



Allison MT Series - Proper Torque Specifications

Flexplate to drive cover bolts	56-66 N•m	41-49 lb ft
Flexplate/adapter to drive cover nuts	46-54 N•m	34-40 lb-ft
Transmission to frame mounting bolts	Models w/o retarder: 222-260 N•m Models w/ retarder: 90-110 N•m	164-192 lb ft 67-81 lb ft
Converter side mount bolts	110-132 N•m	81-97 lb ft
Output flange retaining bolt (640, 643, 644, 647)	138-164 N•m	102-121 lb ft
Output flange nut (650, 653, 654CR)	813-1085 N•m	600-800 lb ft
Companion flange or universal joints bolts	Tighten to vehicle's manufacturer's specification	
Converter housing adapter to engine housing	73-88 N•m	54-65 lb ft
Transmission housing to engine housing or adapter	49-58 N•m	36-43 lb ft
Manual selector lever nut	20-27 N•m	15-20 lb ft
PTO mounting bolts	35-43 N•m	26-32 lb ft
Modulator control retaining bolt	14-22 N•m	10-16 lb ft
Bellcrank and cable support brackets to transmission	57-68 N•m	42-50 lb ft
Cooler lines to transmission	34-47 N•m	25-34 lb ft
Temperature sensor plug or temperature sending unit	22-27 N•m	16-20 lb ft
Fill tube fitting	88-102 N•m w/ 0.675" long oil pan boss: 122-136 N•m	65-75 lb ft 90-100 lb ft
Drain plug	20-27 N•m	15-20 lb ft
Speedometer driven gear assembly to rear cover	61-68 N•m	45-50 lb ft
Neutral start switch to transmission housing	68-81 N•m	50-60 lb ft
Reverse signal to transmission housing	5-7 N•m	4-5 lb ft