ 6 Bolt Pad - TT2000/3000		1	-	33920P	23011646
	- TT4000		1	-	33920S	23011649
N.I.	Ground Sleeve - TT2000/3000		1	-	33923M	6880493
N.I.	1st Turbine Drive Gear:					
	- 60T - w/ 1 1/2" Snout - TT2000		1	-	33931M	6774671
	- 60T - w/ 2" Snout - TT2000/3000		1	-	33931P	23013426
N.I.	1st Turbine Driven Gear - 60T		1	-	33932M	23011628
N.I.	Input Accessory Gear:					
	- 40T - TT2000		1	-	33984M	23017247
	- 48T - TT2000		1	-	33984P	23017248
	- 42T - TT2000		1	-	33984S	23015965
N.I.	Accessory Gear:					
	- 44T		1	-	33985M	6777456
	- 42T		1	-	33985P	6776965
	- 42T - Ford Loader		1	-	33985S	6838516
	- Shaft PTO - TT2000		1	-	33987M	6836519
N.I.	Bearing - Charging Pump - TT2000/3000		2	-	TT1210	148409
MISCELLANEOUS						
N.I.	Service Manual - OEM		1	-	TM-2000M	N.L.
N.I.	Parts Manual - OEM		1	-	TM-2000P	N.L.

ALLISON

CLBT4000 (4460/HT70)

To Get The Correct Parts, You Must Provide The Assembly Number Found On The Transmisson Name Plate.

REBUILDER KITS

DESCRIPTION	QTY.	YEAR	DELUXE KIT	MASTER O/H KIT	LESS STEELS KIT	OVERHAUL KIT	GASKET & SEAL KIT
CLBT4000 (4460/HT70) (6774212)	1	-				AK37900	

ILL.	DESCRIPTION	BRAND	QTY.	YEAR	PART NO.	REF NO.
HARD PARTS - NEW						
N.I.	Charging Pump		1	-	37920	6772023
N.I.	Stator Assembly		1	-	37925	6772462
N.I.	Ground Sleeve		1	-	37923	6834444
N.I.	Output Shaft		1	-	37993	6775319
N.I.	Transfer Drive Gear		1	-	37991	6775325
N.I.	Piston - Lock-Up		1	-	37845	29503808
N.I.	Backing Plate		1	-	37846	23016957
N.I.	Stator Race		1	-	37907	6772293

NOTES

ALLISON CLBT5000/6000/8000

To Get The Correct Parts, You Must Provide The Assembly Number Found On The Transmisson Name Plate.

REBUILDER KITS

DESCRIPTION	QTY.	YEAR	DELUXE KIT	MASTER O/H KIT	LESS STEELS KIT	OVERHAUL KIT	GASKET & SEAL KIT
CLBT5000 - Early (23019147)	1	-				AK37900M	
CLBT5000/6000 - Late (29541551)	1	-				AK37900N	
CLBT8000 (29541552)	1	-				AK37900P	

ILL.	DESCRIPTION	QTY.	YEAR	PART NO.	REFERENCE NO.
CLUTCH PLATES					
N.I.	Friction - Internal Spline - 5000/6000 Series	1	-	37103	23041616
N.I.	Steel - External Spline - 5000/6000 Series	1	-	37100	6769326

HARD PARTS - NEW

ILL.	DESCRIPTION	BRAND	QTY.	YEAR	PART NO.	REF NO.
N.I.	Charging Pump:					
	- 5000/6000		1	-	37920M	6880125
	- 5000/6000 - High Capacity		1	-	37920P	23018418
	- 8000		1	-	37920S	6880121
	CLBT 5000/6000:					
N.I.	Pump Driven Gear		1	-	37201-7	6769720
N.I.	Pump Drive Gear		1	-	37201-6	6769722
N.I.	Ground Sleeve - Large Bore - Late		1	-	37923M	6774712
N.I.	Turbine Shaft - Short		1	-	37930M	6831068
N.I.	Drop Box Gear - Top		1	-	37981M	23047087
N.I.	Drop Box Gear - Lower		1	-	37982M	23012928
N.I.	Drop Box Idler Gear		1	-	37983M	6837349
N.I.	Drop Box Idler Gear - w/o Speedo Plug		1	-	37983P	6837350
N.I.	Drop Box Output Shaft		1	-	37993P	23047088
N.I.	Lower Drop Box Shaft		1	-	37994M	6759043
N.I.	L/U Piston - Converter:					
	- 100 Spline Turbine		1	-	37845M	6774130
	- 89 Spline Turbine		1	-	37845P	29537227
	- 110 Spline Turbine		1	-	37845S	23048574
N.I.	Backing Plate - Converter:					
	- 100 Spline Turbine		1	-	37848M	6770587
	- 89 Spline Turbine		1	-	37848P	23016058
	- 110 Spline Turbine		1	-	37848S	23048498
N.I.	Stator - Race - 43 Spline		1	-	37843M	6756319
	Stator - Race - 45 Spline		1	-	37843P	6774709

NOTES

REBUILDER KITS

[illegible]

HEAVY DUTY TRANSMISSION COOLERS

TRANSMISSION MODEL	HORSEPOWER SERIES	ON HIGHWAY	OFF HIGHWAY
		OEM RATING	OEM RATING
MT40, 41, 42	150	K1290	K1292
	200	K1290	K2305
	250	K1292	K2306
AT540, 543, 545, 547	125	K1299	K1299
	150	K1299	K1299
	175	K1299	K1299
	200	K1299	K1299
	235	K1299	K1299
MT640, 643, 645, 653, 653DR	175	K1299	K1299
	200	K1299	K1299
	250	K1271	K1271
Without Retarder MT644, 646, 647, 648, 650, 654, 654CR, 655, 656CR	200	K1290	K2305
	250	K1292	K2306
	300	K2305	K1297
V730	200	K1292	N/A
	260	K2305	N/A
Without Retarder HT740, 747, 748, 750, 750DB, 750DR, 754, 754CR, 755CR, 755DR, CLBT754	250	K1292	K2306
	300	K2305	K1297
	350	K2306	K1298
	400	K1297	K1298
	425	K1298	K2312

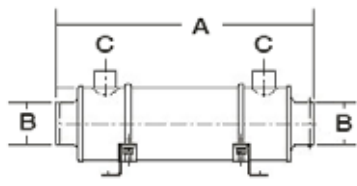
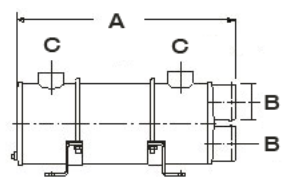
NOTE: K1271, K1277, & K1299 are two pass coil, designed for low flow pumps (ideal for use on Allison Transmissions).

COOLER SELECTION CHART

PART NUMBER	SIZE IN INCHES	FITTING SIZE FPT	GPM RANGE	BTU/HR RATING PER HAYDEN STANDARD 100% FITD 1.7 GPM/TUBE @ 2500 FPM
K1260	12 x 24 x 1-1/2	3/4	6-24	35,200
K1268	12 x 18 x 1-1/2	3/4	6-24	25,800
K1271	24 x 30 x 1-1/2	1	6-24	81,800
K1277	28 x 33 x 1-1/2	1	14-56	110,675
K1290	18 x 24 x 1-1/2	3/4	9-36	54,300
K1292	24 x 24 x 1-1/2	1	12-48	72,300
K1297	36 x 30 x 1-1/2	1-1/4	18-72	133,000
K1298	36 x 40 x 1-1/2	1-1/4	18-72	180,000
K1299	20 x 24 x 1-1/2	3/4	5-20	59,730
K2305	30 x 24 x 1-1/2	1	15-60	90,400
K2306	30 x 30 x 1-1/2	1	15-60	113,000
K2312	40 x 42 x 1-1/2	2	20-80	208,000



HEAT EXCHANGERS MANUALS & CATALOGS

HEAT EXCHANGERS					
TYPE I			TYPE 2		
					
TYPE	BTU	A (LENGTH)	B DIA. (WATER IN)	C DIA. (OIL PORT/TYPE)	PART NUMBER
I	1230	15.63"	2.25"	.750/14 NPT	H1178
I	1450	15.33"	3.00"	1.0/11.5 NPTF	H1105
I	2050	15.50"	3.00"	1.25/11.5 NPTF	H1127
I	3130	19.38"	3.00"	1.312/12 UN2B	H1249
2	3450	24.55"	2.75"	1.625/12 UN2B	H1274
OTHER SIZES AVAILABLE BY SPECIAL ORDER.					

MANUALS & CATALOGS

DESCRIPTION	PART NO.
Service Manual - AT540, 543, 545 Series Parts Catalog - AT540, 543, 545 Series	TM-540M TM-540P
Service Manual - MT600, 643, 650, 653 Series Parts Catalog - MT600, 643, 650, 653 Series	TM-600M TM-600P
Service Manual - MT644, 647, 654 Series Parts Catalog - MT644, 647, 654 Series	TM-644M TM-644P
Service Manual - HT740, 750, 754 Series Parts Catalog - HT740, 750, 754 Series	TM-700M TM-700P
Service Manual - HT/B741 - 755, Series Parts Catalog - HT/B741 - 755, Series	TM-741M TM-741P
Service Manual - CL/BT750 - 754, Series Parts Catalog - CL/BT750 - 754, Series	TM-750M TM-750P
Service Manual - V730 Parts Catalog - V730	TM-V730M TM-V730P
Service Manual - MD/B 300/400 Parts Catalog - MD/B 300/400 Troubleshoot Manual #2 - OEM - MD/B 300/400 Troubleshoot Manual #3- OEM - MD/B 300/400	TM-3060M TM-3060P TM-3060T TM-3061T
Service Manual - HD/B 500 Parts Catalog - HD/B 500	TM-4560M TM-4560P
Service Manual - LT1000/2000/2400 Parts Catalog - LT1000/2000/2400 Troubleshoot Manual - OEM - LT1000/2000/2400	TM-1000M TM-1000P TM-1000T
Service Manual - TT2000/3000/4000 Parts Catalog - TT2000/3000/4000	TM-2000M TM-2000P
Service Manual - MT30-42 Parts Catalog - MT30-42	TM-3042M TM-3042P

REFERENCE NUMBER TO TRANSTAR INTERCHANGE

REFERENCE PART NO.	NEW SUPERSEDING REFERENCE PART NO.	TRANSTAR PART NO.	REFERENCE PART NO.	NEW SUPERSEDING REFERENCE PART NO.	TRANSTAR PART NO.
148409		TT1210	6775325		37991
148415		11221	6775541		33103M
190139		21139	6775657		K11250
1261968		96-178	6775857		33923S
1363951		3547L	6775859		33964
3039092		11820	6775868		33923
3829139		11548	6775877		33965
3909063		11213	6776965		33985P
5578261		33800C	6777456		33985M
6751723		37333	6778050		11850
6754852		33216	6778383		37383
6756102		33216B	6779667		33958
6756319		37843M	6779941		33930
6756782		21000	6830187		21300
6758036		13159	6830950		33107B
6758740		13177	6831068		37930M
6758781		33204	6831620		11407
6759043		37994M	6831621		11407A
6759048		33105B	6831622		11407B
6761244		13172	6831623		11407C
6762127		3435PL	6831624		11407D
6768446		33103	6831625		11407E
6768472		33800B	6831634		11634-R
6768829		33907	6831641	23045554	11105
6769326		37100	6831658		11411
6769631		11212	6831673		11415
6769720		37201-7	6831676		11676-R
6769722		37201-6	6831679		11216
6769996		33800	6831680		11417
6770264		33102B	6831692		11418
6770492		13176	6831697		11419
6770587		37848M	6831705		11107
6770647		33110B	6833981		13163
6770765		33715D	6833991		11414
6770820		3366PL	6833999		21303
6770845		21845	6834221		21221
6770917		33106B	6834222		21222
6771073		4460P	6834309		11215
6771084	29506678	31301-3	6834327		31327
6771084		31301-4	6834333		37334
6771144		21956	6834444		37923
6771348		33715B	6834453		31453
6771349		33104B	6834486		31486
6771366		13174	6834488		31105
6772023		37920	6834503	29516211	21002/X
6772293		31293	6834583		21224
6772293		37907	6834662		31216
6772462		31462	6834679		31100
6772462		37925	6834684		31684
6772552		21209	6834720		31106
6773311		21850	6834739		31201
6774130		37845M	6834741		31204
6774323	23016683	13158W	6834749	29510666	31206
6774671		33931M	6834817		11817-R
6774709		37843P	6834888		31888
6774712		37923M	6834908		13161
6774968		11211	6834915		21920
6775319		37993	6834976		31301-1

REFERENCE NUMBER TO TRANSTAR INTERCHANGE

REFERENCE PART NO.	NEW SUPERSEDING REFERENCE PART NO.	TRANSTAR PART NO.	REFERENCE PART NO.	NEW SUPERSEDING REFERENCE PART NO.	TRANSTAR PART NO.
6834979	29524133	31301-2	6839945	29536196	FK31800
6835073		31073	6839976		21403
6835182		31217	6839977		21403A
6835183		31183	6839978		21403B
6835322		31001	6839979		21403C
6835385		21001	6839980		21403D
6835398		21004	6880019		21211A
6835455		31455	6880121		37920S
6835567		21216	6880125		37920M
6835568		21568	6880389		13175
6835580		RF31580	6880436		31436
6835605		31605	6880493		33923M
6835642		21642R	6880847		37847
6835768		11768-R	6880899		21212
6835936		11227	6880901		13174A
6835937		11225	6880912		13196
6835939		11939	6880948		37948
6835996		33103B	6880951		37951
6836404		31785	6880952		37204
6836518	29530330	34305C	6880962		37962
6836519		33987M	6880996		37996
6836936		33714	6881028		37028
6837034		31034	6881051	29522708	K37206
6837124		33009	6881052		31301-6
6837203		21206	6881466		11410
6837206		21226	6881471		21410A
6837255		13184	6881926		21005
6837349		37983M	6882565		RH21565
6837350		37983P	6882687		21712
6837422		33102	6882689		13173
6837429		11403	6882736		21410C
6837430		11403A	6882737		21410B
6837431		11403B	6882798	23045483	K11224
6837432		11403C	6882799		K11223
6837433		11403D	6882804		21804
6837442		33102	6883005		31003
6837478		31216A	6883007		31004
6837484		31684A	6883031		13170
6837629		31417	6883033		13169
6837630	29537398 29519114	31415	6883035		13165
6837690		33100	6883044		21800
6837719		11719-R	6883045		21225
6837976		31976	6883703		37703
6838233		37233	6883901		21901
6838417		31777	6883935		31225
6838418		31778	6883938	23045382 23047298	K34411A
6838419		31419	6883950		31950
6838516		33985S	6884259		K21900B
6838640		37640	6884270		FK11800
6839021		31021	6884872		13166
6839163		21302	6884902		11228
6839285		K21900/S	6885145		11145-R
6839375		21415	6885175		33920M
6839376		11416	6885213		K11235
6839508		21508	6885391		98-164
6839511	29519114 29537398	31416	6885423	23016682	13540X
6839512		31418	6885570		11410A
6839514		11413	6885571		11410B

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REFERENCE PART NO.	NEW SUPERSEDING REFERENCE PART NO.	TRANSTAR PART NO.	REFERENCE PART NO.	NEW SUPERSEDING REFERENCE PART NO.	TRANSTAR PART NO.
6885572		21410	23014094		11422
8616052		11301	23014239		13740V
8622947		11002	23014304		11202
8623101	29520292	3643L	23014441		K31301V
8626281		13268A	23014462		21214
8641300		38151V	23014527		21202
8658110	23017367	3410L	23014542		96-178
8683187		5A-187	23014632		K21301V
9157334		33982	23015364		31800B
9209334		33981	23015392	29527502	21201-1
9232489		33983	23015393	29527503	21201-1
9232490		33130	23015402		21201-2
9414211		11503BK	23015404	29527508	21201-2
9418483		21219	23015617	23014632	21301T
9422966		31921	23015732		11732-R
9423442		31922	23015799		21799
9426919		11919	23015807	6836272	34002
9426920	29501499	11920	23015871	29515355	21871R
9429635		31920	23015872		21872R
9438017	29517123	21223/A	23015880	8623121	3284L
9439704		31704	23015883	29525170	13153
9441863		31209	23015965		33984S
23010122		33103	23015975		38151A
23010122		33103N	23016058		37848P
23010439		R31104	23016347		13160
23010610		38511	23016559		3877L
23010654		21713	23016564		13151
23010871		33103P	23016600		13152
23011446		31446	23016606		21107
23011456		13155	23016608		21105
23011457	29509198	13157	23016610		21100
23011471		13164	23016643		21200A
23011475		13154	23016681		13740W
23011628		33932M	23016681		13740X
23011646		33920P	23016722		21204C
23011646		K33206	23016723		21204D
23011649		33920S	23016751	29514491	21751R
23011670		3914D	23016763		21763R
23011779		650M-CASE	23016859		21006
23011825		21825R	23016866		11404
23011924		21003	23016889	29527490	K21636A
23012438		K11900	23016947		31200
23012575		UDK-545	23016957		31957
23012785		21785	23016957		37846
23012921	9429005	31210	23017114	29527481	K21637A
23012928		37982M	23017172		21172R
23012990		11000	23017247		33984M
23013015		11229/-R	23017248		33984P
23013114		13178	23017257		21257R
23013398		21220	23017264	29516333	21108
23013426		33931P	23017267		21221B
23013451		11412	23017446		21204E
23013454		34301	23017521		21225A
23013456		21456	23017610		K11235
23013906		21204/A	23017699		21456B
23013907		21907	23017763		11763
23013926		37926	23018418		37920P
23014020		11920-R	23018535		31535

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REFERENCE PART NO.	NEW SUPERSEDING REFERENCE PART NO.	TRANSTAR PART NO.	REFERENCE PART NO.	NEW SUPERSEDING REFERENCE PART NO.	TRANSTAR PART NO.
23018594		21594F	23048511		W31102
23018596		21596R	23048574		37845S
23018598		21598R	23048628		R14102
23018625	23011670	3914LW	24222079		15D-176
23018811	29511257	34200C-R	25010643		HD223
23018960		21416	25611122		PF897
23018961		21424	29500365	29506392	34661S
23019201		FK21800	29500731	6834319	31731
23019222		21785B	29500739	6752556	11421
23019653		21302V	29500939		14947
23019782		21782	29501099		13350
23019827	29532370	K31900X	29501150		13540W
23040476		21202A	29501160	23016682	13540W/X
23041376		13376	29501161	23016683	13158W
23041616		37103	29501424		14110
23041786		W31101	29501499		11920
23042197		R/W11103	29501543		14956
23042198		R/W11106	29502295		FK11800W
23042199	29529492	W11104	29502302		FK21800W
23042200		R/W21103	29503283		13472
23042201		R/W21104	29503288		13288
23042210		R/W21101	29503665	(AS36-033)	11610
23045042		13740R/S	29503808		31808
23045054		21102	29503808		37845
23045072		11001	29503987		21223/A
23045099	6837442	13171	29505561		31800B
23045247		11712	29505562	23013624	31800
23045328	23013474	11226	29505563	23013625	31800A
23045343		31220	29505633		14956P
23045371		31204A	29505634		14956M
23045519		13519	29505789		DP-789
23045556		21200B	29505859		14200P
23045588	29536334	R14100	29505866	23045299	21423
23045870		21870	29506008		11999U
23045906	23017523	11545	29506041		31002
23046074		11768-R	29506042		31225A
23046108		R21106	29506325		21325
23046152	29527102	21008	29506392		FK11800AW
23046153	29527101	21007	29506468		12507
23046154		21154	29506484		15A-437
23046344		13162	29506485		31486A
23046402		33920	29507528		14200
23046556		31556	29507674	23014306	21203
23046598		11302	29507909		11423
23046638	29527509	K21637	29508022	29510665	31206A
23046658		13196A	29509198	23011474	13156
23046718		21718R	29509636	29537356	11920B-R
23046745		21745R	29509637		20A-436
23046746		21746R	29509660	6838298	11298-R
23047087		37981M	29509983		13157
23047088		37993P	29510666		31206
23047199		31202	29510769		11769-R
23047298		31950	29510838	23014159	11222
23047771		31107	29511860	23018806	8005
23047772		31108	29512113		13161
23048030		21883	29513271	29538490	FK34661SW
23048498		37848S	29513517		11210
23048511		R31102G	29514114		14528M

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REFERENCE PART NO.	NEW SUPERSEDING REFERENCE PART NO.	TRANSTAR PART NO.	REFERENCE PART NO.	NEW SUPERSEDING REFERENCE PART NO.	TRANSTAR PART NO.
29514486		DC-545	29536337		R14106
29514487		DC-540	29536338		R14100M
29514804		14946	29536339		R14102M
29515355		21871R	29536340		R14104M
29515399	23045554	11105	29536341		R14106M
29515691		14850P	29536343		14101
29516211	23045606	21002	29536344		14103
29516215		21606	29536345		14105
29516333		21108	29536346		14107
29516484		14984	29536347		14101M
29516484		21484	29536348		14103M
29516486		21486	29536349		14105M
29516486		14984B	29536350		14107M
29516488		14984M	29536379		15850
29516490		14984P	29536408		20A-199
29520291	8623102	3956L	29536482		15108
29520292		3643L	29536526		13200R
29524116	23046294	21294R	29536722		
29524795	6759971	13150W	29536833		5A-192
29525170		13153	29537067		14803
29526899		14800	29537067		14803
29527101		21007	29537068		K14900-2
29527373		21800	29537227		37845P
29527490		K21636A	29537369		31A-436
29527499	23046636	K21636	29537370		5A-436E
29527502		21201-1	29537371		
29527781		14956B	29537373		5A-436F
29528207		R14104	29537393		15103
29528215	29538491	FK21800L	29537394		15528
29529492	29537887	R11104	29537965		15800
29530312		15100	29537966		15800A
29530313		15101	29537993		15530
29530314		15105	29539579		14802
29530315		15106	29539653		15531A
29530326			29539792		35A-199A
K21900FW			29540479		15A-199
29530330		34305C	29540483		14528
29530495		14109M	29541371		35A-199
29530496		R14108M	29541736		14850
29530531		13351	29541852		15A-199A
29530564			6839962-3		K21201C
FK31800A			6839963-3		K21202C
29531048		15107	J1210		TT1210
29531049		15102	PF-168		FK11800A
29532370		K31900X			
29532584	29527373	21800L			
29533074		5A-198			
29533075		5A-199			
29534354		13287			
29534362		DP-790			
29535230		13473			
29535942	29539669	K14900			
29536105		15531			
29536299		15200			
29536334	23045588	R14100			
29536334		R14100			
29536335		R14102			
29536336		R14104			