



Allison 3000/4000 Series - Proper Torque Specifications

All control module bolts	51-61 N•m	38-45 lb ft
Speed sensor bolts	24-29 N•m	18-21 lb-ft
Flexplate to crankshaft hub bolts	Refer to Engine Manufacturer's Specifications	
Flexplate to flexplate adapter bolts	12 bolt design: 33-39 N•m 6 bolt design: 63-73 N•m	25-29 lb ft 46-54 lb ft
Fluid drain plug	25-32 N•m	18-24 lb ft
Fluid fill tube bracket	24-29 N•m	18-21 lb ft
Control module pressure taps	10-13 N•m	7-10 lb ft
Cooler fittings	#12: 34-47 N•m #16: 54-68 N•m #20: 68-81 N•m	25-35 lb ft 40-50 lb ft 50-60 lb ft
Cooler port cover bolts	51-61 N•m	38-45 lb ft
Expansion plug (before Apr 1997)	1-2 N•m	9-18 lb ft
Flexplate adapter-to-converter cover bolts	33-39 N•m	25-29 lb ft
Output flange bolts	Prior to 12/1/98: 3k: 30-35 N•m 4k: 51-61 N•m After 12/1/98: 3k/4k: 70-80 N•m	Prior to 12/1/98: 22-26 lb ft 38-45 lb ft After 12/1/98: 3k/4k: 52-59 lb ft
PTO cover bolts	51-61 N•m	38-45 lb ft
PTO mounting bolts	51-61 N•m	38-45 lb ft
Breather	12-16 N•m	9-12 lb ft
PTO pressure hose to transmission	10-13 N•m	7-10 lb ft
Rear cover bolts	90-110 N•m	66-81 lb ft
TPS to transmission bracket	M6 bolts: 10-13 N•m ¼ 20 bolts: 12-15 N•m	84-120 lb inch 108-132 lb inch