



Allison 1000/2000 Series - Checklist for Adaptation

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

	SAE No. 2 Housing	SAE No.3 Housing
Flywheel Housing: Bore Diameter	17.625 $\frac{+0.005}{-0.000}$ in.	16.125" $\frac{+0.005}{-0.000}$ in.
	(447.68 $\frac{+0.13}{-0.00}$ mm)	(409.58 $\frac{+0.13}{-0.00}$ 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	1.703 - 1.705 in. (43.26 - 43.31 mm)	1.703 - 1.705 in. (43.26 - 43.31 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)	0.010 in T.I.R. (0.25 mm)	0.010 in T.I.R. (0.25 mm)
Flexplate:		
Check for radial cracks		
Check for elongated mounting holes		
Check for signs of distress or wear		
Converter Axial Location	1.201 - 1.361 in (30.50 - 34.56 mm)	1.581 - 1.741 in. (40.15 - 44.21 mm)
Flatness (Area adjacent to each Converter mounting hole)	0.030 in. T.I.R. (0.076 mm)*	0.030 in. T.I.R. (0.076 mm)*

*when measured at 11.5 in. (292 mm) diameter