



Allison 3000/4000 Series - Checklist for Adaptation

Adaptation measurements need to be completed to ensure proper transmission and engine alignment.

	3000 Series	4000 Series
Flywheel Housing: Bore Diameter	17.625 $\frac{+0.005}{-0.000}$ in.	20.125" $\frac{+0.005}{-0.000}$ in.
	(447.68 $\frac{+0.13}{-0.00}$ mm)	(511.18 $\frac{+0.13}{-0.00}$ mm)
Bore Eccentricity (Limits are for installed engines)	0.020 in T.I.R. (0.51 mm)	0.020 in T.I.R. (0.51 mm)
Face Squareness (Limits are for installed engines)	0.020 in T.I.R. (0.51 mm)	0.020 in T.I.R. (0.51 mm)
Crankshaft Hub and/or Adaptor: Converter Pilot Diameter	2.006 - 2.008 in. (50.94 - 50.99 mm)	2.006 - 2.008 in. (50.94 - 50.99 mm)
Face Squareness (T.I.R. per inch of diameter or 25 mm of diameter)	0.0005 in. (0.013 mm)	0.0005 in. (0.013 mm)
Pilot Eccentricity (with respect to crankshaft center of rotation)	0.005 in. T.I.R. (0.13 mm)	0.005 in. T.I.R. (0.13 mm)
Flexplate:		
Check for radial cracks		
Check for elongated mounting holes		
Check for signs of distress or wear		
Converter Axial Location	1.943 - 1.983 in. (49.36 - 50.38 mm)	1.732 - 1.842 in. (44.0 - 44.8 mm)