



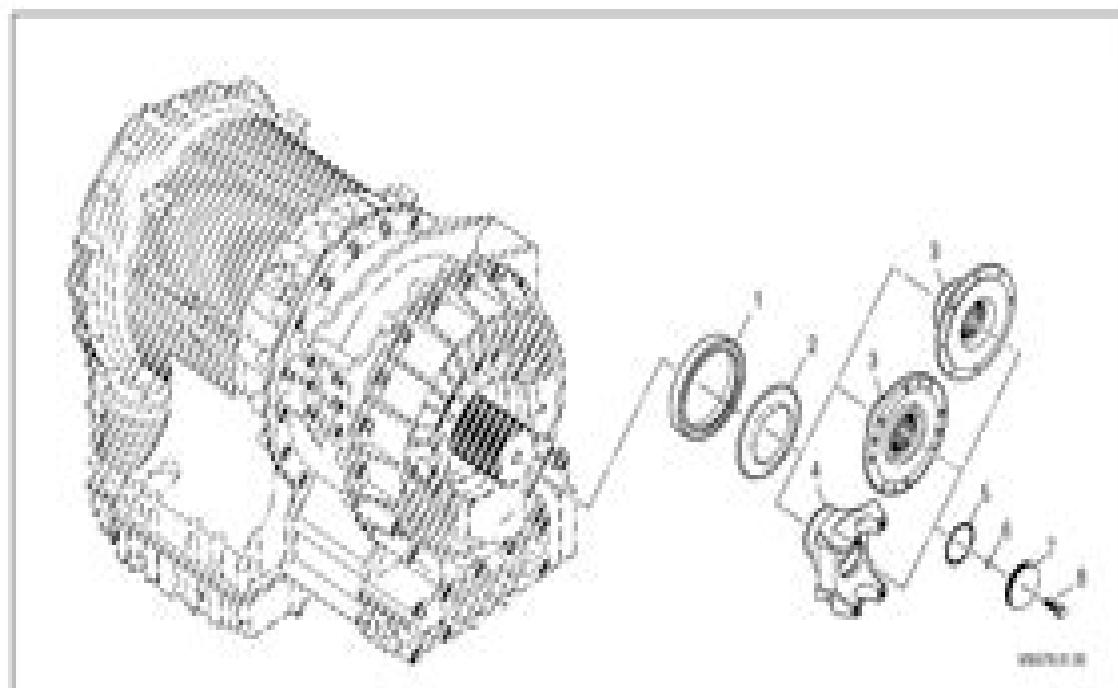
b. Assembly (Figure 2-5 and 2-6)

1. Install oil seal 1 using installer J 37031-A (except 4700 and 4800 models) or J 43024 (4700 and 4800 models), and J 8092 or equivalent.
2. If removed, use special tool J 46150 to press a new slinger 2 onto the flange or yoke.
3. Install flange 3 or yoke 4.
4. Install O-ring 5 on plug 7.
5. Insert bolt 8 through retainer plug 7.
6. Install an O-ring 6 over the threaded end of bolt 8 so that the O-ring seats against the retainer plug.
7. Install retainer plug 7 into the yoke or flange. Tighten bolt 8 to 70-80 N·m (51-60 lb·ft).

2-18. ON-VEHICLE MAINTENANCE

The following may be serviced or removed with the transmission mounted in the vehicle. Refer to the indicated paragraph for removal instructions:

Item	Paragraph
PTO(s)	4-2b
Oil Fill Tube	4-2c(2)
Remote Cooler Manifold	4-2c(3)
Input, Turbine, and Output Speed Sensor	4-2c(7)
Control Module	4-2f



Allison Transmission Service Manual Md306

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