



Allison 1000/2000 Series - Proper Torque Specifications

Oil pan bolts	24-29 N•m	18-21 lb ft
Main pressure tap	10-13 N•m	7-10 lb-ft
Cooler fittings	0.750-16 inch series: 20-30 N•m 1.0625-12 inch series: 34-47 N•m	15-22 lb ft 25-35 lb ft
Cooler manifold bolts	20-34 N•m	15-25 lb ft
Flexplate adapter to converter cover bolts	57-68 N•m	42-50 lb ft
Flexplate to crankshaft hub bolts	Refer to Engine Manufacturer's Specifications	
Flexplate to flexplate adapter bolts	57-68 N•m	42-50 lb ft
Fluid drain plug	30-40 N•m	22-30 lb ft
Fluid fill tube bracket bolt	No exact specification - ensure firmly seated against bracket	
Speed sensor bolts	10-13 N•m	7-10 lb ft
Output flange bolt	108-136 N•m	80-100 lb ft
PTO cover bolts	51-61 N•m	38-45 lb ft
PTO mounting bolts	51-61 N•m	38-45 lb ft
NSBU switch to main housing	24-29 N•m	18-21 lb ft
Selector lever nut (customer supplied)	20-27 N•m	15-20 lb ft
PTO pressure hose to transmission	10-13 N•m	7-10 lb ft
Rear cover bolts	51-61 N•m	38-45 lb ft
TPS engine bracket	M6 bolts: 10-13 N•m 0.250-20 bolts: 12-15 N•m	7-10 lb ft 9-11 lb ft