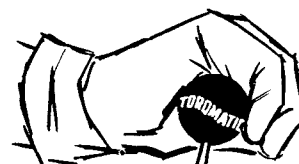
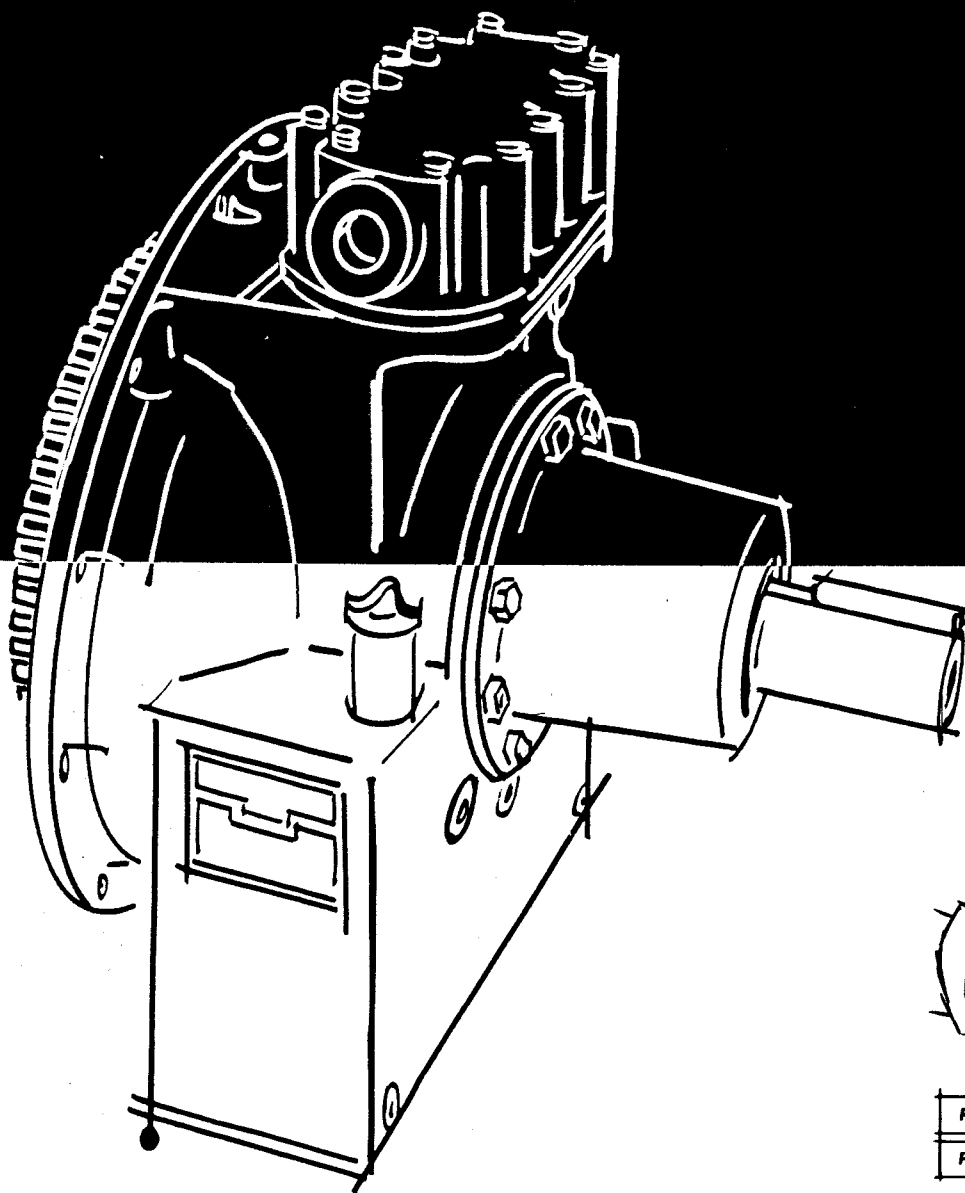


SA 1039K

SERIES 200-300

Allison

TORQMATIC[®]
PARTS CATALOG



POWERSHIFT IS YOUR PROFIT

POWERSHIFT IS OUR BUSINESS

Finding your assembly number

Torqmatic® Converter models included in this catalog are listed on Pages 1-1.1 and 3-1.1 by A/N (Assembly Number) in numerical sequence. Information not included in this catalog can be obtained by contacting the Service Parts Department.

HOW TO ORDER PARTS

Be sure to give the TORQMATIC® Converter Assembly Part Number, the Model, and the Serial Number found on the TORQMATIC® Converter name plate.

Always give the part name and quantity desired, as well as the part number.

CAUTION

Do not order parts directly from the numerical index.

NOTE



All parts orders should be placed with the distributor or dealer from whom you purchased your equipment. Do not place orders directly with Allison Division.

FOR AVAILABLE *Service Kits* —

SEE PAGE 11

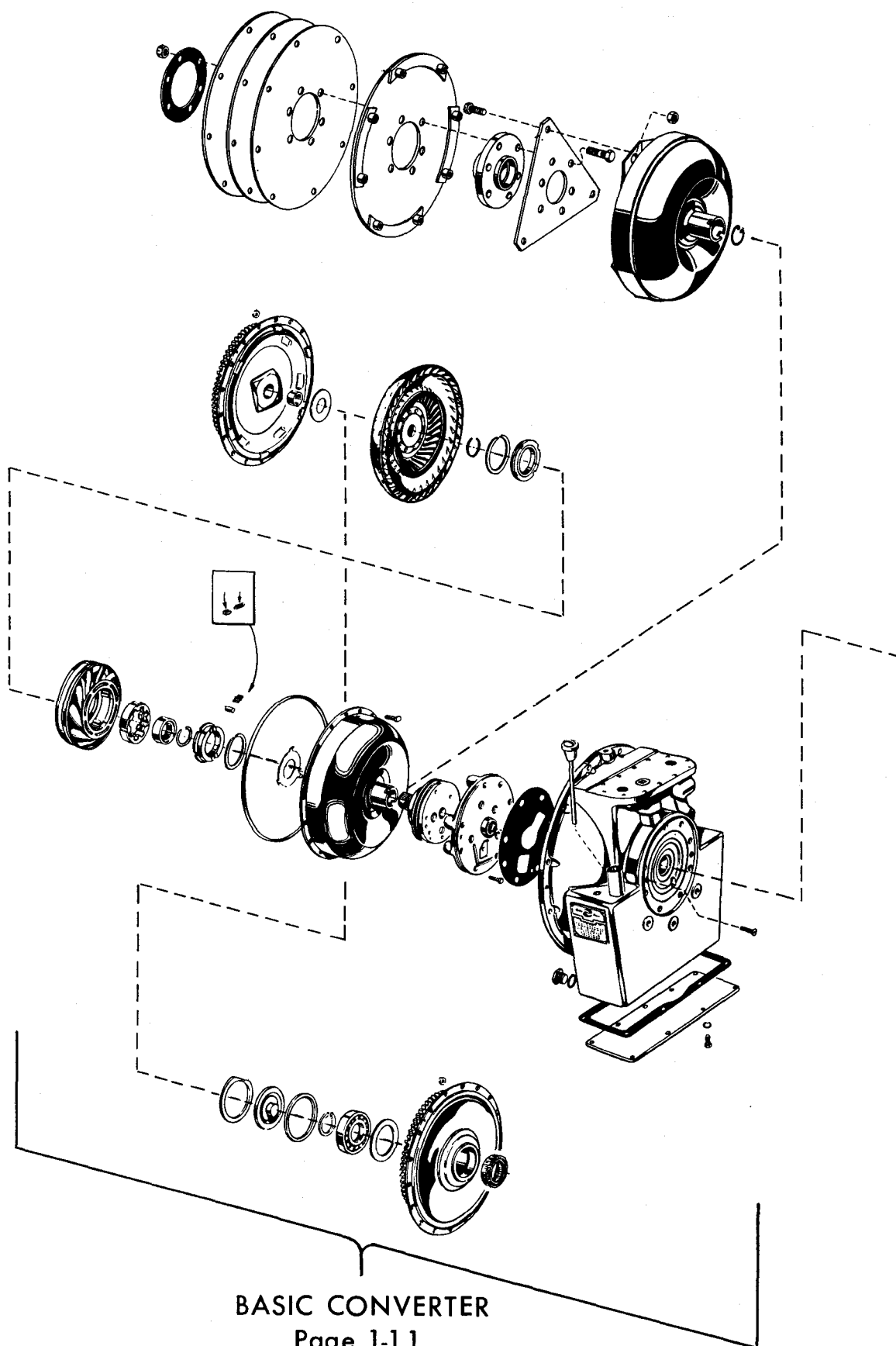
SERIES 200-300 PARTS CATALOG

TORQMATIC is a registered trademark of the Allison Division of General Motors



Allison Division, General Motors, Box 894, Indianapolis, Indiana 46206

11/15/67

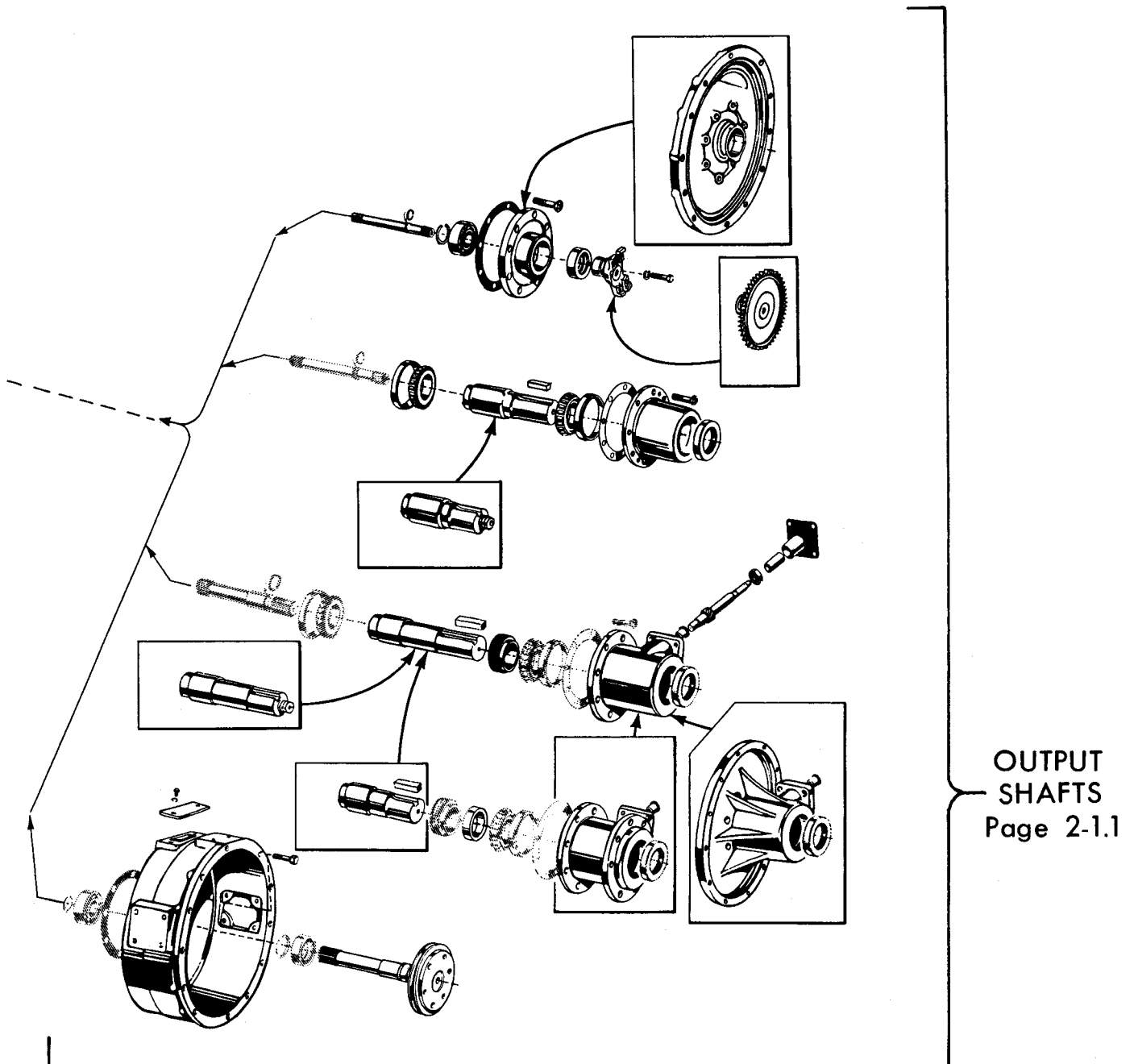


BASIC CONVERTER

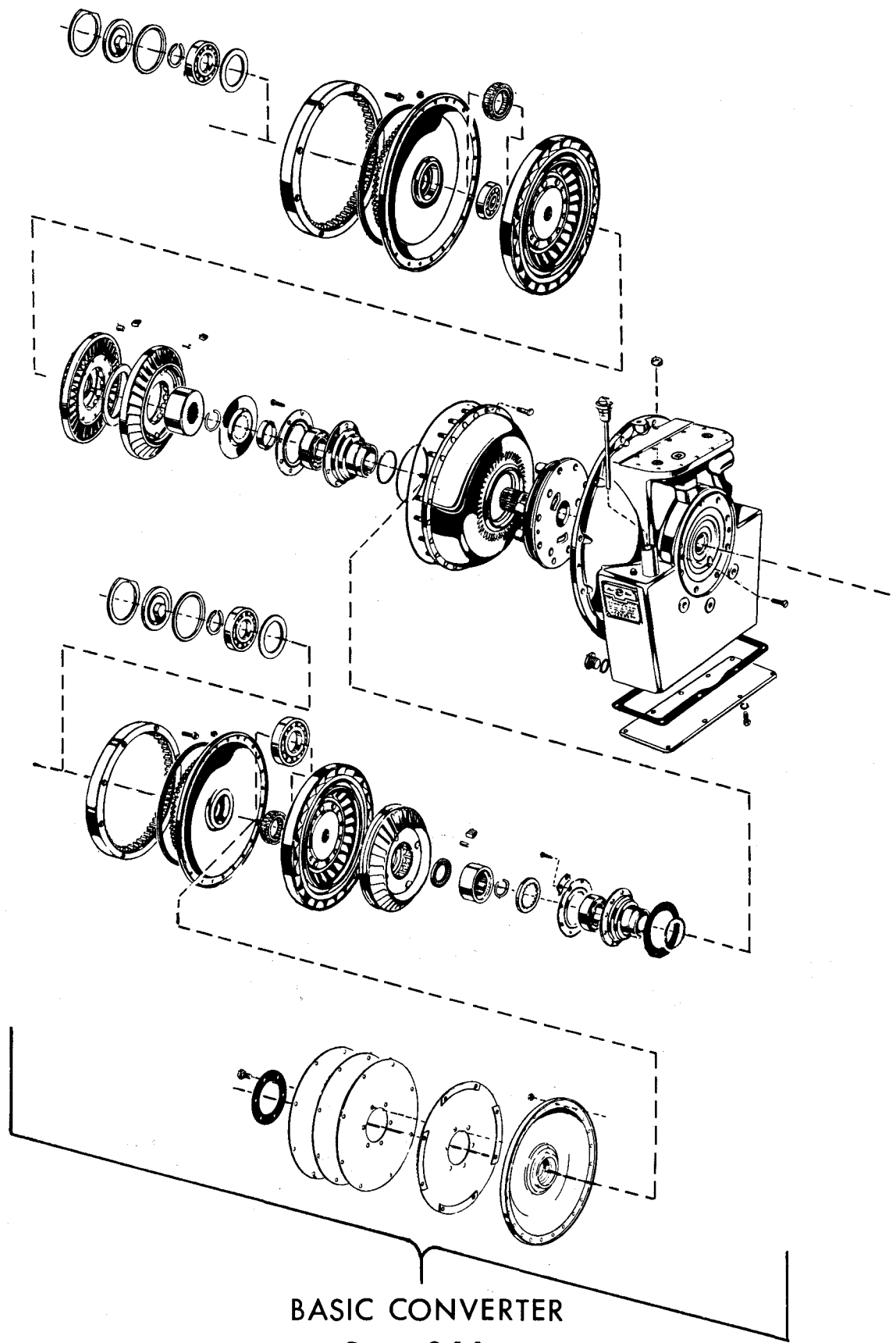
Page 1-1.1

Pictorial Index

To Get the Right Part you
must Know Your Converter
Assembly Number
Found on the Converter
Name Plate



OUTPUT
SHAFTS
Page 2-1.1

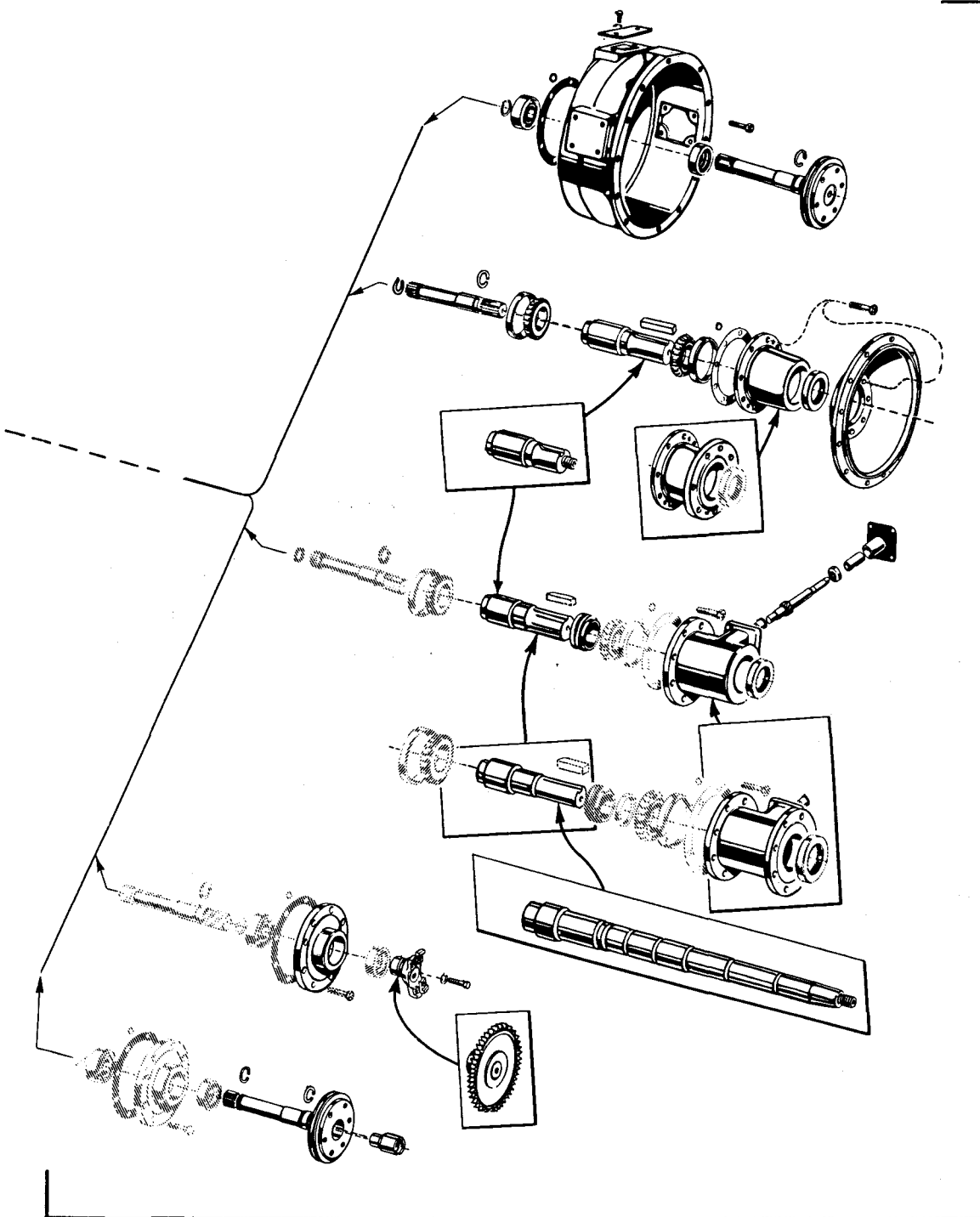


BASIC CONVERTER

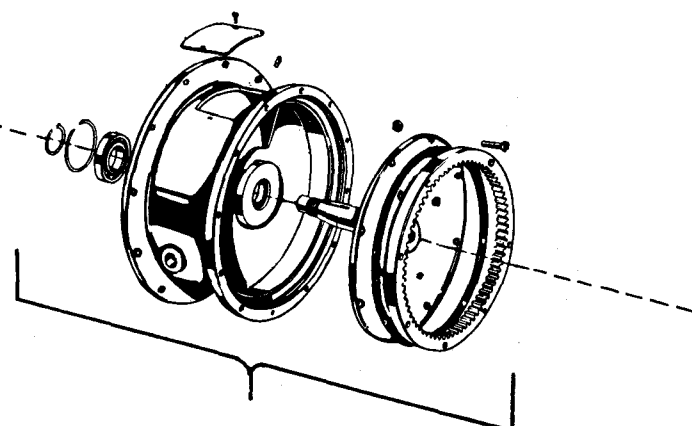
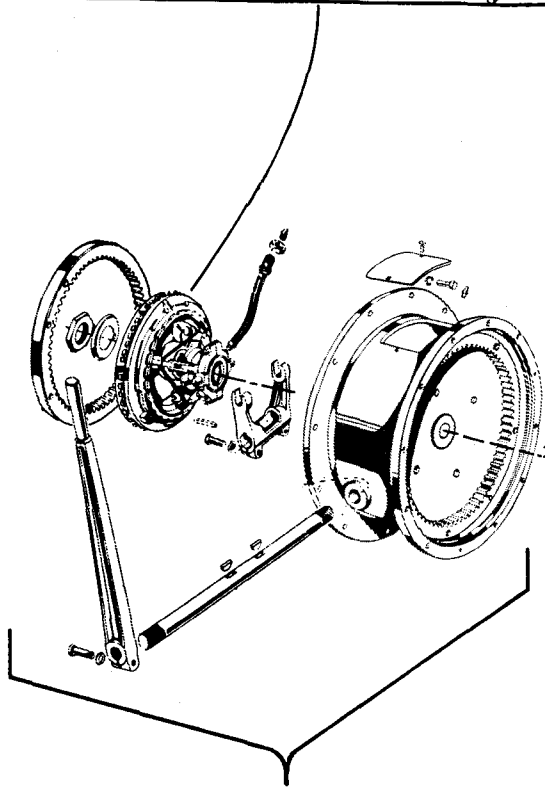
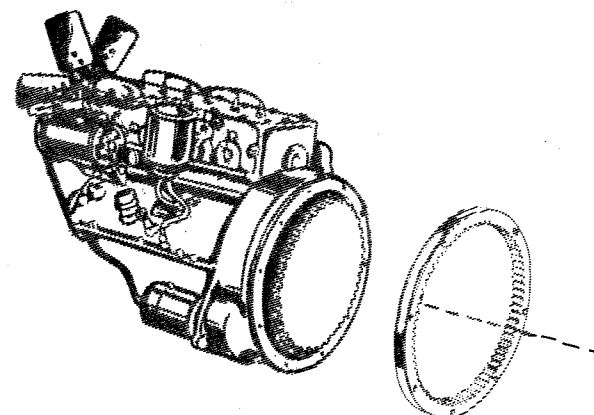
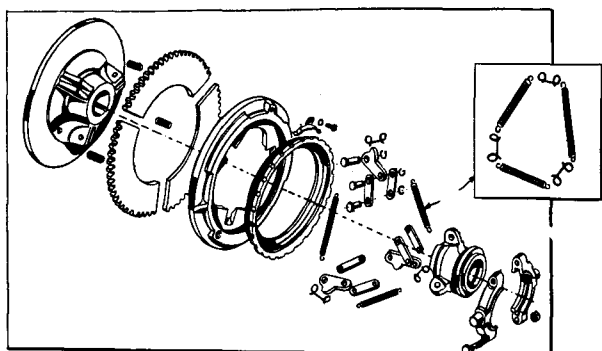
Page 3-1.1

Pictorial Index

To Get the Right Part you
must Know Your Converter
Assembly Number
Found on the Converter
Name Plate



OUTPUT
SHAFTS
Page 4-1.1



MANUAL INPUT
DISCONNECT CLUTCH
ASSEMBLY OPTION

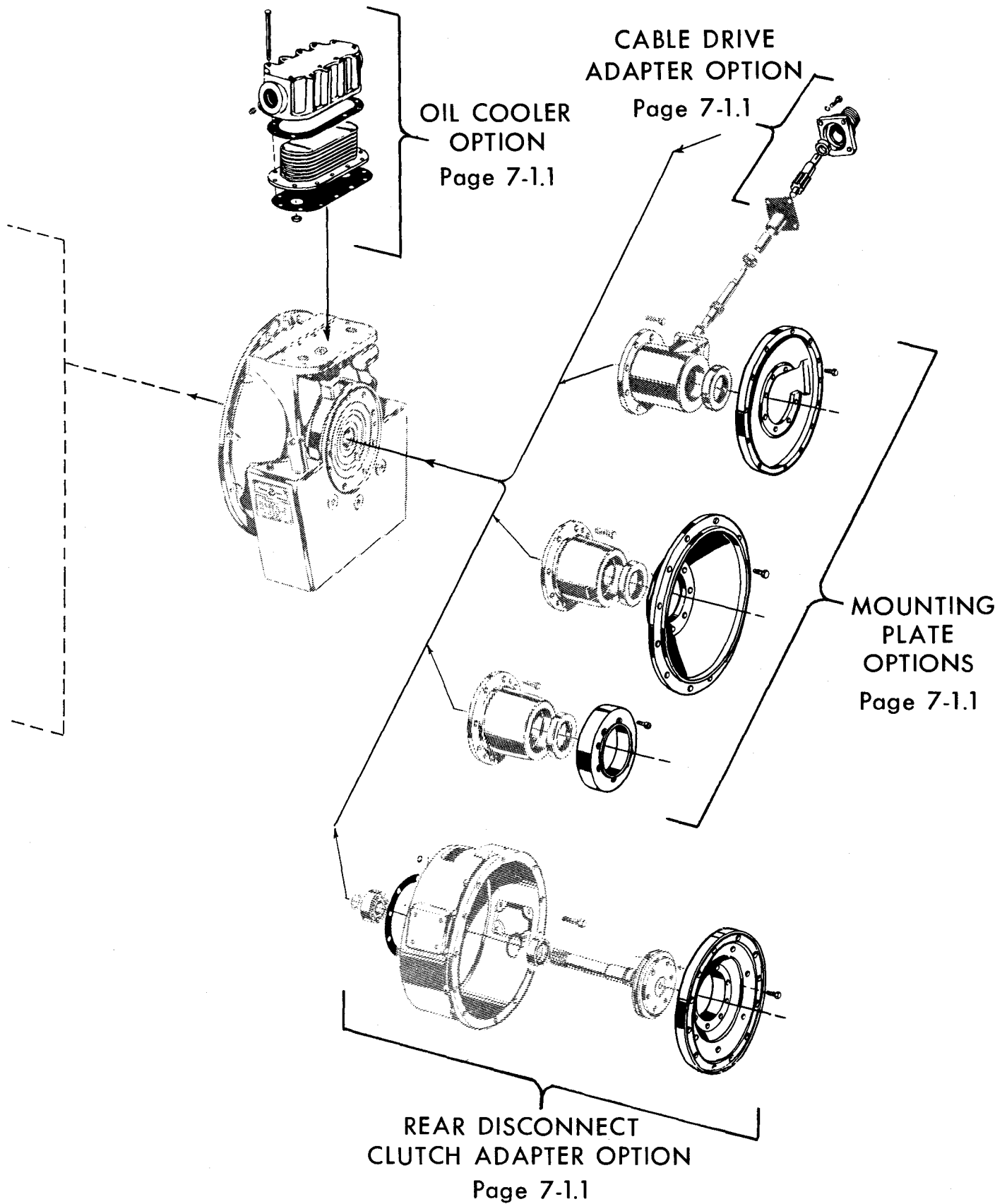
Page 5-1.1

MANUAL INPUT DISCONNECT
CLUTCH HOUSING OPTION

Page 6-1.1

**To Get the Right Part you
must Know Your Converter
Assembly Number
Found on the Converter
Name Plate**

Pictorial Index



MODEL DESIGNATION CODE
(Stamped on the Transmission Name Plate)

BASIC TORQMATIC CONVERTERS: LETTERS

TC = Converter assembly
TCA = Converter with accessory drive
TCO = Converter with overrunning clutch
TCRD = Converter with rear-disconnect clutch

SERIES DESIGNATION: FIRST TWO DIGITS

— 24x = 240 Series
— 32x = 320 Series
— 37x = 370 Series

CONVERTER BASIC VARIATIONS: THIRD DIGIT

— xx4 = Automotive flange
— xx5 = Industrial shaft - standard bearing
— xx6 = SAE 3 rear-disconnect clutch housing
— xx7 = Industrial shaft - extra-duty bearings
— xx8 = Industrial shaft - bevel pinion mounting
— xx9 = SAE 2 rear-disconnect clutch housing

CONVERTER OPTIONS: LAST THREE DIGITS

— xxx-101 = Series 200: Cooler (see section 7, group A)
— xxx-102 = Series 300: Cooler (see section 7, group A)
— xxx-103 = Unassigned
— xxx-104 = Series 200: SAE 2 housing (see section 6, group B)
— xxx-105 = Series 200: SAE 2 housing (see section 6, group B);
10-inch input-disconnect clutch (see section 5, group A)
— xxx-106 = Series 200: SAE 2 housing (see section 6, group B);
cooler (see section 7, group A)
— xxx-107 = Series 200: SAE 2 housing (see section 6, group B);
10-inch input-disconnect clutch (see section 5, group A);
cooler (see section 7, group A)
— xxx-108 = Series 200: SAE 3 housing with 10-inch drive ring (see section 6, group D)
— xxx-109 = Series 200: SAE 3 housing with 10-inch drive ring (see section 6, group D);
10-inch input-disconnect clutch (see section 5, group A)
— xxx-110 = Series 200: SAE 3 housing with 10-inch drive ring (see section 6, group D);
cooler (see section 7, group A)
— xxx-111 = Series 200: SAE 3 housing with 10-inch drive ring (see section 6, group D);
10-inch input-disconnect clutch (see section 5, group A);
cooler (see section 7, group A)
— xxx-112 = Series 200 or 300: Rear-disconnect clutch adapter (see section 7, group F)
— xxx-113 = Series 200: Rear-disconnect clutch adapter (see section 7, group F);
cooler (see section 7, group A)
— xxx-114 = Series 200: 10-inch input drive ring (see section 6, group A)
— xxx-115 = Series 200: 10-inch input drive ring (see section 6, group A);
cooler (see section 7, group A)

(Continued on next page)

MODEL DESIGNATION CODE - Continued
CONVERTER OPTIONS: LAST THREE DIGITS - Continued

- xxx-116 = Series 300: SAE 2 housing (see section 6, group C)
- xxx-117 = Series 300: SAE 2 housing with 11 1/2-inch drive ring (see section 6, group C); 10-inch input disconnect clutch (see section 5, group A)
- xxx-118 = Series 300: SAE 2 housing with 11 1/2-inch drive ring (see section 6, group C); cooler (see section 7, group A)
- xxx-119 = Series 300: SAE 2 housing with 11 1/2-inch drive ring (see section 6, group C); 10-inch input disconnect clutch (see section 5, group A); cooler (see section 7, group A)
- xxx-120 = Series 300: SAE 3 housing with 11 1/2-inch drive ring (see section 6, group E)
- xxx-121 = Series 300: SAE 3 housing with 11 1/2-inch drive ring (see section 6, group E); 10-inch input-disconnect clutch (see section 5, group A)
- xxx-122 = Series 300: SAE 3 housing with 11 1/2-inch drive ring (see section 6, group E); cooler (see section 7, group A)
- xxx-123 = Series 300: SAE 3 housing with 11 1/2-inch drive ring (see section 6, group E); 10-inch input-disconnect clutch (see section 5, group A); cooler (see section 7, group A)
- xxx-124 = Series 300: Rear-disconnect clutch adapter (see section 7, group F); cooler (see section 7, group A)
- xxx-127 = Series 200-300: Accessory drive adapter (see section 7, group B)
- xxx-129 = Series 200-300: Rear-disconnect clutch adapter (see section 7, group F)
- xxx-132 = Series 300: SAE 3 housing with 11 1/2-inch drive ring (see section 6, group F); 10-inch input disconnect clutch (see section 5, group A); accessory drive adapter (see section 7, group B)
- xxx-133 = Series 300: SAE 3 housing with 11 1/2-inch drive ring (see section 6, group E)
- xxx-134 = Series 200: SAE 2 housing with 10-inch drive ring (see section 6, group G)
- xxx-136 = Series 300: SAE 2 housing with 11 1/2-inch drive ring (see section 6, group F)
- xxx-137 = Series 300: SAE 3 housing (see section 6, group J)
- xxx-141 = Series 300: SAE 2 housing with 11 1/2-inch drive ring (see section 6, group F); accessory drive adapter (see section 7, group B)
- xxx-144 = Series 300: SAE 3 housing with 11 1/2-inch drive ring (see section 6, group J); 10-inch input disconnect clutch (see section 5, group A); cable drive adapter for accessory drive (see section 7, group B)
- xxx-145 = Series 200-300: SAE 3 housing with 11 1/2-inch drive ring (see section 6, group E); 10-inch input-disconnect clutch (see section 5, group A); cooler (see section 7, group A) accessory drive adapter (see section 7, group B)
- xxx-146 = Series 200-300: SAE 3 housing with 11 1/2-inch drive ring (see section 6, group J); 10-inch input disconnect clutch (see section 5, group A)

(Continued on next page)

MODEL DESIGNATION CODE - Continued

If an assembly or subassembly is ordered, all subassemblies and detail parts indented beneath it will be included.

If a detail part is ordered, only the detail part will be sent unless its part number is starred (*). A starred (*) part number means that such a part is not serviced alone. This is necessary because certain parts require factory installation or adjustment. If an order is received for a starred (*) part, the assembly or subassembly under which it is indented will be sent.

LISTED BELOW ARE THE SERVICE KITS
AVAILABLE FOR THE SERIES 200-300 TORQMATIC CONVERTER

BASIC OVERHAUL KIT - P/N 6759026

Used on all TC-200 Torqmatic Converters
Contains all expendable items recommended be replaced at normal overhaul,
seals, gaskets, thrust washer, snaprings, stator springs and rollers.

OVERHAUL KIT - P/N 6759027

Used on TC-200 Torqmatic Converter with automotive shaft,
rear disconnect clutch, and chain coupling outputs

Used with Basic Overhaul Kit - P/N 6759026
Contains output bearing, seal & gasket.

OVERHAUL KIT - P/N 6759028

Used on TC-200 Torqmatic Converter with industrial shaft or bevel pinion outputs

Used with Basic Overhaul Kit - P/N 6759031
Contains output bearing, seals & shims.

OVERHAUL KIT - P/N 6759029

Used on TC-200 Torqmatic Converter with governor drive output

Used with Basic Overhaul Kit - P/N 6759026
Contains output bearing, seals & shims.

BASIC SEAL AND GASKET KIT - P/N 6759030

Used on all TC-200 Torqmatic Converters
Contains all seals & gaskets necessary for complete converter rebuild.

DRIVE RING KIT - P/N 6775458

Used on TC-300 Torqmatic Converters
Contains drive ring, seal, washer, bolt and grease.

BASIC OVERHAUL KIT - P/N 6759031

Used on all TC-300 Torqmatic Converters
Contains all expendable items recommended be replaced at normal overhaul,
seals, gaskets, thrust washer, snaprings, stator springs and rollers.

OVERHAUL KIT - P/N 6759032

Used on TC-300 Torqmatic Converter with automotive shaft,
rear disconnect clutch or chain coupling outputs

Used with Basic Overhaul Kit - P/N 6759031
Contains output bearing, seal & gasket.

OVERHAUL KIT - P/N 6759033

Used on TC-300 Torqmatic Converter with industrial shaft output

Used with Basic Overhaul Kit - P/N 6759031
Contains output bearing, seals & shims.

OVERHAUL KIT - P/N 6759034

Used on TC-300 Torqmatic Converter with industrial output shaft with extra-duty bearings

Used with Basic Overhaul Kit - P/N 6759031
Contains output bearing, seals & shims.

OVERHAUL KIT - P/N 6759035

Used on TC-300 Torqmatic Converter with governor drive output

Used with Basic Overhaul Kit - P/N 6759031
Contains output bearing, seals & shims.

OVERHAUL KIT - P/N 6759036

Used on TC-300 Torqmatic Converter with governor drive output with extra-duty bearings

Used with Basic Overhaul Kit - P/N 6759031
Contains output bearing, seals & shims.

BASIC SEAL AND GASKET KIT - P/N 6759038

Used on all TC-300 Torqmatic Converters
Contains all seals & gaskets necessary for complete converter rebuild.

SEAL AND GASKET KIT - P/N 6759039

Used on TC-300 Torqmatic Converter with automotive shaft,
rear disconnect clutch, or chain coupling drive output

Used with Basic Seal & Gasket Kit - P/N 6759038
Contains all seals & gaskets necessary for complete converter rebuild.

SEAL AND GASKET KIT - P/N 6759040

Used on TC-300 Torqmatic Converter with governor drive output

Used with Basic Seal & Gasket Kit - P/N 6759038
Contains output seals & gaskets.

TC-200 SERIES BASIC TORQMATIC CONVERTER SECTION

TO FIND DETAIL PARTS FOR YOUR ALLISON TORQMATIC CONVERTER, TURN TO THE GROUP AND PAGE LISTED OPPOSITE THE ASSEMBLY PART NUMBER OF YOUR CONVERTER.

A/N*	MODEL	GROUP	A/N*	MODEL	GROUP
6755291	TC 244	A	6771706	TCOA 245	B
6755292	TC 245	A	6772099	TCOA 247	B
6755386	TCA 245	A	6772102	TCOA 248	B
6755387	TCRD 246	A	6772207	TCOA 248	B
6756320	TCA 248	A	6777207	TCA 258	C
6756733	TC 248	A	6777208	TCRD 256	D
6756751	TCA 247	A	6777209	TCA 258	C
6757848	TC 248	A	6777466	TCA 258	D
6757850	TC 244	A	6777589	TC 254	D
6758071	TCA 248	A	6777669	TC 255	D
6758320	TCA 248	A	6777823	TCA 257	D
6758586	TCRD 246	A	6779094	TC 254	D
6770237	TCA 247	A	6779463	TC 248	D
6770518	TCO 245	B	6779957	TCRD 259	D
6771200	TCOA 245	B	6832246	TC 256	D
6771244	TCOA 247	B	6832987	TC 258	D

* A/N* - ASSEMBLY NUMBER - FOUND ON YOUR TRANSMISSION NAMEPLATE

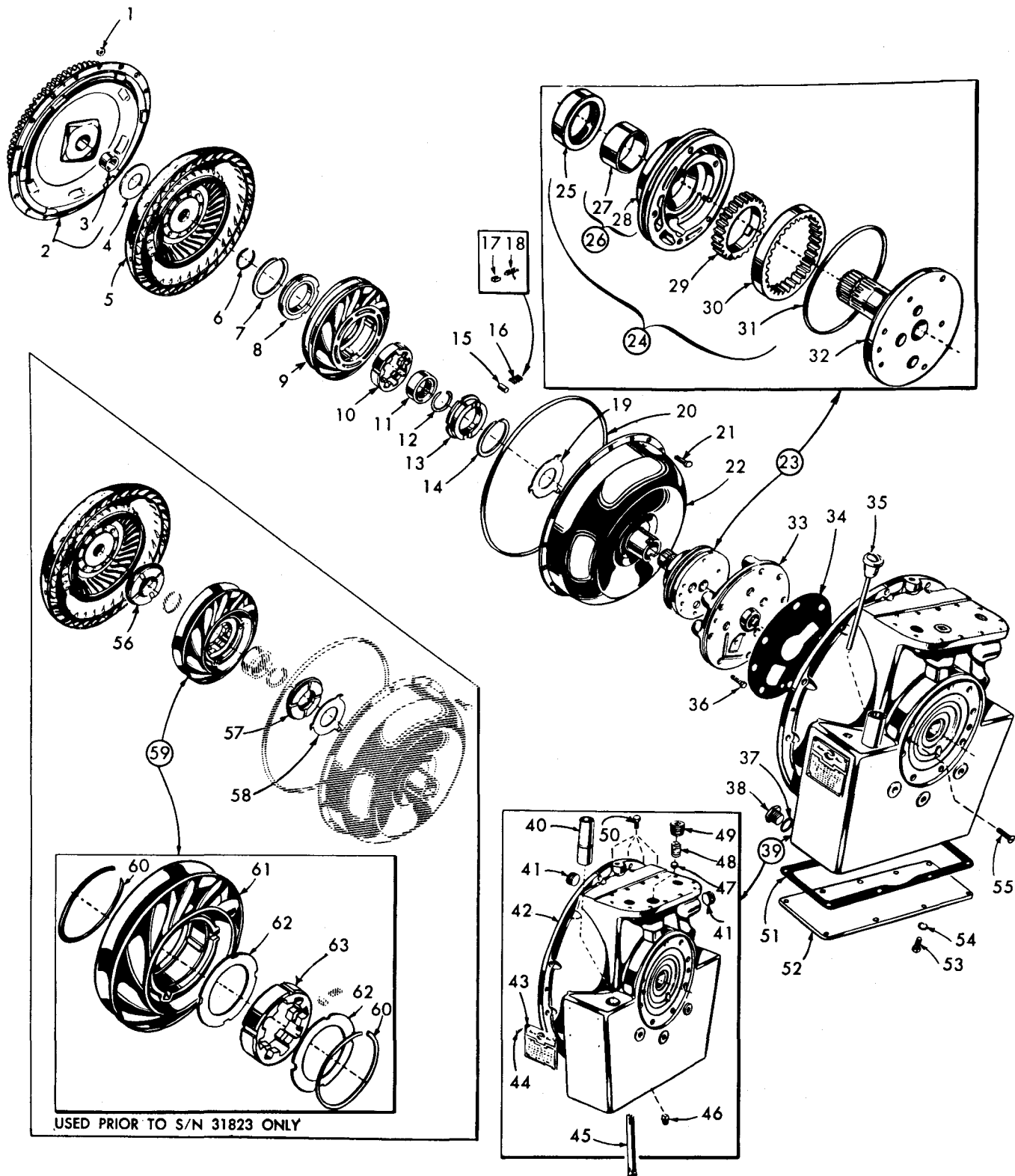


FIG. 1. TC-200 SERIES BASIC TORQMATIC CONVERTER

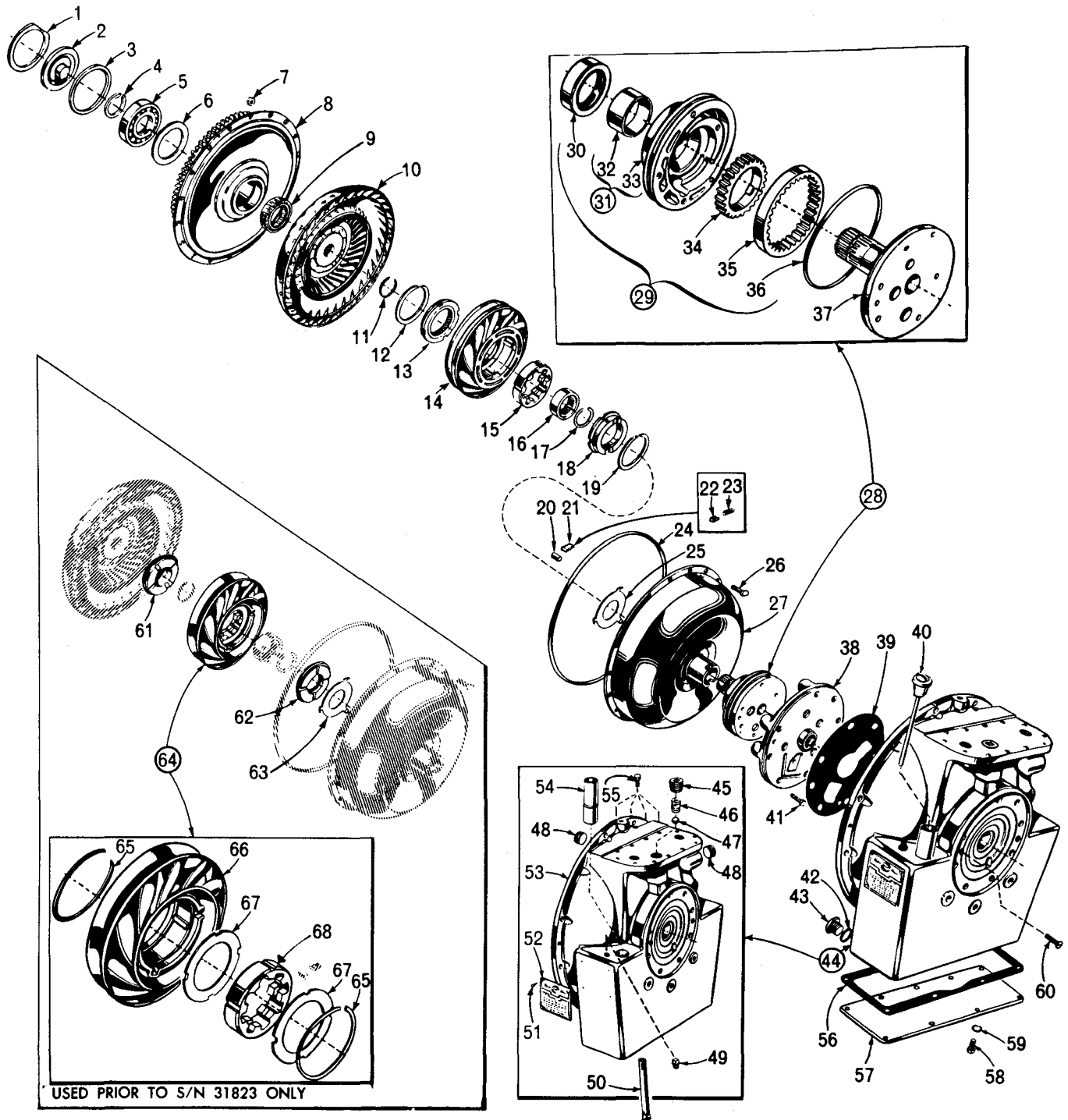


FIG. 1-1. TCO 200 SERIES BASIC TORQMATIC CONVERTER WITH OVERRUNNING CLUTCH

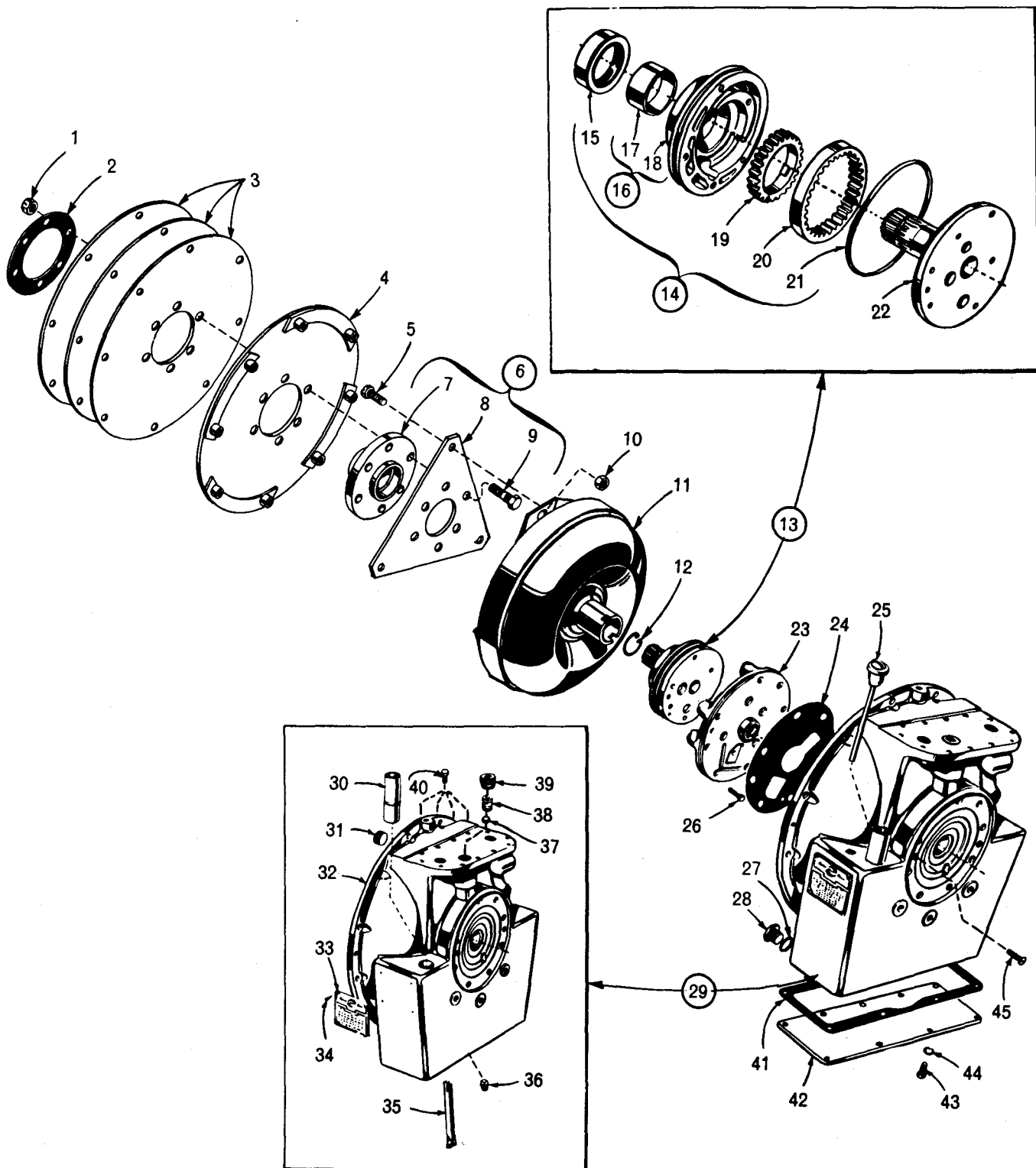


FIG. 1-2. TC 250 SERIES BASIC TORQMATIC CONVERTER

GROUP A

TC-200 SERIES BASIC TORQMATIC CONVERTER, FIGURE 1

REF NO	NOMENCLATURE	PART NO	REQ
1	NUT	451006	18
2	GEAR AND COVER ASSY	6755221	1
3	BUSHING	3790478	1
4	WASHER, TURBINE THRUST	3719262	1
5	TURBINE ASSY	3702724	1
6	RING, EXTERNAL, SNAP, 1 1/4 OD	6750046	1
7	RING, INTERNAL, SNAP, 3.45 ID	3702104	1
8	WASHER, THRUST, ALSO AVAILABLE IN STATOR KIT	3735785	1
	6774685		
9	STATOR ASSY, STATOR 3777395 AVAILABLE ONLY IN	3777395	1
	STATOR KIT 6774685 COMPOSED OF 1 3777395		
	STATOR, 1 3719260 CAM, 2 3702104		
	SNAP RING, 2 3735785 STATOR THRUST		
	WASHERS, 1 3702744 CONVERTER PUMP		
	THRUST WASHERS AND 1 6774686 INSTRUCTION		
	SHEET, SEE SPI 500		
10	CAM, STATOR FREEWHEEL, ALSO AVAILABLE IN STATOR	3719260	1
	KIT 6774685, SEE SPI 280		
11	RACE, FREEWHEEL ROLLER	6754958	1
12	RING, EXTERNAL, SNAP, 1 1/4 OD	6750046	1
13	WASHER, THRUST, ALSO AVAILABLE IN STATOR KIT	3735785	1
14	RING, INTERNAL, SNAP, 3.45 ID, ALSO AVAILABLE	3702104	1
	IN STATOR KIT 6774685		
15	ROLLER, STATOR FREEWHEEL, HY 10-S-016, SEE	3702101	8
	SPI 280		
16	SPRING, ROLLER, SEE SPI 280	3719261	8
17	GUIDE, ROLLER, USE PRIOR TO S/N 19439 ONLY,	3691806	8
	SEE SPI 280		
18	SPRING, ROLLER, USE PRIOR TO S/N 19439 ONLY,	3689751	8
	SEE SPI 280		
19	WASHER, CONVERTER PUMP THRUST, USE 6756629	3702744	1
	PRIOR TO S/N 31823. STARTING WITH S/N 31823		
	USE 3702744, ALSO AVAILABLE IN STATOR KIT		
	6774685, SEE SPI 500		
20	RING, SEAL, 12 ID X 0.139 DIA	3713622	1
21	BOLT, SPCL	3717166	18
22	PUMP ASSY, CONVERTER, TC 240 SERIES 2.0 TO 1	6756519	1
	STALL TORQUE RATIO		
23	PUMP ASSY, CHARGING OIL, USE 6755266 PRIOR TO	6773200	1
	S/N 31823. STARTING WITH S/N 31823 USE		
	6773200, SEE SPI 500		
24	GEAR AND BODY ASSY	6756644	1
25	SEAL, OIL	3772748	1
26	BODY ASSY, OIL PUMP	3744348	1
27	BUSHING	3702069	1
28	BODY, OIL PUMP	3744349	1
29	GEAR, CHARGING OIL PUMP DRIVE	3719252	1
30	GEAR, CHARGING OIL PUMP DRIVEN	3689760	1
31	RING, SEAL	3689826	1
32	SUPPORT, STATOR, GROUND SLEEVE, USE 6754964	6773199	1
	PRIOR TO S/N 31823. STARTING WITH S/N		
	31823 USE 6773199, SEE SPI 500		
33	ADAPTER, CHARGING OIL PUMP	6754968	1
34	GASKET	6756872	1
35	INDICATOR, OIL LEVEL	6755786	1
36	BOLT, HX HD, SELF-LOCKING, 1/4-20 X 1	9409062	5
37	GASKET, ANNULAR	105456	1
38	PLUG, DRAIN	6701230	1
39	HOUSING ASSY, CONVERTER, SEE SPI 136	6768955	1
40	SLEEVE, OIL FILLER	6755789	1
41	PLUG, SQ-SCKT HD, 3/4 NPT	444672	2
42	HOUSING, CONVERTER	6768942	1

CONTINUED ON NEXT PAGE

* SERVICED AS AN ASSY - NOT AS A DETAIL PART

GROUP A CONT

TC-200 SERIES BASIC TORQMATIC CONVERTER, FIGURE 1

REF NO	NOMENCLATURE	PART NO	REQ
43	PLATE, TORQMATIC CONVERTER NAME	6832907	1
44	SCREW, RND HD DRV, NO. 4 X 1/4	142862	4
45	TUBE, OIL COOLER RETURN	6756693	1
46	PLUG, PIPE, 1/4	444576	1
47	BALL	453621	1
48	SPRING	6757709	1
49	PLUG, SQ HD PIPE, 1	444678	1
50	BOLT, HX HD, 5/16-18 X 1/2, SEE SPI 196	179812	4
51	GASKET, SUMP PLATE	6754490	1
52	PLATE, SUMP	6754495	1
53	BOLT, HX HD, 5/16-18 X 7/8	179817	9
54	WASHER, LOCK, 5/16	103320	9
55	SCREW, FLAT 1/4-20 X 1 3/4	113998	2
56	WASHER, STATOR FRONT THRUST, USED PRIOR TO S/N 31823 ONLY, SEE SPI 500	3709094	1
57	WASHER, STATOR REAR THRUST, SEE SPI 127, USED PRIOR TO S/N 31823 ONLY, SEE SPI 500	6756233	1
58	WASHER, CONVERTER PUMP THRUST, USED PRIOR TO S/N 31823 ONLY, SEE SPI 500	6756629	1
59	STATOR ASSY, USED PRIOR TO S/N 31823 ONLY, WHEN REPLACING 6769234 STATOR ASSY OR 3796309 STATOR ORDER 6774685 STATOR KIT COMPOSED OF 1 3777395 STATOR, 1 3719260 CAM, 2 3702104 SNAPRING, 2 3735785 STATOR THRUST WASHERS, 1 3702744 CONVERTER PUMP THRUST WASHERS AND 1 6774686 INSTRUCTION SHEET, SEE SPI 500	6769234	1
60	RING, SNAP, ALSO AVAILABLE IN STATOR KIT 6774685, SEE SPI 500	3702104	2
61	STATOR, USED PRIOR TO S/N 31823 ONLY, WHEN REPLACING 6769234 STATOR ASSY OR 3796309 STATOR ORDER 6774685 STATOR KIT COMPOSED OF 1 3777395 STATOR, 1 3719260 CAM, 2 3702104 SNAPRING, 2 3735785 STATOR THRUST WASHERS, 1 3702744 CONVERTER PUMP THRUST WASHERS AND 1 6774686 INSTRUCTION SHEET, SEE SPI 500	3796309	1
62	WASHER, CAM THRUST, USED PRIOR TO S/N 31823 ONLY, SEE SPI 500	3702103	2
63	CAM, STATOR FREEWHEEL, ALSO AVAILABLE IN STATOR KIT 6774685	3719260	1

GROUP B

TC-200 SERIES BASIC TORQMATIC CONVERTER, FIGURE 1-1
OVERRUNNING CLUTCH

1	RING, INTERNAL SNAP, 3.361 OD	6759926	1
2	COVER, BEARING	6772312	1
3	RING, SQUARE SECTION SEAL, 3.107 ID	6759906	1
4	RING, EXTERNAL SNAP, 1.404 ID	6750127	1
5	BEARING ASSY, SINGLE ROW BALL, NO 3208XRIA	903208	1
6	RETAINER, SPRAG	6759927	1
7	NUT	451006	18
8	GEAR AND COVER ASSY	6759928	1
9	SPRAG ASSY	8618363	1
10	TURBINE ASSY	6759932	1
11	RING, EXTERNAL, SNAP, 1 1/4 OD	6750046	1
12	RING, SNAP, INTERNAL, 3.45 ID, ALSO AVAILABLE IN STATOR KIT 6774685	3702104	1

CONTINUED ON NEXT PAGE

GROUP B CONT

TC-200 SERIES BASIC TORQMATIC CONVERTER, FIGURE 1-1
OVERRUNNING CLUTCH

REF NO	NOMENCLATURE	PART NO	REQ
13	WASHER, THRUST, ALSO AVAILABLE IN STATOR KIT . . . 6774685	3735785	1
14	STATOR ASSY, STATOR 3777395 AVAILABLE ONLY IN . . STATOR KIT 6774685. COMPOSED OF 1 3777395 STATOR, 1 3719260 CAM, 2 3702104 SNAPRING, 2 3735785 STATOR THRUST WASHERS, 1 3702744 CONVERTER PUMP THRUST WASHERS AND 1 6774686 INSTRUCTION SHEET, SEE SPI 500	3777395	1
15	CAM, STATOR FREEWHEEL, ALSO AVAILABLE IN STATOR . KIT 6774685, SEE SPI 280	3719260	1
16	RACE, FREEWHEEL ROLLER	6754958	1
17	RING, EXTERNAL, SNAP, 1 1/4 OD	6750046	1
18	WASHER, THRUST	3735785	1
19	RING, INTERNAL, SNAP, 3.45 ID	3702104	1
20	ROLLER, STATOR FREEWHEEL, HY 10-S-016, SEE . . . SPI 280	3702101	8
21	SPRING, ROLLER, SEE SPI 280	3719261	8
22	GUIDE, ROLLER, USE PRIOR TO S/N 19439 ONLY . . .	3691806	8
23	SPRING, ROLLER, USE PRIOR TO S/N 19439 ONLY, . . SEE SPI 280	3689751	8
24	RING, SEAL, 12 ID X .139 DIA	3713622	1
25	WASHER, CONVERTER PUMP THRUST, ALSO AVAILABLE IN STATOR KIT 6774685	3702744	1
26	BOLT, SPCL	3717166	18
27	PUMP ASSY, CONVERTER, TC 240 SERIES 2.0 TO 1 . . STALL TORQUE RATIO	6756519	1
28	PUMP ASSY, CHARGING OIL, SEE SPI 500	6773200	1
29	GEAR AND BODY ASSY	6756644	1
30	SEAL, OIL	3772748	1
31	BODY ASSY, OIL PUMP	3744348 *	1
32	BUSHING	3702069	1
33	BODY, OIL PUMP	3744349 *	1
34	GEAR, CHARGING OIL PUMP DRV	3719252 *	1
35	GEAR, CHARGING OIL PUMP DRVN	3689760 *	1
36	RING, SEAL	3689826	1
37	SUPPORT, STATOR, GROUND SLEEVE	6773199	1
38	ADAPTER, CHARGING OIL PUMP	6754968	1
39	GASKET	6756872	1
40	INDICATOR, OIL LEVEL	6755786	1
41	BOLT, HX HD, SELF-LOCKING, 1/4-20 X 1	9409062	5
42	GASKET, ANNULAR	105456	1
43	PLUG, DRAIN	6701230	1
44	HOUSING ASSY, CONVERTER, SEE SPI 136	6768955	1
45	PLUG, SQ HD PIPE, 1	444678	1
46	SPRING	6757709	1
47	BALL	453621	1
48	PLUG, SQ-SCKT HD, 3/4 NPT	444672	2
49	PLUG, PIPE, 1/4	444576	1
50	TUBE, OIL COOLER RETURN	6756693	1
51	SCREW, RND HD DRV, NO. 4 X 1/4	142862	4
52	PLATE, TORQMATIC CONVERTER NAME	6832907	1
53	HOUSING, CONVERTER	6768942 *	1
54	SLEEVE, OIL FILLER	6755789	1
55	BOLT, HX HD, 5/16-18 X 1/2, SEE SPI 196	179812	4
56	GASKET, SUMP PLATE	6754490	1
57	PLATE, SUMP	6754495	1
58	BOLT, HX HD, 5/16-18 X 7/8	179817	9
59	WASHER, LOCK, 5/16	103320	9
60	SCREW, FLAT, 1/4-20 X 1 3/4	113998	2
61	WASHER, STATOR FRONT THRUST, USED PRIOR TO S/N . 31823 ONLY, SEE SPI 500	3709094	1

CONTINUED ON NEXT PAGE

* SERVICED AS AN ASSY - NOT AS A DETAIL PART

GROUP B CONT

TC-200 SERIES BASIC TORQMATIC CONVERTER, FIGURE 1-1
OVERRUNNING CLUTCH

REF NO	NOMENCLATURE	PART NO	REQ
62	WASHER, STATOR REAR THRUST, USED PRIOR TO S/N . . 31823 ONLY, SEE SPI 500	6756233	1
63	WASHER, CONVERTER PUMP THRUST, USED PRIOR TO . . S/N 31823 ONLY, SEE SPI 500	6756629	1
64	STATOR ASSY, USED PRIOR TO S/N 31823 ONLY, WHEN . REPLACING 6769234 STATOR ASSY OR 3796309 STATOR ORDER 6774685 STATOR KIT COMPOSED OF 1 3777395 STATOR, 1 3719260 CAM, 2 3702104 SNAP RING, 2 3735785 STATOR THRUST WASHERS, 1 3702744 CONVERTER PUMP THRUST WASHERS AND 1 6774686 INSTRUCTION SHEET, SEE SPI 500	6769234	1
65	RING, SNAP, ALSO AVAILABLE IN STATOR KIT . . . 6774685, SEE SPI 500	3702104	2
66	STATOR, USED PRIOR TO S/N 31823 ONLY, WHEN . . REPLACING 6769234 STATOR ASSY OR 3796309 STATOR ORDER 6774685 STATOR KIT COMPOSED OF 1 3777395 STATOR, 1 3719260 CAM, 2 3702104 SNAP RING, 2 3735785 STATOR THRUST WASHERS, 1 3702744 CONVERTER PUMP THRUST WASHERS AND 1 6774686 INSTRUCTION SHEET, SEE SPI 500	3796309	1
67	WASHER, CAM THRUST, USED PRIOR TO S/N 31823 ONLY, SEE SPI 500	3702103	2
68	CAM, STATOR FREEWHEEL, ALSO AVAILABLE IN STATOR KIT 6774685	3719260	1

GROUP C

TC-200 SERIES BASIC TORQMATIC CONVERTER, FIGURE 1-2

1	NUT, HX, LOCK, 1/2-20	117213	6
2	PLATE, FLEX DISK	6774012	1
3	DISK, FLEXIBLE	6777448	3
4	DISK AND WASHER ASSY, FLEXIBLE	6777449	1
5	BOLT, HX HD, 3/8-24 X 5/8	9409033	3
6	HUB ASSY, DRIVE	6777108	1
7	HUB, DRIVE	6777110	*
8	PLATE, DRIVE	6777109	*
9	BOLT, SPECIAL, 1/2-20-1.25	6777107	6
10	NUT, HEX, 3/8-24	103026	3
11	CONVERTER ASSY	6778111	1
12	RING, SNAP, EXTERNAL	6774105	1
13	PUMP ASSY, CHARGING OIL	6777106	1
14	GEAR AND BODY ASSY	6756644	1
15	SEAL, OIL	3772748	1
16	BODY ASSY, OIL PUMP	3744348	*
17	BUSHING	3702069	1
18	BODY, OIL PUMP	3744349	*
19	GEAR, CHARGING OIL PUMP DRIVE	3719252	*
20	GEAR, CHARGING OIL PUMP DRIVEN	3689760	*
21	RING, SEAL	3689826	1
22	SUPPORT, STATOR	6774104	1
23	ADAPTER, CHARGING OIL PUMP	6754968	1
24	GASKET, ADAPTER	6756872	1
25	INDICATOR, OIL LEVEL	6755786	1
26	BOLT, HX HD, SELF-LOCKING, 1/4-20 X 1	9409062	5
27	GASKET, ANNULAR	105456	1
28	PLUG, DRAIN	6701230	1

CONTINUED ON NEXT PAGE

* SERVICED AS AN ASSY - NOT AS A DETAIL PART

GROUP C CONT

TC-200 SERIES BASIC TORQMATIC CONVERTER, FIGURE 1-2

REF NO	NOMENCLATURE	PART NO	REQ
29	HOUSING ASSY, CONVERTER	6768955	1
30	SLEEVE, OIL FILLER	6755789	1
31	PLUG, SQ-SCKT HD, 3/4 NPT	444672	2
32	HOUSING, CONVERTER	6768942 *	1
33	PLATE, NAME	6832907	1
34	SCREW, RND HD DRV, NO. 4 X 1/4	142862	4
35	TUBE, OIL COOLER RETURN	6756693	1
36	PLUG, PIPE, 1/4	444576	1
37	BALL	453621	1
38	SPRING	6757709	1
39	PLUG, SQ HD, PIPE, 1	444678	1
40	BOLT, HX HD, 5/16-18 X 1/2, SEE SPI 196	179812	4
41	GASKET, SUMP PLATE	6754490	1
42	PLATE, SUMP	6754495	1
43	BOLT, HX HD, 5/16-18 X 7/8	179817	9
44	WASHER, LOCK, 5/16	103320	9
45	SCREW, FLAT, 1/4-20 X 1 3/4	113998	2

GROUP D

TC-200 SERIES BASIC TORQMATIC CONVERTER, FIGURE 1-2

SAME AS GROUP C, EXCEPT FOR PARTS LISTED BELOW.

6	HUB ASSY, DRIVE	6777884	1
7	HUB, DRIVE	6777885 *	1

* SERVICED AS AN ASSY - NOT AS A DETAIL PART

TC-200 SERIES BASIC TORQMATIC CONVERTER OUTPUT SHAFTS SECTION

TO FIND DETAIL PARTS FOR YOUR ALLISON TORQMATIC CONVERTER, TURN TO THE GROUP AND PAGE LISTED OPPOSITE THE ASSEMBLY PART NUMBER OF YOUR CONVERTER.

A/N*	MODEL	GROUP	A/N*	MODEL	GROUP
6755291	TC 244	A	6771706	TCOA 245	N
6755292	TC 245	B	6772099	TCOA 247	H
6755386	TCA 245	E	6772102	TCOA 248	K
6755387	TCRD 246	D	6772207	TCOA 248	F
6756320	TCA 248	F	6777207	TCA 258	K
6756733	TC 248	C	6777208	TCRD 256	J
6756751	TCA 247	H	6777209	TCA 258	F
6757848	TC 248	C	6777466	TCA 258	F
6757850	TC 244	G	6777589	TC 254	A
6758071	TCA 248	K	6777669	TC 255	B
6758320	TCA 248	M	6777823	TCA 257	L
6758586	TCRD 246	J	6779094	TC 254	G
6770518	TCO 245	G	6779463	TC 248	C
6772037	TCA 247	L	6779957	TCRD 259	P
6771200	TCOA 245	E	6832246	TC 256	Q
6771244	TCOA 247	L	6832987	TC 258	C

* A/N* - ASSEMBLY NUMBER - FOUND ON YOUR TRANSMISSION NAMEPLATE

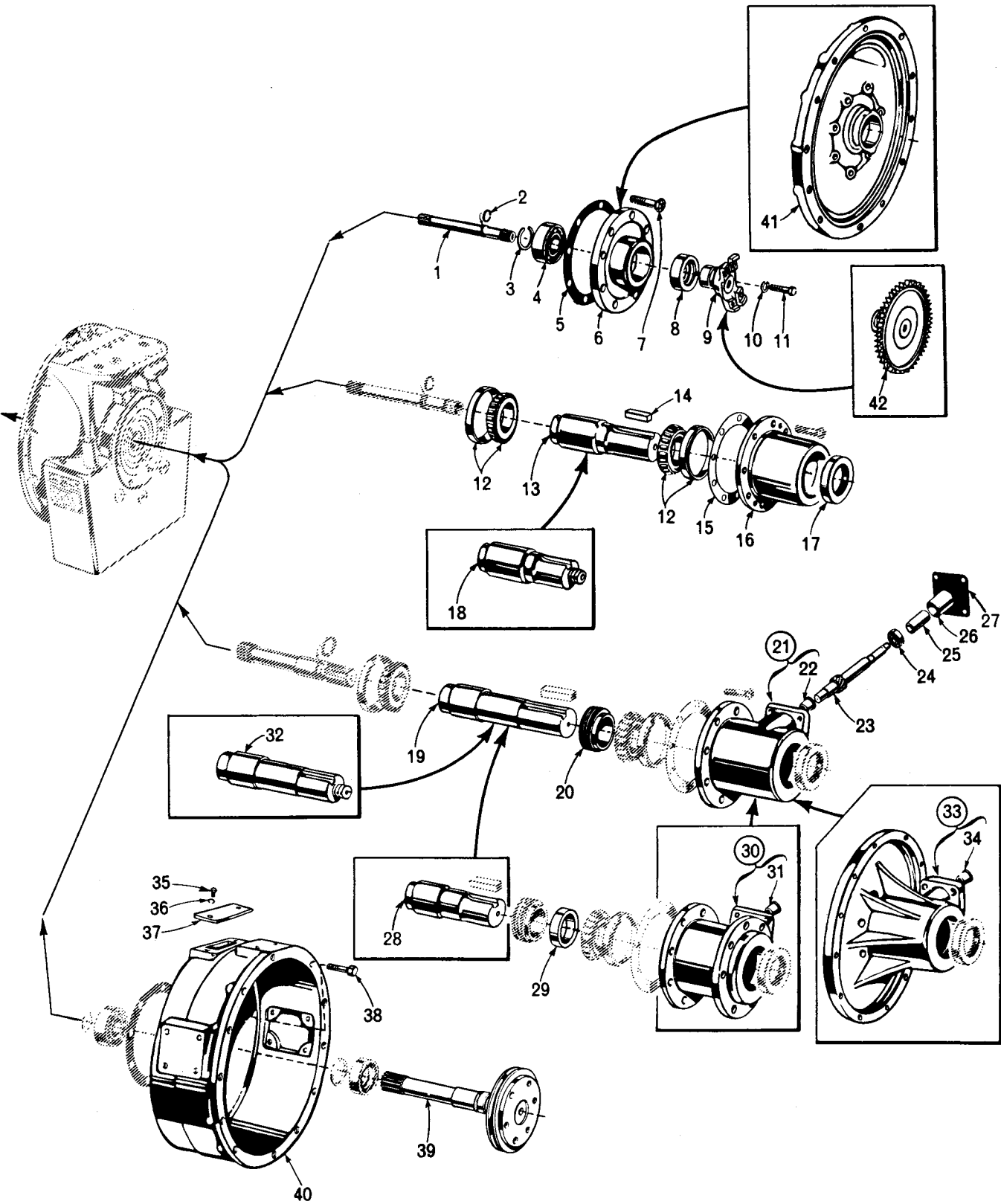


FIG. 2. TC 200 SERIES BASIC TORQMATIC CONVERTER OUTPUT SHAFTS

GROUP A

TC-200 SERIES OUTPUT SHAFT, AUTOMOTIVE, FIGURE 2

REF NO	NOMENCLATURE	PART NO	REQ
1	SHAFT, TURBINE	6754962	1
2	RING, HOOK TYPE SEAL	3689838	1
3	RING, EXTRNL SNAP, 1.250 ID	6750046	1
4	BEARING ASSY, SINGLE ROW BALL, ND3307L1214A	907050	1
5	GASKET, BRNG RTNR	6753966	1
6	RETAINER, BRNG	6755302	1
7	BOLT, HX HD, SELF-LOCKING, 1/2-13 X 2 1/2	9409055	8
8	SEAL, OIL, 2.750 X 1.750 ID X .50 THICK	6773249	1
9	FLANGE ASSY, M4C	6754963	1
10	WASHER, LOCK, 1/2	103323	1
11	BOLT, HX HD, 1/2-20 X 1 1/4	181429	1
12-42	NOT USED IN THIS GROUP.		

GROUP B

TC-200 SERIES OUTPUT SHAFT, INDUSTRIAL, FIGURE 2

SAME AS GROUP A, EXCEPT FOR PARTS LISTED BELOW.

1	SHAFT, TURBINE	6759462	1
3-6	NOT USED IN THIS GROUP.		
8-11	NOT USED IN THIS GROUP.		
12	BEARING ASSY, TAPERED ROLLER, TIMKEN 397-394 RS.	9422228	2
13	SHAFT ASSY, CONVERTER OUTPUT	6755032	1
14	KEY, 5/8 X 5/8 X 3	6751531	1
15	SHIM, BRNG HSNG, .003	6778856	AR
15	SHIM, BRNG HSNG, .010	6778857	AR
16	HOUSING, BRNG	6754508	1
17	SEAL, OIL, 3.378 OD X 2.35 ID X .483 WIDE	6754506	1
18-42	NOT USED IN THIS GROUP.		

GROUP C

TC-200 SERIES OUTPUT, SHAFT, INDUSTRIAL, BEVEL PINION MOUNTING, FIGURE 2

SAME AS GROUP B, EXCEPT FOR PARTS LISTED BELOW.

13-14	NOT USED IN THIS GROUP.		
18	SHAFT ASSY, CONVERTER OUTPUT	6756856	1

GROUP D

TC-200 SERIES OUTPUT SHAFT, INDUSTRIAL, SAE. NO. 3 REAR DISCONNECT CLUTCH, FIGURE 2

SAME AS GROUP A, EXCEPT FOR PARTS LISTED BELOW.

1	NOT USED IN THIS GROUP.		
4	BEARING ASSY, SINGLE ROW BALL, ND 3307X1A	903307	1
6-7	NOT USED IN THIS GROUP.		
9-34	NOT USED IN THIS GROUP.		
35	BOLT, HX HD, 3/8-16 X 3/4	179837	2
36	WASHER, LOCK, 3/8	103321	2
37	SHIELD, DUST	6757426	1
38	BOLT, HX HD, SELF-LOCKING, 1/2-13 X 2 3/4	9409203	8
39	SHAFT, TURBINE	6755469	1
40	HOUSING, SAE NO. 3 REAR DISCONNECT CLUTCH	6754349	1

GROUP E

TC-200 SERIES OUTPUT SHAFT, INDUSTRIAL SHAFT WITH ACCESSORY DRIVE, FIGURE 2

SAME AS GROUP B, EXCEPT FOR PARTS LISTED BELOW.

REF NO	NOMENCLATURE	PART NO	REQ
13	NOT USED IN THIS GROUP.		
16	NOT USED IN THIS GROUP.		
18	NOT USED IN THIS GROUP.		
19	SHAFT ASSY, CONVERTER OUTPUT	6755383	1
20	GEAR, ACCESSORY DRV, 2.5 TO 1	6755619	1
21	HOUSING ASSY, BRNG	6755377	1
22	BUSHING	2222424	1
23	GEAR, ACCESSORY DRVN, 2.5 TO 1	6755618	1
24	BEARING ASSY, SINGLE ROW BALL, ND 3202NR1214A . .	907411	1
25	SLEEVE, ACCESSORY DRV	3224085	1
26	SPACER, 1.38 OD X .06 WALL X 2.16	6751524	1
27	GASKET	3224773	1

GROUP F

TC-200 SERIES OUTPUT SHAFT
INDUSTRIAL SHAFT WITH ACCESSORY DRIVE AND BEVEL PINION MOUNTING, FIGURE 2

SAME AS GROUP E, EXCEPT FOR PARTS LISTED BELOW.

7	BOLT, HX HD, 1/2-13 X 2 3/4	9409203	8
14	NOT USED IN THIS GROUP.		
19	NOT USED IN THIS GROUP.		
21-22	NOT USED IN THIS GROUP.		
28-31	NOT USED IN THIS GROUP.		
32	SHAFT ASSY, CONVERTER OUTPUT	6756321	1
33	HOUSING ASSY, BRNG	6757521	1
34	BUSHING	2222424	1

GROUP G

TC-200 SERIES OUTPUT SHAFT, INDUSTRIAL, COUPLING, FIGURE 2

SAME AS GROUP A, EXCEPT FOR PARTS LISTED BELOW.

6	NOT USED IN THIS GROUP.		
7	BOLT, HX HD, 1/2-13 X 3	9409240	8
9	NOT USED IN THIS GROUP.		
41	RETAINER, BRNG	6757737	1
42	COUPLING, OUTPUT DRV	6757757	1

GROUP H

TC-200 SERIES OUTPUT SHAFT
INDUSTRIAL SHAFT WITH EXTRA DUTY BEARINGS AND ACCESSORY DRIVE, FIGURE 2

SAME AS GROUP E, EXCEPT FOR PARTS LISTED BELOW.

7	BOLT, HX HD, SELF-LOCKING, 1/2-13 X 2 3/4	9409203	8
12	BEARING ASSY, TAPERED ROLLER, TIMKEN 558S-553X. .	456635	2
18-19	NOT USED IN THIS GROUP.		
21-22	NOT USED IN THIS GROUP.		
28	SHAFT ASSY, CONVERTER OUTPUT	6758295	1
29	SPACER, CONVERTER OUTPUT SHAFT	6756689	1
30	HOUSING ASSY, BRNG	6756706	1
31	BUSHING	2222424	1

GROUP J

TC-200 SERIES OUTPUT SHAFT, INDUSTRIAL, SAE NO. 3 REAR DISCONNECT CLUTCH HOUSING, FIGURE 2

SAME AS GROUP D, EXCEPT FOR PARTS LISTED BELOW.

REF NO	NOMENCLATURE	PART NO	REQ
4	BEARING ASSY, SINGLE ROW BALL, ND 3307L1214A. . .	907050	1
39	SHAFT, TURBINE, ALSO ORDER BEARING 907050 WHEN . REPLACING SHAFT 6758592, SEE SPI 499	6772735	1

GROUP K

TC-200 SERIES OUTPUT SHAFT, INDUSTRIAL SHAFT WITH ACCESSORY DRIVE, FIGURE 2

SAME AS GROUP E, EXCEPT FOR PARTS LISTED BELOW.

19	SHAFT ASSY, CONVERTER OUTPUT	6758124	1
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GROUP L

TC-200 SERIES OUTPUT SHAFT, INDUSTRIAL, FIGURE 2

SAME AS GROUP H, EXCEPT FOR PARTS LISTED BELOW.

18	NOT USED IN THIS GROUP.		
19	SHAFT ASSY, CONVERTER OUTPUT	6769908	1
20	GEAR, ACCESSORY DRV, 1.69 TO 1	6768426	1
23	GEAR, ACCESSORY DRVN, 1.69 TO 1	6768425	1
28	NOT USED IN THIS GROUP.		

GROUP M

TC-200 SERIES OUTPUT SHAFT
INDUSTRIAL SHAFT WITH ACCESSORY DRIVE AND BEVEL PINION MOUNTING, FIGURE 2

SAME AS GROUP E, EXCEPT FOR PARTS LISTED BELOW.

7	BOLT, HX HD, 1/2-13 X 2 1/2	9409055	8
33-34	NOT USED IN THIS GROUP.		

GROUP N

TC-200 SERIES OUTPUT SHAFT
INDUSTRIAL SHAFT WITH ACCESSORY DRIVE, FIGURE 2

SAME AS GROUP E, EXCEPT FOR PARTS LISTED BELOW.

19	SHAFT ASSY, CONVERTER OUTPUT	6772786	1
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GROUP P

TC-200 SERIES OUTPUT SHAFT, INDUSTRIAL
SAE NO. 2 REAR DISCONNECT CLUTCH HOUSING, FIGURE 2

SAME AS GROUP D, EXCEPT FOR PARTS LISTED BELOW.

4	BEARING ASSY, SINGLE ROW BALL, ND 3307L1214A . .	907050	1
39	SHAFT, TURBINE	6772735	1
40	HOUSING, SAE NO. 2 REAR DISCONNECT CLUTCH	6756913	1

GROUP Q

TC-200 SERIES OUTPUT SHAFT, INDUSTRIAL, FIGURE 2

SAME AS GROUP A, EXCEPT FOR PARTS LISTED BELOW

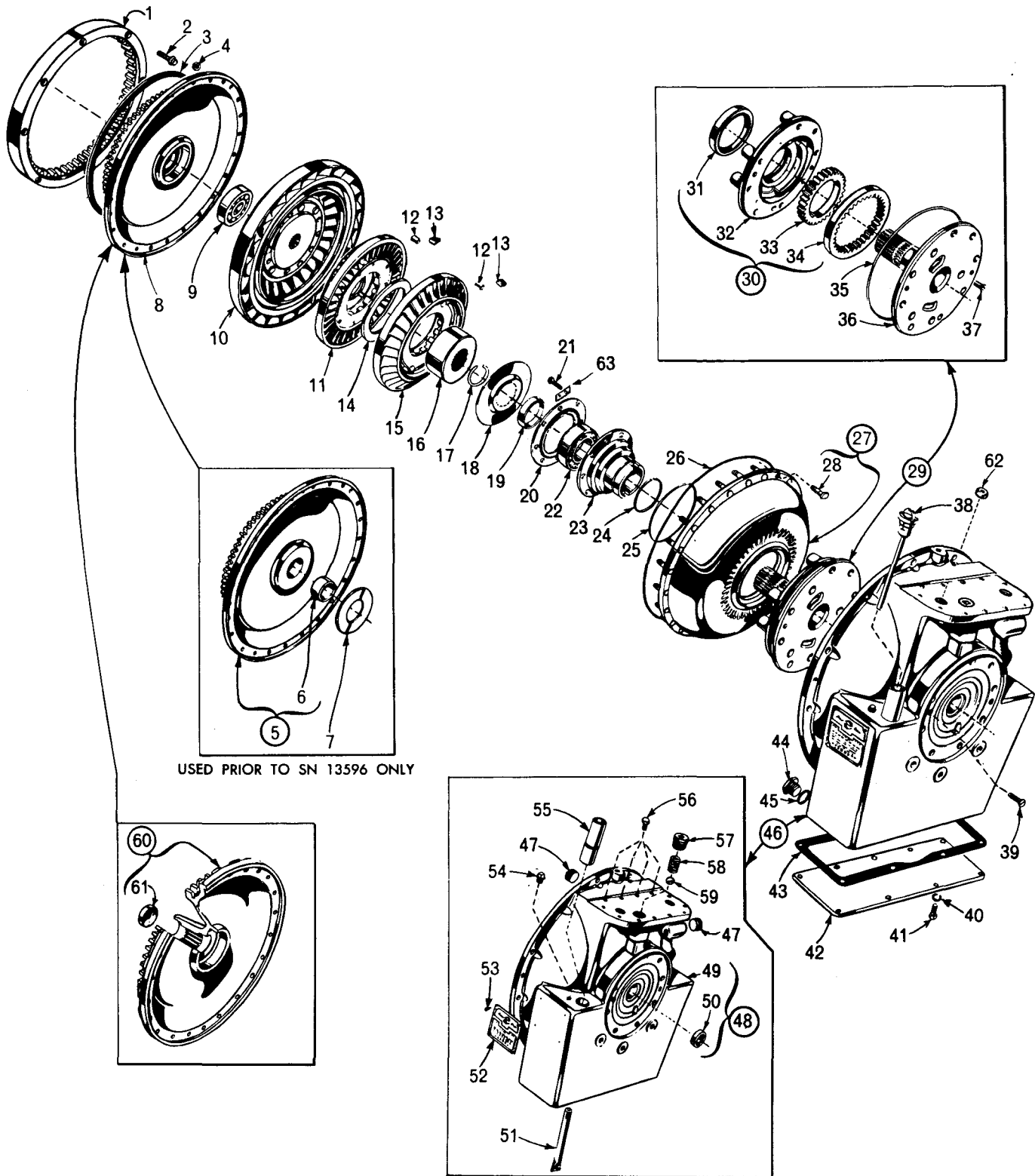
REF NO	NOMENCLATURE	PART NO	REQ
1	NOT USED IN THIS GROUP		
6	NOT USED IN THIS GROUP		
7	BOLT, HEX HD, 1/2-13 X 3	9409240	8
9-11	NOT USED IN THIS GROUP		
39	SHAFT, TURBINE	6772735	1
41	RETAINER, BEARING	6757737	1

TC-300 SERIES BASIC TORQMATIC CONVERTER SECTION

TO FIND DETAIL PARTS FOR YOUR ALLISON TORQMATIC CONVERTER, TURN TO THE GROUP AND PAGE LISTED OPPOSITE THE ASSEMBLY PART NUMBER OF YOUR CONVERTER.

A/N*	MODEL	GROUP	A/N*	MODEL	GROUP
6755060	TC 324	A	6769968	TCA 378	C
6755061	TC 325	A	6769969	TC 378	C
6755062	TCRD 326	A	6769970	TC 327	A
6755390	TCA 325	A	6769971	TC 324	A
6755395	TC 374	C	6769973	TC 376	B
6755396	TC 375	C	6769974	TC 374	C
6755397	TCA 375	C	6770285	TC 337	D
6755398	TCRD 376	C	6770730	TC 335	D
6756752	TC 327	A	6772298	TCOA 377	E
6756753	TCA 327	A	6772535	TCOA 377	E
6756754	TC 377	C	6772882	TCOA 327	F
6756755	TCA 377	C	6774265	TC 374	G
6756789	TCA 378	C	6774295	TC 376	H
6756914	TCRD 329	A	6774942	TCRD 356	L
6756937	TCRD 379	C	6774943	TC 374	M
6757844	TCRD 379	C	6774944	TC 375	M
6757846	TC 374	C	6774945	TCRD 376	M
6757847	TC 378	C	6774946	TCA 377	M
6758048	TCA 328	A	6774947	TCRD 379	M
6759137	TCA 378	C	6774948	TC 378	M
6759598	TCA 377	C	6774949	TC 354	L
6759643	TC 376	B	6774950	TC 374	M
6759657	TC 324	A	6774951	TCOA 377	N
6759658	TC 325	A	6774952	TCOA 377	N
6759659	TC 327	A	6774953	TCOA 357	P
6759660	TCA 327	A	6774954	TC 374	Q
6759661	TCA 325	A	6774955	TC 376	R
6759663	TCA 378	C	6776068	TCOA 327	F
6759664	TCRD 326	A	6777113	TCRD 379	C
6759666	TC 374	C	6777769	TC 355	L
6759667	TC 374	C	6778166	TC 377	M
6759668	TC 375	C	6778167	TCRD 359	S
6759669	TC 377	C	6778205	TC 357	L
6759672	TCA 377	C	6778373	TCORD 379	N
6759674	TCRD 376	C	6778889	TCA 377	M
6759676	TCRD 379	C	6778966	TCA 377	M
6759677	TCA 377	C	6779069	TCOA 377	N
6759706	TCA 377	C	6779796	TCA 375	M
6759730	TC 378	C	6777113	TCRD 379	C
6759741	TC 328	A	6778206	TCA 357	L
6759759	TCRD 329	A	6831011	TCORD 356	P
6759767	TCA 377	C	6832081	TCRD 379	M
6769539	TCA 327	A	6832682	TCA 358	L
6769873	TC 328	A	6832883	TCOA 357	P
6769874	TCA 327	A	6833593	TC 355	S
6769943	TCA 377	C	6833671	TC 374	S

* A/N* - ASSEMBLY NUMBER - FOUND ON YOUR TRANSMISSION NAMEPLATE



USED PRIOR TO SN 13596 ONLY

FIG. 3. TC 300 SERIES BASIC TORQMATIC CONVERTER

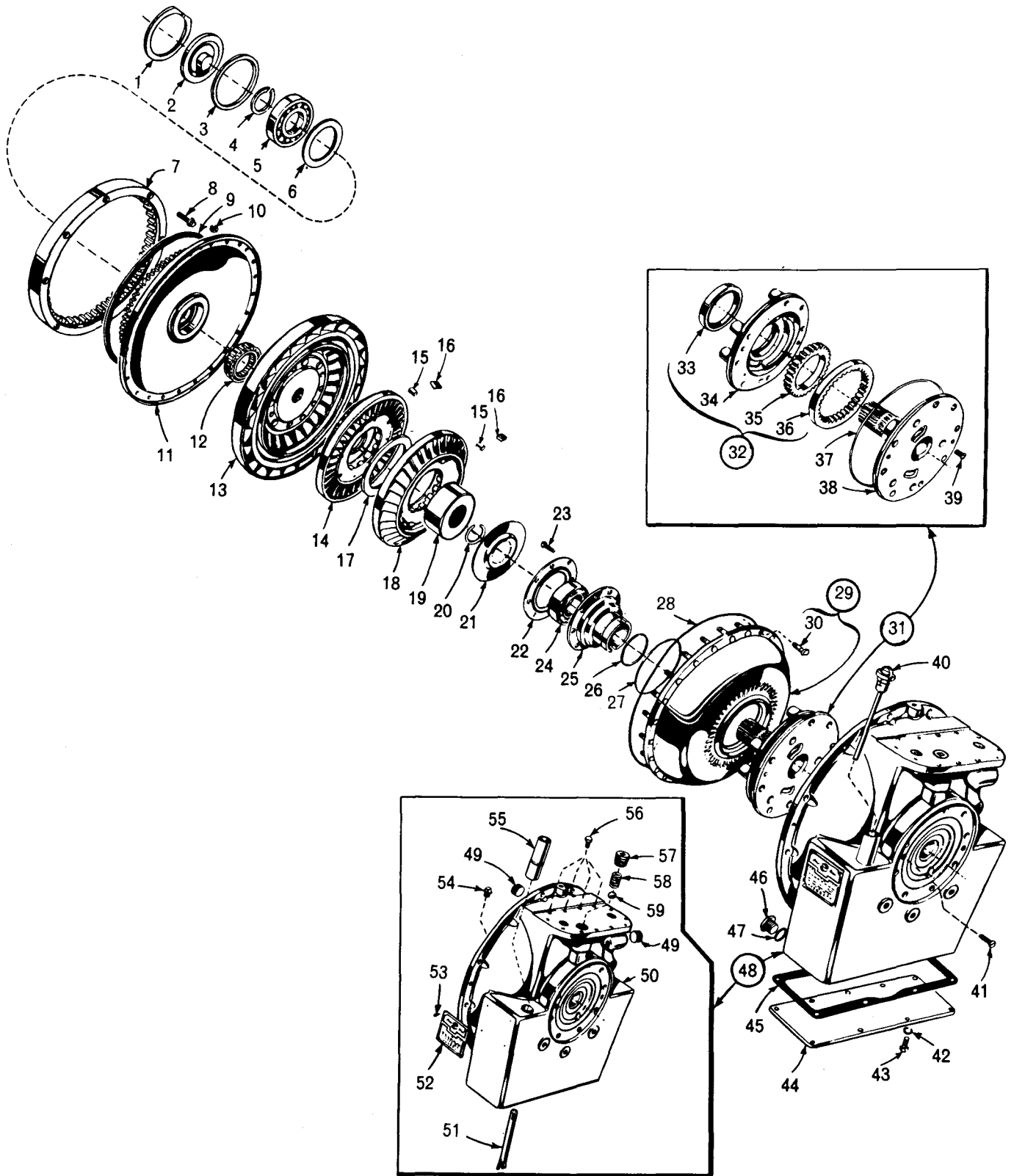


FIG. 3-1. TC 300 SERIES BASIC TORQMATIC CONVERTER, WITH OVERRUNNING CLUTCH

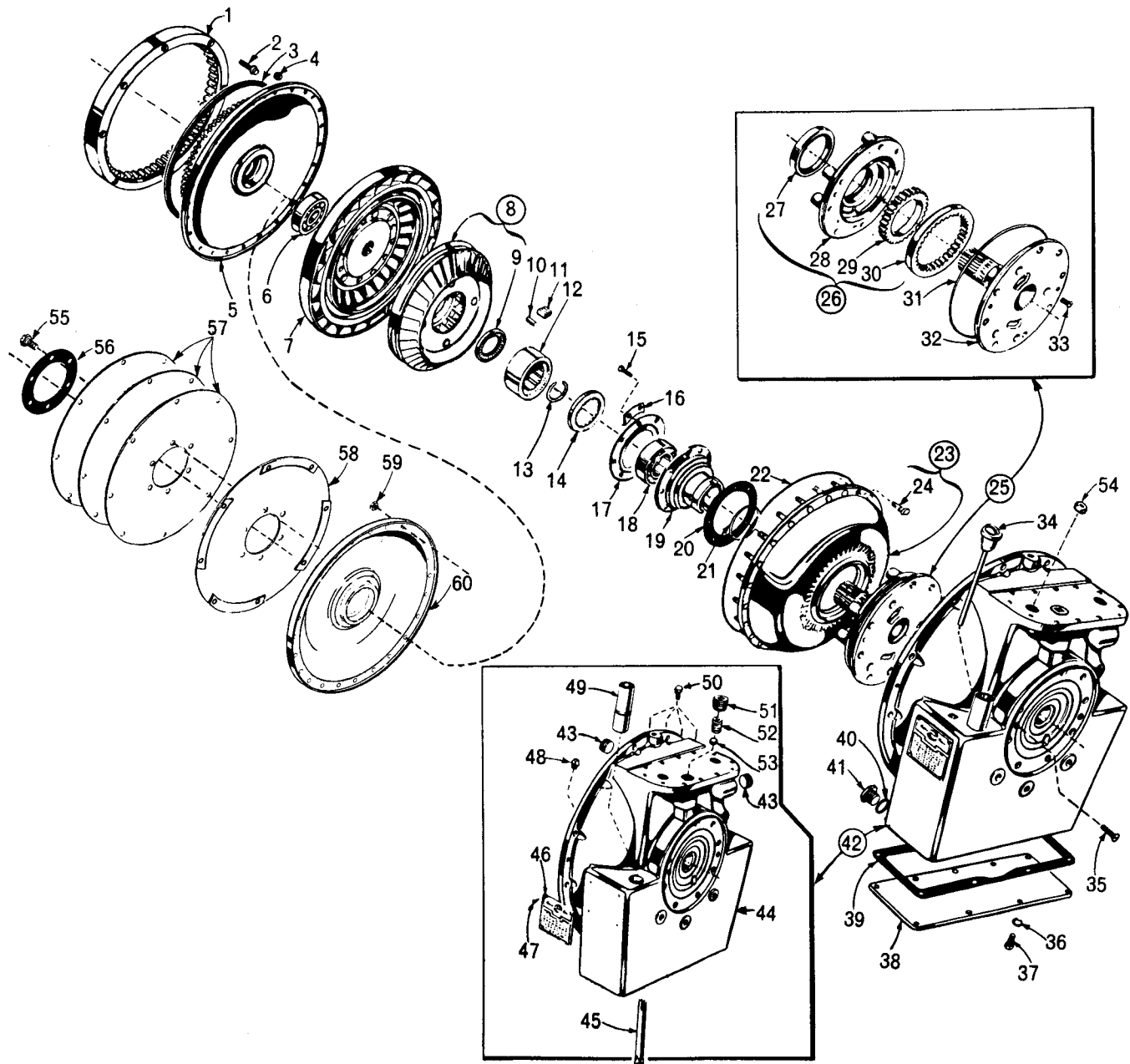


FIG. 3-2. TC 300 SERIES BASIC TORQMATIC CONVERTER

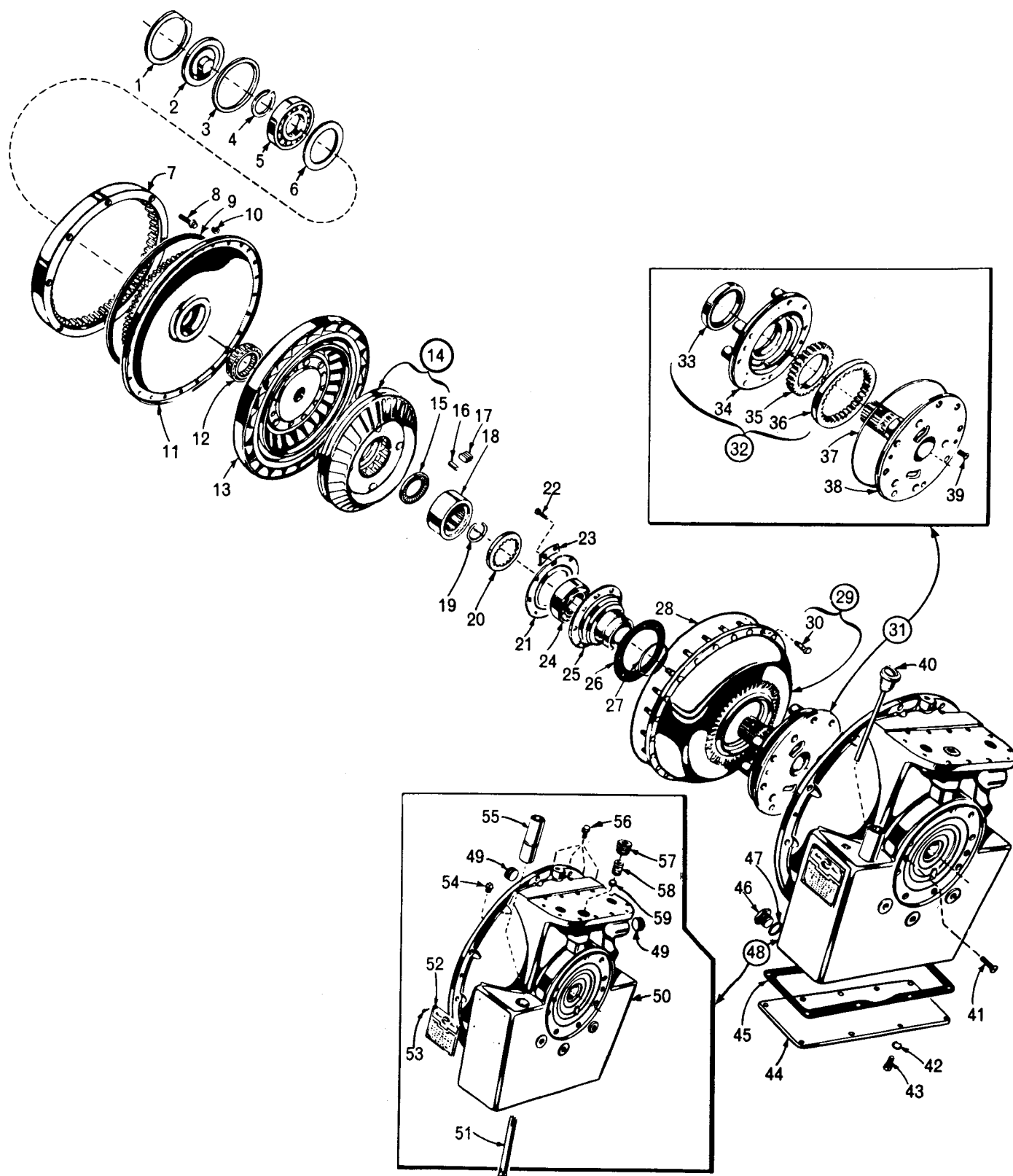


FIG. 3-3. TC 300 SERIES BASIC TORQMATIC CONVERTER, WITH OVERRUNNING CLUTCH

GROUP A

TC-300 SERIES BASIC TORQMATIC CONVERTER, FIGURE 3

REF NO	NOMENCLATURE	PART NO	REQ
1	GEAR, RING, SEE SPI 351	6775414	1
2	BOLT, SPCL HEAD, 3/8-16 X 1 1/4, SEE SPI 351 . .	9412270	8
3	RING, SEAL, SEE SPI 351	6769818	1
4	NUT, HX LOCK, 5/16-24	451006	24
5	COVER ASSY, CONVERTER PUMP, USE PRIOR TO	6755325	1
	S/N 13596, SEE SPI 224		
6	BUSHING, USE PRIOR TO S/N 13596, SEE	6754922	1
	SPI 224		
7	WASHER, TURBINE THRUST, USE PRIOR TO S/N	6755004	1
	13596, SEE SPI 224		
8	COVER, CONVERTER PUMP, USE 6772408 COVER	6772408	1
	STARTING WITH S/N 13596, SEE SPI 224		
9	BEARING ASSY, SINGLE ROW BALL, ND 3208, USE . . .	903208	1
	903208 BEARING STARTING WITH S/N 13596		
10	TURBINE ASSY, PRIOR TO S/N 13596 USE TURBINE . .	6769453	1
	6755467		
11	STATOR ASSY, FIRST	6768903	1
12	ROLLER, STATOR FREEWHEEL	7450737	16
13	SPRING, FREEWHEEL ROLLER	6771296	16
14	WASHER, SPACER, 4.62 OD X 3.5 ID X .22 WIDE . .	6754994	1
15	STATOR ASSY, SECOND	6768902	1
16	RACE, FREEWHEEL ROLLER	6755892	1
17	RING, EXTERNAL SNAP, 1.61 ID	6755897	1
18	SPACER, FREEWHEEL ROLLER RACE	6769856	1
19	SPACER, 2.00 OD X 1.81 ID X 0.493 WIDE, USED . .	6755896	1
	ONLY ON TRNS PRIOR TO S/N 7144		
20	RETAINER, BRNG	6757634	1
21	BOLT, HX HD, SELF-LOCKING, 1/4-20 X 3/4 CLS 2 . .	9409088	8
22	BEARING ASSY, DOUBLE ROW BALL, MRC 52209 K-1 . .	9417910	1
23	HUB, CONVERTER PUMP, SEE SPI 292	6768714	1
24	RING, HOOK TYPE SEAL, 2.906 DIA	6754488	1
25	RING, SEAL	6758296	1
26	RING, SEAL	6753866	1
27	PUMP ASSY, CONVERTER, TC 320 SERIES 3.5 TO 1 . .	6756847	1
	STALL TORQUE RATIO		
28	BOLT, SPCL, 5/16-24 X 1.30	6755988	24
29	PUMP ASSY, CHARGING OIL, USE 6757621 PRIOR TO . .	6768707	1
	S/N 19085, SEE SPI 292		
30	GEAR AND BODY ASSY, USE 6757086 PRIOR TO . . .	6768706	1
	S/N 19085, SEE SPI 292		
31	SEAL, 3.00 ID	6769816	1
32	BODY, OIL PUMP, USE 6768349 PRIOR TO . . .	6768704 *	1
	S/N 19085, SEE SPI 292		
33	GEAR, OIL PUMP DRV	6768351 *	1
34	GEAR, OIL PUMP DRVN	6768350 *	1
35	RING, SEAL, 8.00 ID X 1/8 DIA	6702958	1
36	SLEEVE, CONVERTER GROUND	6769530	1
37	SCREW, FLAT HD, SLOTTED, 1/4-20 X 5/8	113989	3
38	INDICATOR, OIL LEVEL	6755786	1
39	SCREW, FLAT HD, 1/4-20 X 1 3/4	113998	2
40	WASHER, LOCK, 5/16	103320	9
41	BOLT, HX HD, 5/16-18 X 7/8 CLS 2	179817	9
42	PLATE, SUMP	6754495	1
43	GASKET, SUMP PLATE	6754490	1
44	PLUG, DRAIN	6701230	1
45	GASKET, ANNULAR	105456	1
46	HOUSING ASSY, CONVERTER, SEE SPI 136	6768956	1
47	PLUG, SQ SCKT HD, 3/4 NPT	444672	2
48	NOT USED IN THIS GROUP.		
49	HOUSING, CONVERTER	6768942 *	1
50	NOT USED IN THIS GROUP.		
51	TUBE, OIL COOLER RETURN	6756693	1

CONTINUED ON NEXT PAGE

* SERVICED AS AN ASSY - NOT AS A DETAIL PART

GROUP A CONT

TC-300 SERIES BASIC TORQMATIC CONVERTER, FIGURE 3

REF NO	NOMENCLATURE	PART NO	REQ
52	PLATE, TORQMATIC CONVERTER NAME	6832907	1
53	SCREW, RND HD DRV, NO. 4 X 1/4	142862	4
54	PLUG, PIPE, 1/4	444576	1
55	SLEEVE, OIL FILLER	6755789	1
56	BOLT, HX HD, 5/16-18 X 1/2, SEE SPI 196	179812	4
57	PLUG, SQ SCKT HD, PIPE, 1	444678	1
58	SPRING, TWO END COILS ARE WHITE	6758597	1
59	BALL	453621	1
60-63	NOT USED IN THIS GROUP.		

GROUP B

TC-300 SERIES BASIC TORQMATIC CONVERTER, FIGURE 3

SAME AS GROUP A, EXCEPT FOR PARTS LISTED BELOW.

5-8	NOT USED IN THIS GROUP.		
9	BEARING ASSY, SINGLE ROW BALL, NO 3L11X1A	903011	1
10	TURBINE ASSY	6769060	1
11	STATOR ASSY, FIRST	6769105	1
16	RACE, FREEWHEEL ROLLER	6769048	1
17	RING, EXTERNAL SNAP	6758777	1
18	SPACER, FREEWHEEL ROLLER RACE	6769045	1
19	NOT USED IN THIS GROUP.		
20	NOT USED IN THIS GROUP.		
21	BOLT, HX HD, 1/4-20 X 5/8	179793	8
22	BEARING, SINGLE ROW BALL, NO 20212NO.1A	954466	1
23	HUB, CONVERTER PUMP	6769062	1
27	PUMP ASSY, CONVERTER, FOR TC 370 SERIES	6756001	1
	2.5 TO 1 STALL TORQUE RATIO		
29	PUMP ASSY, CHARGING OIL	6769061	1
36	SLEEVE	6769055	1
38	INDICATOR, OIL LEVEL, 16 IN. LENGTH,	6769621	1
	STARTING WITH S/N 22308 AND LATER USE		
	SLEEVE 6769622 WITH INDICATOR 6769621		
38	INDICATOR, OIL LEVEL, 15 IN. LENGTH,	6769090	1
	PRIOR TO S/N 22308 ONLY, USE 6769090		
	INDICATOR WITH 6769089 SLEEVE		
46	HOUSING ASSY, CONVERTER	6769623	1
48	HOUSING ASSY, CONVERTER	6769073	1
49	HOUSING, CONVERTER	6769054	1
50	SLEEVE, CONVERTER HOUSING	6769052	1
55	SLEEVE, OIL FILLER, PRIOR TO S/N 22308 USE	6769622	1
	SLEEVE 6769089 WITH INDICATOR 6769090,		
	STARTING WITH S/N 22308 AND LATER, USE		
	SLEEVE 6769622 WITH INDICATOR 6769621		
60	COVER ASSY, CONVERTER PUMP	6769849	1
61	PLUG	6774572	1
63	LOCKSTRIP	6769053	4

GROUP C

TC-300 SERIES BASIC TORQMATIC CONVERTER, FIGURE 3

SAME AS GROUP A, EXCEPT FOR PARTS LISTED BELOW.

27	PUMP ASSY, CONVERTER, FOR TC 370 SERIES	6756001	1
	2.5 TO 1 STALL TORQUE RATIO		

* SERVICED AS AN ASSY - NOT AS A DETAIL PART

GROUP D

TC-300 SERIES BASIC TORQMATIC CONVERTER, FIGURE 3

SAME AS GROUP A, EXCEPT FOR PARTS LISTED BELOW.

REF NO	NOMENCLATURE	PART NO	REQ
11	STATOR ASSY, FIRST	6768727	1

GROUP E

TC-300 SERIES BASIC TORQMATIC CONVERTER, FIGURE 3-1
OVERRUNNING CLUTCH

1	RING, INTERNAL SNAP, 3.361 OD	6759926	1
2	COVER, BEARING	6772312	1
3	RING, SQUARE SECTION SEAL, 3.107 ID	6759906	1
4	RING, EXTERNAL SNAP	6702989	1
5	BEARING ASSY, SINGLE ROW BALL, ND 3L10X1A	903010	1
6	RETAINER, SPRAG	6772309	1
7	GEAR, RING	6775414	1
8	BOLT, SPCL HD, 3/8-16 X 1 1/4, SEE SPI 351	9412270	8
9	RING, SEAL, SEE SPI 351	6769818	1
10	NUT, HX LOCK, 5/16-24	451006	24
11	COVER, CONVERTER PUMP	6772301	1
12	SPRAG ASSY	8618363	1
13	TURBINE ASSY	6772310	1
14	STATOR ASSY, FIRST	6768903	1
15	ROLLER, STATOR FREEWHEEL	7450737	16
16	SPRING, FREEWHEEL ROLLER	6771296	16
17	WASHER, SPACER, 4.62 OD X 3.51 ID X .22 WIDE	6754994	1
18	STATOR ASSY, SECOND	6768902	1
19	RACE, FREEWHEEL ROLLER	6755892	1
20	RING, EXTERNAL SNAP, 1.61 ID	6755897	1
21	SPACER, FREEWHEEL ROLLER RACE	6769856	1
22	RETAINER, BEARING	6757634	1
23	BOLT, HX HD, SELF-LOCKING, 1/4-20 X 3/4, CLS 2	9409088	8
24	BEARING ASSY, DOUBLE ROW BALL, MRC 5209K1	9417910	1
25	HUB, CONVERTER PUMP	6768714	1
26	RING, HOOK TYPE SEAL, 2.906 DIA	6754488	1
27	RING, SEAL	6758296	1
28	RING, SEAL	6753866	1
29	PUMP ASSY, CONVERTER, FOR TC 370 SERIES	6756001	1
	2.5 TO 1 STALL TORQUE RATIO		
30	BOLT, SPECIAL, 5/16-24 X 1.30	6755988	24
31	PUMP ASSY, CHARGING OIL	6768707	1
32	GEAR AND BODY ASSY	6768706	1
33	SEAL, 3.00 ID	6769816	1
34	BODY, OIL PUMP	6768704	*
35	GEAR, OIL PUMP DRIVE	6768351	*
36	GEAR, OIL PUMP DRIVEN	6768350	*
37	RING, SEAL, 8.00 ID X 1/8 DIA	6702958	1
38	SLEEVE, CONVERTER GROUND	6769530	1
39	SCREW, FLAT HEAD, SLOTTED, 1/4-20 X 5/8	113989	3
40	INDICATOR, OIL LEVEL	6755786	1
41	SCREW, FLAT HEAD, 1/4-20 X 1 3/4	113998	2
42	WASHER, LOCK, 5/16	103320	9
43	BOLT, HX HD, 5/16-18 X 7/8, CLS 2	179817	9
44	PLATE, SUMP	6754495	1
45	GASKET, SUMP PLATE	6754490	1
46	PLUG, DRAIN	6701230	1
47	GASKET, ANNULAR	105456	1
48	HOUSING ASSY, CONVERTER	6768956	1
49	PLUG, SQUARE SOCKET HEAD, 3/4 NPT	444672	2
50	HOUSING, CONVERTER	6769942	*

CONTINUED ON NEXT PAGE

* SERVICED AS AN ASSY - NOT AS A DETAIL PART

GROUP E CONT

TC-300 SERIES BASIC TORQMATIC CONVERTER, FIGURE 3-1
OVERRUNNING CLUTCH

REF NO	NOMENCLATURE	PART NO	REQ
51	TUBE, OIL COOLER RETURN	6756693	1
52	PLATE, TORQMATIC CONVERTER NAME	6832907	1
53	SCREW, ROUND HD DRV, NO. 4 X 1/4	142862	4
54	PLUG, PIPE, 1/4	444576	1
55	SLEEVE, OIL FILLER	6755789	1
56	BOLT, HX HD, 5/16-18 X 1/2 SEE SPI 196	179812	4
57	PLUG, SQUARE SOCKET HEAD, PIPE, 1 INCH	444678	1
58	SPRING	6758597	1
59	BALL	453621	1

GROUP F

TC-300 SERIES BASIC TORQMATIC CONVERTER, FIGURE 3-1
OVERRUNNING CLUTCH

SAME AS GROUP E, EXCEPT FOR PARTS LISTED BELOW.

29	PUMP ASSY, CONVERTER, TC 320 SERIES 3.5 TO 1	6756847	1
30	STALL TORQUE RATIO BOLT, SPECIAL, 5/16-24 X 1.30	6755988	24

GROUP G

TC-300 SERIES BASIC TORQMATIC CONVERTER, FIGURE 3

SAME AS GROUP A, EXCEPT FOR PARTS LISTED BELOW.

27	PUMP ASSY, CONVERTER, FOR TC 370 SERIES 2.5 TO 1	6756001	1
	STALL TORQUE RATIO		
38	INDICATOR, OIL LEVEL	6769621	1
46	HOUSING ASSY, CONVERTER	6774266	1
55	SLEEVE, OIL FILLER	6769622	1

GROUP H

TC-300 SERIES BASIC TORQMATIC CONVERTER, FIGURE 3

SAME AS GROUP A, EXCEPT FOR PARTS LISTED BELOW.

27	PUMP ASSY, CONVERTER, FOR TC 370 SERIES 2.5 TO 1	6756001	1
	STALL TORQUE RATIO		
38	INDICATOR, OIL LEVEL	6769621	1
46	HOUSING ASSY, CONVERTER	6774266	1
55	SLEEVE, OIL FILLER	6769622	1
62	PLUG, ORIFICE	6756659	1

GROUP J

TC-300 SERIES BASIC TORQMATIC CONVERTER, FIGURE 3

SAME AS GROUP A, EXCEPT FOR PARTS LISTED BELOW.

27	PUMP ASSY, CONVERTER, FOR TC 370 SERIES 2.5 TO 1	6756001	1
	STALL TORQUE RATIO		
38	INDICATOR, OIL LEVEL	6769621	1
55	SLEEVE, OIL FILLER	6769622	1

GROUP K

TC-300 SERIES BASIC TORQMATIC CONVERTER, FIGURE 3-1
OVERRUNNING CLUTCH

SAME AS GROUP E, EXCEPT FOR PARTS LISTED BELOW.

REF NO	NOMENCLATURE	PART NO	REQ
40	INDICATOR, OIL LEVER	6769621	1
55	SLEEVE, OIL FILLER	6769622	1

GROUP L

TC-300 SERIES BASIC TORQMATIC CONVERTER, FIGURE 3-2

1	GEAR, RING	6775414	1
2	BOLT, SPCL. HEAD 3/8-16 X 1 1/4	9412270	8
3	RING, SEAL	6769818	1
4	NUT, HX LOCK, 5/16-24	451006	24
5	COVER, CONVERTER PUMP	6830464	1
6	BEARING, NO 3L10 X R1A	903010	1
7	TURBINE ASSY	6774622	1
8	STATOR ASSY	6774962	1
9	BEARING, THRUST TORRINGTON FB 29009	9417499	1
10	ROLLER, STATOR FREEWHEEL	6774968	10
11	SPRING, FREEWHEEL ROLLER	6774966	10
12	RACE, FREEWHEEL	6774847	1
13	RING, EXTERNAL SNAP, 1.61 ID	6755897	1
14	SPACER, FREEWHEEL ROLLER RACE	6774620	1
15	BOLT, HX HD, 1/4-20 X 3/8	6773679	8
16	TAB, LOCKING	6769631	4
17	RETAINER, BEARING	6769491	1
18	BEARING, DOUBLE ROW BALL, MRC 5211K	9420046	1
19	HUB, CONVERTER PUMP	6774621	1
20	GASKET	6759971	1
21	RING, HOOK TYPE SEAL, 2.906 DIA	6754488	1
22	RING, SEAL	6753866	1
23	PUMP ASSY, CONVERTER, FOR 350 SERIES	6774616	1
24	BOLT, SPCL, 5/16-24 X 1.30	6755988	24
25	PUMP ASSY, CHARGING OIL	6774794	1
26	GEAR AND BODY ASSY	6768706	1
27	SEAL, 3.00 ID	6769816	1
28	BODY, OIL PUMP	6768704	1
29	GEAR, OIL PUMP DRIVE	6768351	1
30	GEAR, OIL PUMP DRIVEN	6768350	1
31	RING, SEAL, 8.00 ID X 1/8 DIA	6702958	1
32	SLEEVE, CONVERTER GROUND	6774626	1
33	SCREW, FLAT HD, SLOTTED, 1/4-20 X 5/8	113989	3
34	INDICATOR, OIL LEVEL	6755786	1
35	SCREW, FLAT HD, 1/4-20 X 1 3/4	113998	2
36	WASHER, LOCK, 5/16	103320	9
37	BOLT, HX HD, 5/16-18 X 7/8 CLS 2	179817	9
38	PLATE, SUMP	6754495	1
39	GASKET, SUMP PLATE	6754490	1
40	PLUG, DRAIN	6701230	1
41	GASKET, ANNULAR	105456	1
42	HOUSING ASSY, CONVERTER	6768956	1
43	PLUG, SQ SCKT HD, 3/4 NPT	444672	2
44	HOUSING, CONVERTER	6768942	1
45	TUBE, OIL COOLER RETURN	6756693	1
46	PLATE, TORQMATIC CONVERTER NAME	6832907	1
47	SCREW, RND HD, DRV, NO. 4 X 1/4	142862	4
48	PLUG, PIPE, 1/4	444576	1
49	SLEEVE, OIL FILLER	6755789	1
50	BOLT, HX HD, 5/16-18 X 1/2, SEE SPI 196	179812	4

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* SERVICED AS AN ASSY - NOT AS A DETAIL PART

GROUP L CONT

TC-300 SERIES BASIC TORQMATIC CONVERTER, FIGURE 3-2

REF NO	NOMENCLATURE	PART NO	REQ
51	PLUG, SQ SCKT HD PIPE, 1	444678	1
52	SPRING, TWO END COILS ARE WHITE	6758597	1
53	BALL	453621	1
54-60	NOT USED IN THIS GROUP.		

GROUP M

TC-300 SERIES BASIC TORQMATIC CONVERTER, FIGURE 3-2

SAME AS GROUP L, EXCEPT FOR PARTS LISTED BELOW.

23	PUMP ASSY, CONVERTER, TC 370 SERIES	6774627	1
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GROUP N

TC-300 SERIES BASIC TORQMATIC CONVERTER, FIGURE 3-3
OVERRUNNING CLUTCH

1	RING, INTERNAL SNAP, 3.361 OD	6759926	1
2	COVER, BEARING	6772312	1
3	RING, SQ SECTION SEAL, 3.107 ID	6759906	1
4	RING, EXTERNAL SNAP	6702989	1
5	BEARING ASSY, SINGLE ROW BALL, ND 3L10X1A	903010	1
6	RETAINER, SPRAG	6772309	1
7	GEAR, RING	6775414	1
8	BOLT, SPCL HD, 3/8-16 X 1 1/4	9412270	8
9	RING, SEAL	6769818	1
10	NUT, HX LOCK, 5/16-24	451006	24
11	COVER, CONVERTER PUMP	6772301	1
12	SPRAG ASSY	8618363	1
13	TURBINE ASSY	6774816	1
14	STATOR ASSY	6774962	1
15	BEARING, THRUST, TORRINGTON, FB 29009	9417499	1
16	ROLLER, STATOR FREEWHEEL	6774968	10
17	SPRING, FREEWHEEL ROLLER	6774966	10
18	RACE, FREEWHEEL	6774847	1
19	RING, EXTERNAL SNAP	6755892	1
20	SPACER, FREEWHEEL ROLLER RACE	6774620	1
21	RETAINER, BEARING	6769491	1
22	BOLT, HX HD, 1/4-20 X 5/8	6773679	8
23	TAB, LOCKING	6779631	4
24	BEARING, DOUBLE ROW BALL, MRC 5211K	9420046	1
25	HUB, CONVERTER PUMP	6774621	1
26	GASKET	6759971	1
27	RING, HOOK TYPE SEAL, 2.906 DIA	6754488	1
28	RING, SEAL	6753866	1
29	PUMP ASSY, CONVERTER, FOR TC 370 SERIES	6774627	1
30	BOLT, SPECIAL, 5/16-24 X 1.30	6755988	24
31	PUMP ASSY, CHARGING OIL	6774794	1
32	GEAR AND BODY ASSY	6768706	1
33	SEAL, 3.00 ID	6769816	1
34	BODY, OIL PUMP	6768704	1
35	GEAR, OIL PUMP DRIVE	6768351	1
36	GEAR, OIL PUMP DRIVEN	6768350	1
37	RING, SEAL, 8.00 ID X 1/8 DIA	6702958	1
38	SLEEVE, CONVERTER GROUND	6764626	1
39	SCREW, FLAT HD, SLOTTED, 1/4-20 X 5/8	113989	3
40	INDICATOR, OIL LEVEL	6755786	1
41	SCREW, FLAT HD, 1/4-20 X 1 3/4	113998	2

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* SERVICED AS AN ASSY - NOT AS A DETAIL PART

GROUP N CONT

TC-300 SERIES BASIC TORQMATIC CONVERTER, FIGURE 3-3
OVERRUNNING CLUTCH

REF NO	NOMENCLATURE	PART NO	REQ
42	WASHER, LOCK, 5/16	103320	9
43	BOLT, HX HD, 5/16-18 X 7/8, CLS 2	179817	9
44	PLATE, SUMP	6754495	1
45	GASKET, SUMP PLATE	6754490	1
46	PLUG, DRAIN	6701230	1
47	GASKET, ANNULAR	105456	1
48	HOUSING ASSY, CONVERTER	6768956	1
49	PLUG, SQ SOCKET HD, 3/4 NPT	444672	2
50	HOUSING, CONVERTER	6768942 *	1
51	TUBE, OIL COOLER RETURN	6756693	1
52	PLATE, TORQMATIC CONVERTER NAME	6832907	1
53	SCREW, RD HD DRV, NO. 4 X 1/4	142862	4
54	PLUG, PIPE, 1/4	444576	1
55	SLEEVE, OIL FILLER	6755789	1
56	BOLT, HX HD, 5/16-18 X 1/2, SEE SPI 196	179812	4
57	PLUG, SQ SOCKET HD, PIPE, 1 IN	444678	1
58	SPRING	6758597	1
59	BALL	453621	1

GROUP P

TC-300 SERIES BASIC TORQMATIC CONVERTER, FIGURE 3-3

SAME AS GROUP N, EXCEPT FOR PARTS LISTED BELOW.

29	PUMP ASSY, CONVERTER, FOR TC 350 SERIES	6774616	1
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GROUP Q

TC-300 SERIES BASIC TORQMATIC CONVERTER, FIGURE 3-2

SAME AS GROUP L, EXCEPT FOR PARTS LISTED BELOW.

23	PUMP ASSY, CONVERTER, FOR TC 370 SERIES	6774627	1
34	INDICATOR, OIL LEVEL	6769621	1
42	HOUSING ASSY, CONVERTER	6774266	1
49	SLEEVE, OIL FILLER	6769622	1

GROUP R

TC-300 SERIES BASIC TORQMATIC CONVERTER, FIGURE 3-2

SAME AS GROUP L, EXCEPT FOR PARTS LISTED BELOW.

23	PUMP ASSY, CONVERTER, TC 370 SERIES	6774627	1
34	INDICATOR, OIL LEVEL	6769621	1
42	HOUSING ASSY, CONVERTER	6774266	1
49	SLEEVE, OIL FILLER	6769622	1
54	PLUG, ORIFICE	6756659	1

* SERVICED AS AN ASSY - NOT AS A DETAIL PART

GROUP S

TC-300 SERIES BASIC TORQMATIC CONVERTER, FIGURE 3-2

SAME AS GROUP L, EXCEPT FOR PARTS LISTED BELOW.

REF NO	NOMENCLATURE	PART NO	REQ
1-5	NOT USED IN THIS GROUP.		
7	TURBINE ASSY	6776818	1
55	BOLT, HX HD, 1/2-13 X 1	9409258	6
56	PLATE, FLEX DISK	6774012	1
57	DISK, FLEXIBLE	6777448	3
58	DISK AND WASHER ASSY, FLEXIBLE	6777449	1
59	NUT, HX, 5/16-24	451006	24
60	COVER, TORQUE CONVERTER	6774008	1

TC-300 SERIES BASIC TORQMATIC CONVERTER OUTPUT SHAFTS SECTION

TO FIND DETAIL PARTS FOR YOUR ALLISON TORQMATIC CONVERTER, TURN TO THE GROUP AND PAGE LISTED OPPOSITE THE ASSEMBLY PART NUMBER OF YOUR CONVERTER.

A/N*	MODEL	GROUP	A/N*	MODEL	GROUP
6755060	TC 324	L	6769968	TCA 378	J
6755061	TC 325	C	6769969	TC 378	E
6755062	TCRD 326	A	6769970	TC 327	D
6755390	TCA 325	G	6769971	TC 324	L
6755395	TC 374	L	6769973	TC 376	P
6755396	TC 375	C	6769974	TC 374	M
6755397	TCA 375	G	6770285	TC 337	D
6755398	TCRD 376	A	6770730	TC 335	C
6756752	TC 327	D	6772298	TCOA 377	H
6756753	TCA 327	H	6772535	TCOA 377	K
6756754	TC 377	D	6772882	TCOA 327	H
6756755	TCA 377	H	6774265	TC 374	L
6756789	TC 378	E	6774295	TC 376	Q
6756914	TCRD 329	B	6774942	TCRD 356	A
6756937	TCRD 379	B	6774943	TC 374	L
6757844	TCRD 379	B	6774944	TC 375	C
6757846	TC 374	M	6774945	TCRD 376	A
6757847	TC 378	F	6774946	TCA 377	H
6758048	TC 328	J	6774947	TCRD 379	B
6759137	TCA 378	K	6774948	TC 378	E
6759598	TCA 377	K	6774949	TC 354	L
6759643	TC 376	P	6774950	TC 374	M
6759657	TC 324	L	6774951	TCOA 377	H
6759658	TC 325	C	6774952	TCOA 377	K
6759659	TC 327	D	6774953	TCOA 357	H
6759660	TCA 328	J	6774954	TC 374	L
6759661	TCA 325	G	6774955	TC 376	Q
6759663	TCA 378	J	6776068	TCOA 327	N
6759664	TCRD 326	A	6777113	TCRD 379	S
6759666	TC 374	M	6777769	TC 355	C
6759667	TC 374	L	6778166	TC 377	D
6759668	TC 375	C	6778167	TCRD 359	B
6759669	TC 377	D	6778205	TC 357	D
6759672	TCA 377	H	6778373	TCORD 379	B
6759674	TCRD 376	A	6778889	TCA 377	K
6759676	TCRD 379	B	6778966	TCA 377	N
6759677	TCA 377	K	6779069	TCOA 377	N
6759706	TCA 377	N	6779796	TCA 375	G
6759730	TC 378	E	6777113	TCRD 379	S
6759741	TC 328	E	6778206	TCD 357	H
6759759	TCRD 329	B	6831011	TCORD 356	A
6759767	TCA 377	N	6832081	TCRD 359	T
6769539	TCA 327	H	6832682	TCA 358	U
6769873	TC 328	E	6832883	TCOA 357	K
6769874	TCA 327	H	6833593	TC 355	C
6769943	TCA 377	N	6833671	TC 374	L

* A/N* - ASSEMBLY NUMBER - FOUND ON YOUR TRANSMISSION NAMEPLATE

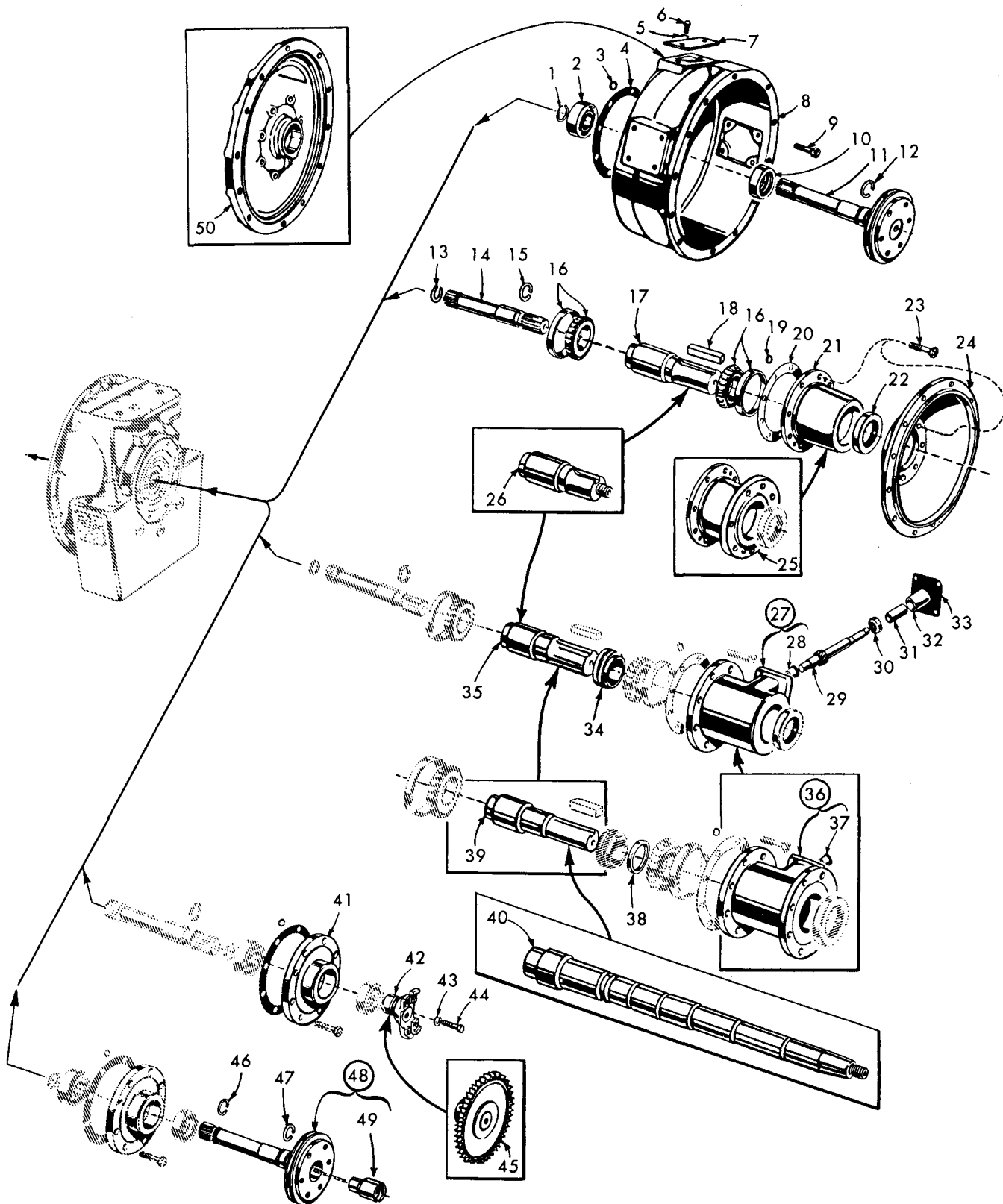


FIG. 4. TC 300 SERIES BASIC TORQMATIC CONVERTER OUTPUT SHAFTS

GROUP A

TC-300 SERIES OUTPUT SHAFT
SAE NO. 3 REAR DISCONNECT CLUTCH HOUSING, FIGURE 4

REF NO	NOMENCLATURE	PART NO	REQ
1	RING, EXTERNAL SNAP, 1.250 ID	6750046	1
2	BEARING ASSY, SINGLE ROW BALL, ND 3307L1214A . .	907050	1
3	RING, SEAL, .487 ID X .103	6763013	8
4	GASKET, BRNG RTNR	6753966	1
5	WASHER, LOCK, 3/8	103321	2
6	BOLT, HX HD, 3/8-16 X 3/4	179837	2
7	SHIELD, DUST	6757426	1
8	HOUSING, SAE NO. 3 REAR DISCONNECT CLUTCH	6754349	1
9	BOLT, HX HD, SELF-LOCKING, 1/2-13 X 2 3/4, CLS 2	9409203	8
10	SEAL, OIL, 2.750 X 1.75 ID X .75 THICK	6773249	1
11	SHAFT, TURBINE, WHEN REPLACING SHAFT 6759948 . .	6772734	1
	ALSO ORDER BEARING 907050, SEE SPI 499		
12	RING, HOOK TYPE SEAL, 1.406 BORE	6751839	1
13-50	NOT USED IN THIS GROUP.		

GROUP B

TC-300 SERIES OUTPUT SHAFT
SAE NO. 2 REAR DISCONNECT CLUTCH HOUSING, FIGURE 4

SAME AS GROUP A EXCEPT FOR PARTS LISTED BELOW.

8	HOUSING, SAE NO. 2 REAR DISCONNECT CLUTCH	6756913	1
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GROUP C

TC-300 SERIES OUTPUT SHAFT, INDUSTRIAL SHAFT, FIGURE 4

1-12	NOT USED IN THIS GROUP.		
13	RING, EXTERNAL SNAP, 1.10 ID	6755903	1
14	SHAFT, TURBINE	6759947	1
15	RING, HOOK TYPE SEAL, 1.406 BORE	6751839	1
16	BEARING ASSY, TAPERED ROLLER, TIMKEN 397-394RS .	9422228	2
17	SHAFT ASSY, CONVERTER OUTPUT	6755031	1
18	KEY, 5/8 X 5/8 X 3	6751531	1
19	RING, SEAL, .487 ID X .103	6763013	8
20	SHIM, BRNG HSNG, .003	6778856	AR
20	SHIM, BRNG HSNG, .010	6778857	AR
21	HOUSING, BRNG	6754508	1
22	SEAL, OIL, 3.378 OD X 2.35 ID X .483 WIDE	6754506	1
23	BOLT, HX HD, SELF-LOCKING, 1/2-13 X 3.00, CLS 2 .	9409203	8
24-50	NOT USED IN THIS GROUP.		

GROUP D

TC-300 SERIES OUTPUT SHAFT
INDUSTRIAL SHAFT WITH EXTRA DUTY BEARINGS, FIGURE 4

SAME AS GROUP C, EXCEPT FOR PARTS LISTED BELOW.

16	BEARING ASSY, TAPERED ROLLER, TIMKEN 558S-553X .	456635	2
17	SHAFT ASSY, CONVERTER OUTPUT	6756869	1
21	NOT USED IN THIS GROUP.		
25	HOUSING, BRNG	6756865	1

GROUP E

TC-300 SERIES OUTPUT SHAFT
INDUSTRIAL SHAFT WITH BEVEL PINION MOUNTING, FIGURE 4

SAME AS GROUP C, EXCEPT FOR PARTS LISTED BELOW.

REF NO	NOMENCLATURE	PART NO	REQ
15	RING, HOOK TYPE SEAL	3689838	1
17	NOT USED IN THIS GROUP.		
18	NOT USED IN THIS GROUP.		
23	BOLT, HX HD, SELF-LOCKING, 1/2-13 X 2 1/2, CLS 2	9409203	8
26	SHAFT ASSY, CONVERTER OUTPUT	6756946	1

GROUP F

TC-300 SERIES OUTPUT SHAFT
INDUSTRIAL SHAFT WITH BEVEL PINION MOUNTING, FIGURE 4

SAME AS GROUP C, EXCEPT FOR PARTS LISTED BELOW.

13	NOT USED IN THIS GROUP.		
17	NOT USED IN THIS GROUP.		
23	BOLT, HX HD, 1/2-13 X 3 1/4	9409227	8
24	PLATE, TRNS ADPTR	6756947	1
26	SHAFT ASSY, CONVERTER OUTPUT	6756946	1

GROUP G

TC-300 SERIES OUTPUT SHAFT, INDUSTRIAL SHAFT WITH ACCESSORY DRIVE, FIGURE 4

SAME AS GROUP C, EXCEPT FOR PARTS LISTED BELOW.

17	NOT USED IN THIS GROUP.		
21	NOT USED IN THIS GROUP.		
27	HOUSING ASSY, BRNG	6755377	1
28	BUSHING	2222424	1
29	GEAR, ACCESSORY DRVN, 2.5 TO 1	6755618	1
30	BEARING ASSY, SINGLE ROW BALL, ND 3202NR1214A . .	907411	1
31	SLEEVE, ACCESSORY DRV	3224085	1
32	SPACER, 1.38 OD X .06 WALL X 2.16	6751524	1
33	GASKET	3224773	1
34	GEAR, ACCESSORY DRV, 2.5 TO 1	6755619	1
35	SHAFT ASSY, CONVERTER OUTPUT	6755380	1

GROUP H

TC-300 SERIES OUTPUT SHAFT
INDUSTRIAL SHAFT WITH EXTRA DUTY BEARINGS AND ACCESSORY DRIVE, FIGURE 4

SAME AS GROUP G, EXCEPT FOR PARTS LISTED BELOW.

16	BEARING ASSY, TAPERED ROLLER, TIMKEN 558S-553X .	456635	2
27-28	NOT USED IN THIS GROUP.		
35	NOT USED IN THIS GROUP.		
36	HOUSING ASSY, BRNG	6756706	1
37	BUSHING	2222424	1
38	SPACER, CONVERTER OUTPUT SHAFT	6756689	1
39	SHAFT ASSY, CONVERTER OUTPUT	6756691	1

GROUP J

TC-300 SERIES OUTPUT SHAFT
INDUSTRIAL SHAFT WITH ACCESSORY DRIVE, FIGURE 4

SAME AS GROUP G, EXCEPT FOR PARTS LISTED BELOW.

REF NO	NOMENCLATURE	PART NO	REQ
18	NOT USED IN THIS GROUP.		
26	SHAFT ASSY	6758054	1
35	NOT USED IN THIS GROUP.		

GROUP K

TC-300 SERIES OUTPUT SHAFT
INDUSTRIAL SHAFT WITH ACCESSORY DRIVE, FIGURE 4

SAME AS GROUP H, EXCEPT FOR PARTS LISTED BELOW.

18	NOT USED IN THIS GROUP.		
38	SPACER, CONVERTER OUTPUT SHAFT	6756689	1
39	NOT USED IN THIS GROUP.		
40	SHAFT ASSY, CONVERTER OUTPUT	6768346	1

GROUP L

TC-300 SERIES OUTPUT SHAFT, AUTOMOTIVE SHAFT, FIGURE 4

SAME AS GROUP A, EXCEPT FOR PARTS LISTED BELOW.

5-8	NOT USED IN THIS GROUP.		
11	NOT USED IN THIS GROUP.		
14	SHAFT, TURBINE	6759946	1
41	RETAINER, BRNG	6755302	1
42	FLANGE ASSY, M4C	6755333	1
43	WASHER, LOCK, 1/2	103323	1
44	BOLT, HX HD, 1/2-20 X 1 1/4, CLS 2	181429	1

GROUP M

TC-300 SERIES OUTPUT SHAFT, COUPLING, FIGURE 4

SAME AS GROUP L, EXCEPT FOR PARTS LISTED BELOW.

42	NOT USED IN THIS GROUP.		
45	COUPLING, OUTPUT DRV	6757758	1

GROUP N

TC-300 SERIES OUTPUT SHAFT
INDUSTRIAL SHAFT WITH EXTRA DUTY BEARINGS AND ACCESSORY DRIVE, FIGURE 4

SAME AS GROUP H, EXCEPT FOR PARTS LISTED BELOW.

29	GEAR, ACCESSORY DRVN, 1.69 TO 1	6768425	1
34	GEAR, ACCESSORY DRV, 1.69 TO 1	6768426	1

GROUP P

TC-300 SERIES OUTPUT SHAFT, FIGURE 4

REF NO	NOMENCLATURE	PART NO	REQ
1	SNAPRING	6703023	1
2	BEARING, SINGLE ROW BALL, ND 3211L1214A	954528	1
3	SEALRING, .487 ID X .103 DIA	6763013	8
4	GASKET, BEARING HSNG	6753966	1
5-8	NOT USED IN THIS GROUP.		
9	BOLT, 1/2-13 X 2 3/4	9409203	8
10	SEAL, LIP TYPE	6754947	1
11-40	NOT USED IN THIS GROUP.		
41	RETAINER, BEARING	6769057	1
42-45	NOT USED IN THIS GROUP.		
46	SEALRING, HOOK TYPE	6764025	1
47	SEALRING, HOOK TYPE	6700296	1
48	SHAFT ASSY, OUTPUT	6769051	1
49	PLUG	6769050	1

GROUP Q

TC-300 SERIES OUTPUT SHAFT, FIGURE 4

SAME AS GROUP A, EXCEPT FOR PARTS LISTED BELOW.

5-8	NOT USED IN THIS GROUP.		
9	BOLT, HX HD, SELF-LOCKING, 1/2-13 X 3	9409240	8
50	RETAINER, BEARING	6757737	1

GROUP R

TC-300 SERIES OUTPUT SHAFT, FIGURE 4

SAME AS GROUP A, EXCEPT FOR PARTS LISTED BELOW.

5-8	NOT USED IN THIS GROUP.		
13-40	NOT USED IN THIS GROUP.		
41	RETAINER, BEARING	6773933	1
42-50	NOT USED IN THIS GROUP.		

GROUP S

TC-300 SERIES OUTPUT SHAFT
SAE NO. 2 REAR DISCONNECT CLUTCH HOUSING, FIGURE 4

SAME AS GROUP A, EXCEPT FOR PARTS LISTED BELOW.

8	HOUSING, SAE NO. 2 REAR DISCONNECT CLUTCH	6777120	1
---	---	---------	---

GROUP T

TC-300 SERIES OUTPUT SHAFT, FIGURE 4

SAME AS GROUP A, EXCEPT FOR PARTS LISTED BELOW

8	HOUSING, SAE NO. 2 REAR DISCONNECT CLUTCH	6831578	1
---	---	---------	---

GROUP U

TC-300 SERIES OUTPUT SHAFT, INDUSTRIAL SHAFT WITH ACCESSORY DRIVE, FIGURE 4

SAME AS GROUP C, EXCEPT FOR PARTS LISTED BELOW

REF NO	NOMENCLATURE	PART NO	REQ
17-18	NOT USED IN THIS GROUP		
21	NOT USED IN THIS GROUP		
26	SHAFT ASSY	6758054	1
27	HOUSING ASSY, BEARING	6755377	1
28	BUSHING	2222424	1
29	GEAR ACCESSORY DRIVEN, 2.5 TO 1	6755618	1
30	BEARING ASSY, SINGLE ROW BALL, ND 3202NR1241A . .	907411	1
31	SLEEVE, ACCESSORY DRV	3224085	1
32	SPACER, 1.38 OD X .06 WALL X 2.16	6751524	1
33	GASKET	3324773	1
34	GEAR, ACCESSORY DRIVE, 2.5 TO 1	6755619	1

MANUAL INPUT DISCONNECT CLUTCH ASSEMBLY OPTION

TO FIND DETAIL PARTS FOR YOUR ALLISON TORQMATIC CONVERTER, TURN TO THE GROUP AND PAGE LISTED OPPOSITE THE SERIES NUMBER OF YOUR CONVERTER.

SERIES	GROUP	PAGE
TC 200, OPTION 6757004	A	5-3.1
TC 300, OPTION 6757004	A	5-3.1

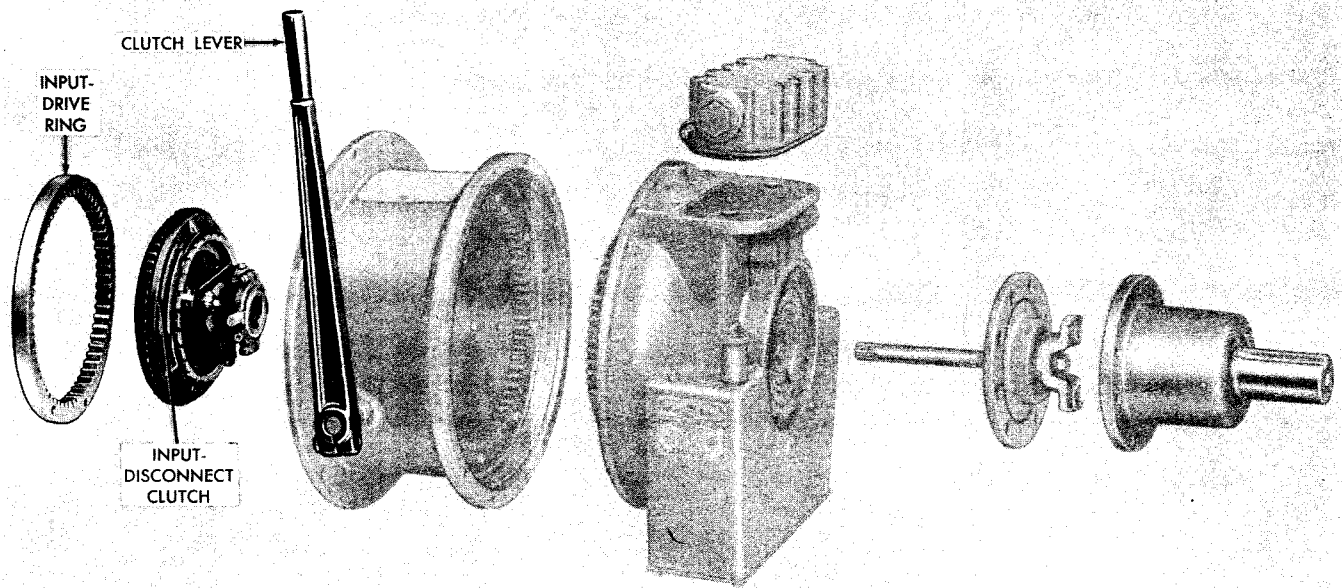


FIG. 5. TC 200-300 SERIES MANUAL INPUT DISCONNECT CLUTCH ASSEMBLY OPTION

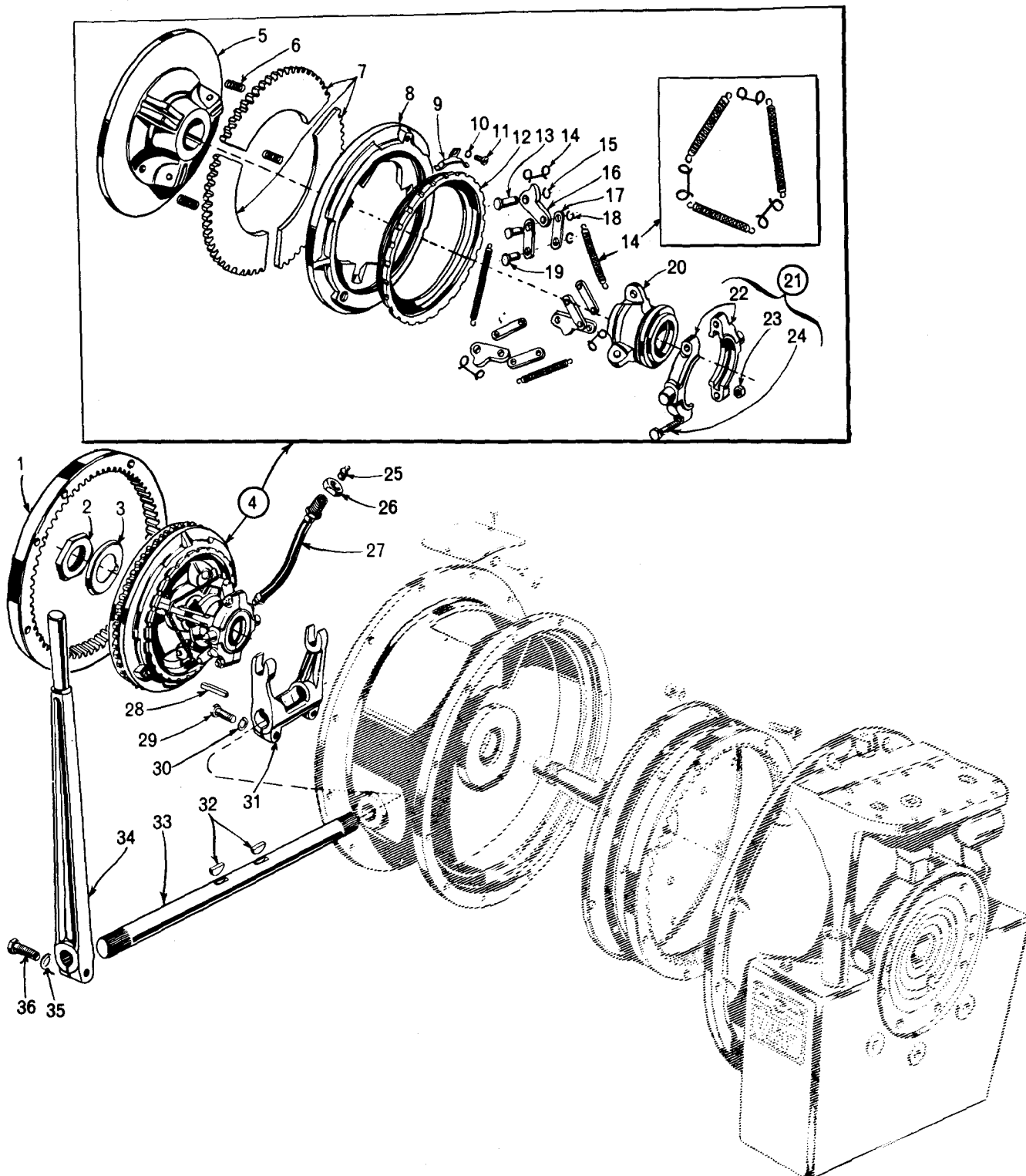


FIG. 5-1. TC 200-300 SERIES MANUAL INPUT DISCONNECT CLUTCH ASSEMBLY OPTION

GROUP A

MANUAL INPUT DISCONNECT CLUTCH ASSEMBLY, OPTION 6757004, FIGURE 5-1

REF NO	NOMENCLATURE	PART NO	REQ
1	RING, DRV, 10 INCH	5192180	1
2	NUT	5192153	1
3	WASHER	5194671	1
4	CLUTCH ASSY, MANUAL INPUT DISCONNECT, 10 INCH . .	5194365	1
5	BODY, CLU	5193258	1
6	SPRING, SEPARATOR	5193431	3
7	FACING ASSY	5192182	1
8	PLATE, PRESR	5194294	1
9	LOCK, ADJUSTING	5194291	1
10	WASHER, SHAKEPROOF, 1/4	114604	1
11	SCREW, FILLISTER HD, 1/4-20 X 3/8	114351	1
12	NUT, ADJUSTING	5193430	1
13	PIN, CLEVIS	5193422	3
14	SPRING, LEVER	5194138	1
15	RING, RTNR	5192142	1
16	LEVER	5194140	3
17	LINK, CONNECTING	5193421	6
18	RING, RTNR	5192176	6
19	PIN, CLEVIS	5193420	6
20	SLEEVE, RELEASE	5193259	1
21	BEARING ASSY, RELEASE	5196719	1
22	BEARING, RELEASE SERVICED IN ASSY *		1
	5196719 ONLY		
23	NUT, ELASTIC STOP, 5/16-24	214279	2
24	BOLT, HX HD, 5/16-24 X 1 3/4	181345	2
25	FITTING, GREASE	191758	1
26	NUT, JAM, 5/8-18	114498	1
27	TUBE ASSY, FLX LUBE	5193064	1
28	KEY, 1/4 X 1/4 X 2	5192489	1
29	BOLT, HX HD, 3/8-16 X 1 1/4, CLS 3	179841	2
30	WASHER, LOCK, 3/8	103321	2
31	YOKE, CLU SHIFTER	5193255	1
32	KEY, WOODRUFF	113782	2
33	SHAFT, CLU SHIFTER	5194244	1
34	LEVER, CLU CONTROL HAND	6778121	1
35	WASHER, LOCK, 3/8, PRIOR TO S/N 42917 USE 103321	103321	1
36	BOLT, HX HD, 3/8-16 X 1 3/8, PRIOR TO S/N 42917 . USE 179887	179842	1

* SERVICED AS AN ASSY - NOT AS A DETAIL PART

MANUAL INPUT DISCONNECT CLUTCH HOUSING OPTIONS AND DRIVE RING OPTIONS

TO FIND DETAIL PARTS FOR YOUR ALLISON TORQMATIC CONVERTER, TURN TO THE GROUP AND PAGE LISTED OPPOSITE THE SERIES NUMBER OF YOUR CONVERTER.

SERIES	GROUP	PAGE
TC 200, OPTION 5192180	A	6-3.1
TC 200, OPTION 6757000	B	6-3.1
TC 200, OPTION 6757002	D	6-3.1
TC 200, OPTION 6759249	G	6-3.2
TC 300, OPTION 6757003	E	6-3.1
TC 300, OPTION 6759251	F	6-3.2
TC 300, OPTION 6759252	H	6-3.2
TC 300, OPTION 6768580	F	6-3.2
TC 300, OPTION 6768581	J	6-3.2
TC 300, OPTION 6768582	E	6-3.1
TC 300, OPTION 6768583	C	6-3.1

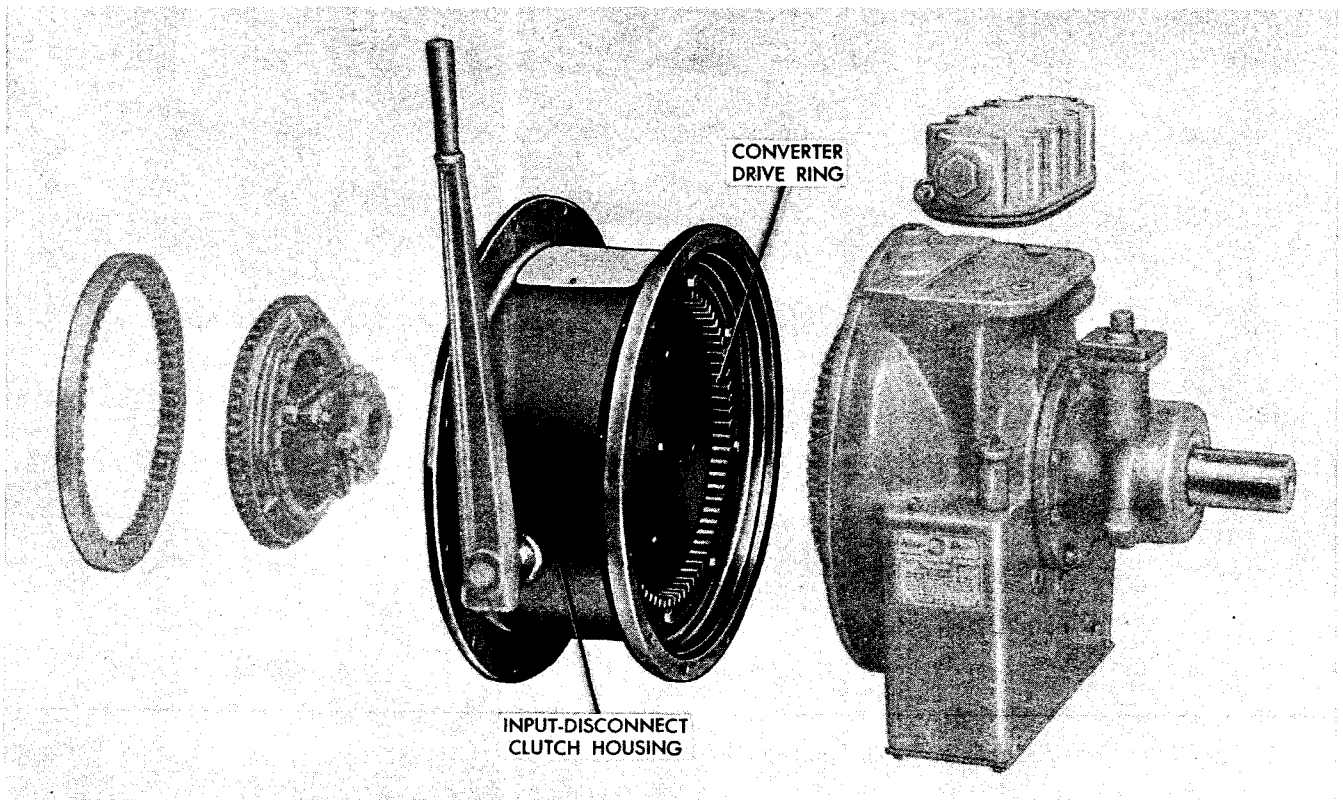


FIG. 6. TC 200-300 SERIES MANUAL INPUT DISCONNECT CLUTCH HOUSING OPTIONS
AND DRIVE RING OPTIONS

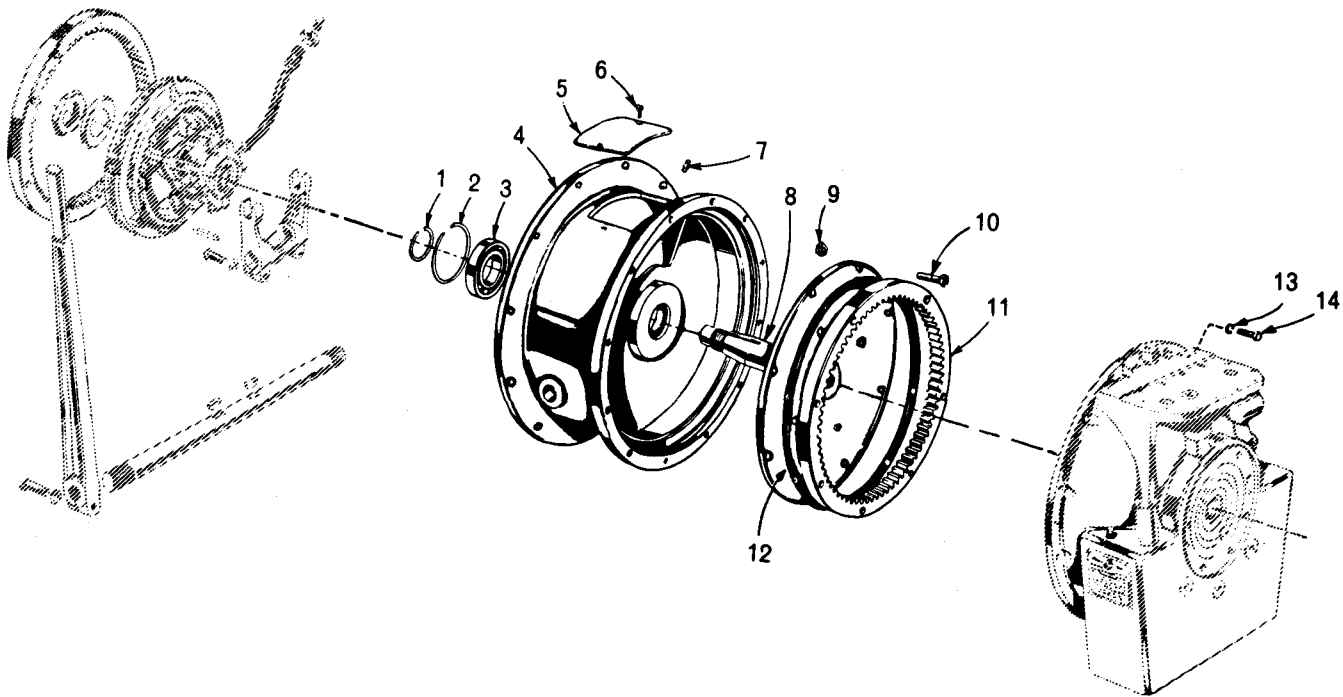


FIG. 6-1. TC 200-300 SERIES MANUAL INPUT DISCONNECT CLUTCH HOUSING
OPTIONS AND DRIVE RING OPTIONS

GROUP A

10-INCH DRIVE RING, OPTION 5192180, FIGURE 6-1

REF NO	NOMENCLATURE	PART NO	REQ
1-10	NOT USED IN THIS GROUP.		
11	RING, DRV, 10 DIA	5192180	1
12-14	NOT USED IN THIS GROUP.		

GROUP B

SAE NO. 2 MANUAL INPUT DISCONNECT CLUTCH HOUSING, OPTION 6757000, FIGURE 6-1

1	RING, SNAP	6751822	1
2	RING, SNAP	6753487	1
3	BEARING ASSY, SINGLE ROW BALL, NO 7509XR1E	907540	1
4	HOUSING, SAE NO. 2 MANUAL INPUT DISCONNECT CLUTCH	6756620	1
5	COVER, MANUAL INPUT DISCONNECT CLU HSG	6756618	1
6	SCREW, NO. 10-24 X 7/16	113903	2
7	FITTING, GREASE	191758	1
8	SHAFT ASSY, CONVERTER INPUT	6756615	1
9	NUT, 3/8-24	103026	8
10	BOLT, HX HD, 3/8-24 X 1 1/2, CLS 2A	9409038	8
11	RING, DRIVE, 10 DIA	5192180	1
12	NOT USED IN THIS GROUP.		
13	WASHER, LOCK, 3/8	103321	12
14	BOLT, HX HD, 3/8-16 X 1 1/8, CLS 2	179840	12

GROUP C

SAE NO. 2 MANUAL INPUT DISCONNECT CLUTCH HOUSING, OPTION 6768583, FIGURE 6-1

SAME AS GROUP B, EXCEPT FOR PARTS LISTED BELOW.

8	SHAFT ASSY, CONVERTER INPUT	6772307	1
9	NUT, 3/8-16	102635	8
10-12	SEE DRIVE RING KIT 6775458, SEE SPI 351 KIT 6775458 CONSISTS OF 1-6775414 DRIVE RING, 1-6769818 SEALRING, 8-9412270 BOLTS, 1 LB 6769877 GREASE AND 1-6770047 INSTRUCTION SHEET		
12	GASKET	6769988	1

GROUP D

SAE NO. 3 MANUAL INPUT DISCONNECT CLUTCH HOUSING, OPTION 6757002, FIGURE 6-1

SAME AS GROUP B, EXCEPT FOR PARTS LISTED BELOW.

4	HOUSING, SAE NO. 3 MANUAL INPUT DISCONNECT CLUTCH	6756627	1
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GROUP E

SAE NO. 3 MANUAL INPUT DISCONNECT CLUTCH HOUSING, OPTION 6768582, FIGURE 6-1

SAME AS GROUP C, EXCEPT FOR PARTS LISTED BELOW.

4	HOUSING, SAE NO. 3 MANUAL INPUT DISCONNECT CLUTCH	6756627	1
---	---	---------	---

GROUP F

SAE NO. 2 MANUAL INPUT DISCONNECT CLUTCH HOUSING, OPTION 6768580, FIGURE 6-1

SAME AS GROUP C, EXCEPT FOR PARTS LISTED BELOW.

REF NO	NOMENCLATURE	PART NO	REQ
8	SHAFT ASSY, CONVERTER INPUT	6772328	1

GROUP G

SAE NO. 2 MANUAL INPUT DISCONNECT CLUTCH HOUSING, OPTION 6759249, FIGURE 6-1

SAME AS GROUP B, EXCEPT FOR PARTS LISTED BELOW.

8	SHAFT ASSY, CONVERTER INPUT	6758988	1
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GROUP H

SAE NO. 3 MANUAL INPUT DISCONNECT CLUTCH HOUSING, OPTION 6759252, FIGURE 6-1

SAME AS GROUP F, EXCEPT FOR PARTS LISTED BELOW.

4	HOUSING, SAE NO. 3 MANUAL INPUT DISCONNECT CLUTCH	6756627	1
8	SHAFT ASSY, CONVERTER INPUT	6758987	1

GROUP J

SAE NO. 3 MANUAL INPUT DISCONNECT CLUTCH HOUSING, OPTION 6768581, FIGURE 6-1

SAME AS GROUP F, EXCEPT FOR PARTS LISTED BELOW.

4	HOUSING, SAE NO. 3 MANUAL INPUT DISCONNECT CLUTCH	6756627	1
---	---	---------	---

OIL COOLER, CABLE DRIVE ADAPTER FOR ACCESSORY DRIVE,
REAR DISCONNECT CLUTCH ADAPTER, AND MOUNTING PLATE OPTIONS

TO FIND DETAIL PARTS FOR YOUR ALLISON TORQMATIC CONVERTER TURN TO
THE GROUP AND PAGE LISTED OPPOSITE THE SERIES NUMBER OF YOUR CONVERTER

SERIES	GROUP	PAGE
TC 200, OPTION 6833423	A	7-3.1
TC 200, OPTION 6756685	G	7-3.2
TC 200, OPTION 6755877	C	7-3.1
TC 248, OPTION 6757008	F	7-3.2
USED ON A/N 6757848 ONLY		
TCA 248, OPTION 6757007	D	7-3.1
TC 300, OPTION 6756685	G	7-3.2
TC 300, OPTION 6833423	A	7-3.1
TCA 300, OPTION 6755877	C	7-3.1
TC 378, OPTION 6757009	E	7-3.2

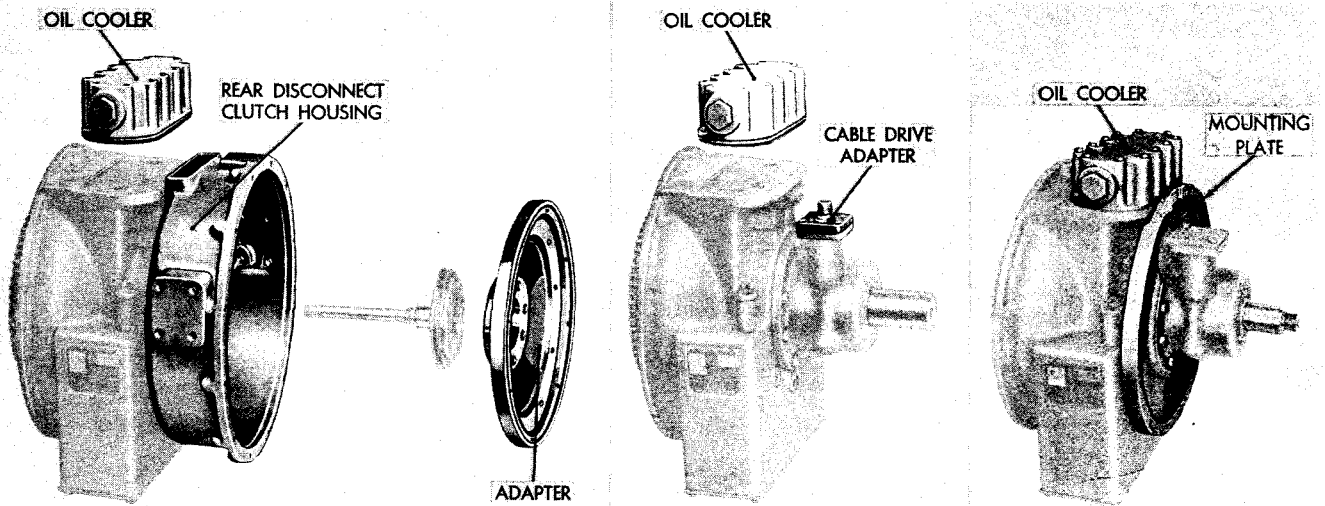


FIG. 7. TC 200-300 SERIES OIL COOLER OPTIONS, CABLE DRIVE ADAPTER
OPTION, REAR DISCONNECT CLUTCH ADAPTER OPTION, AND MOUNTING
PLATE OPTIONS

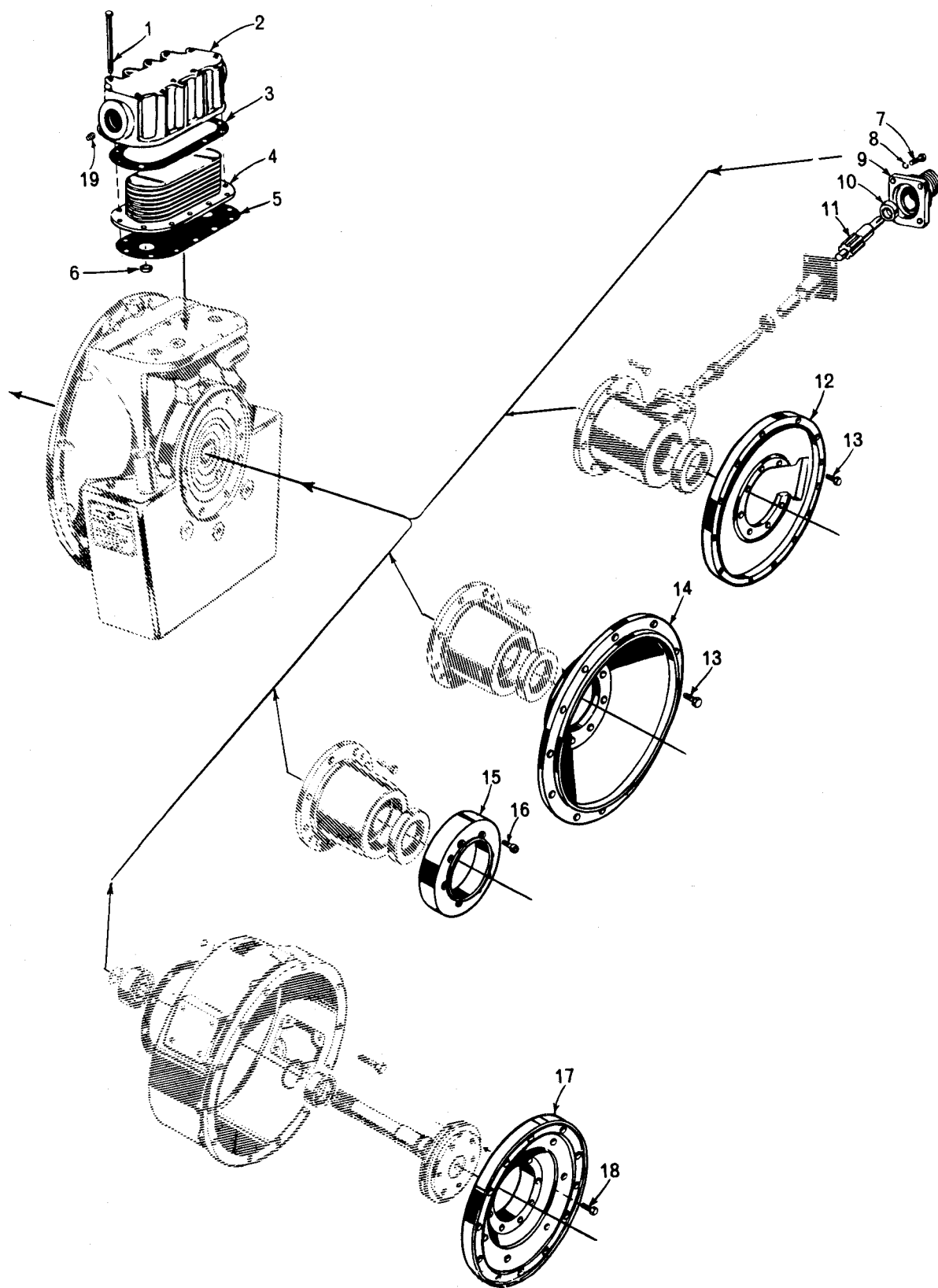


FIG. 7-1. TC 200-300 SERIES OIL COOLER OPTIONS, CABLE DRIVE ADAPTER OPTION, REAR DISCONNECT CLUTCH ADAPTER OPTION, AND MOUNTING PLATE OPTIONS

GROUP A

OIL COOLER, OPTION 6833423, FIGURE 7-1

REF NO	NOMENCLATURE	PART NO	REQ
1	BOLT, HX HD, 5/16-18 X 3 3/4, CLS 2	186271	12
2	COVER, OIL COOLER	6755488	1
3	GASKET, OIL COOLER COVER	6754299	1
4	CORE ASSY, OIL COOLER	8522609	1
5	GASKET, OIL COOLER	6754314	1
6	PLUG, ORIFICE, .218 DIA, SEE SPI 136, TC200 ONLY	6756658	1
6	PLUG, ORIFICE, .312 DIA, SEE SPI 136, TC 300 ONLY	6756659	1
7-18	NOT USED IN THIS GROUP.		
19	PLUG, 1/4 NPTF	444570	1

GROUP B

CABLE DRIVE ADAPTER FOR ACCESSORY DRIVE, OPTION 6755877, FIGURE 7-1

1-6	NOT USED IN THIS GROUP.		
7	BOLT, HX HD, 5/16-18 X 1 1/8, CLS 2	179819	4
8	WASHER, LOCK, 5/16	103320	4
9	ADAPTER, CABLE DRV	6752033	1
10	SEAL, OIL, .50 ID	6752035	1
11	SHAFT, CABLE DRV ADPTR	6752034	1
12-19	NOT USED IN THIS GROUP.		

GROUP C

MOUNTING PLATE, OPTION 6757007, FIGURE 7-1

1-11	NOT USED IN THIS GROUP.		
12	PLATE, MNTG, USE ON CONVERTERS PRIOR TO S/N 6482	6756362	1
13	BOLT, HX HD, SELF-LOCKING, 1/2-13 X 3 1/4, CLS 2, USE ON CONVERTERS PRIOR TO S/N 6482.	9409227	8
14-19	NOT USED IN THIS GROUP.		

GROUP D

MOUNTING PLATE, OPTION 6757009, FIGURE 7-1

1-12	NOT USED IN THIS GROUP.		
13	BOLT, HX HD, SELF-LOCKING, 1/2-13 X 3 1/4, CLS 2	9409227	8
14	PLATE, MNTG	6756947	1
15-19	NOT USED IN THIS GROUP.		

GROUP E

MOUNTING PLATE, FOR TC-248, FIGURE 7-1

1-14	NOT USED IN THIS GROUP.		
15	PLATE, MNTG	6756864	1
16	BOLT, HX SCKT HD, 1/2-13 X 3 3/4	147465	8
17-19	NOT USED IN THIS GROUP.		

GROUP F

REAR DISCONNECT CLUTCH ADAPTER, OPTION 6756685, FIGURE 7-1

1-16	NOT USED IN THIS GROUP.		
17	ADAPTER, REAR DISCONNECT CLU	6756119	1

CONTINUED ON NEXT PAGE

GROUP F CONT

REAR DISCONNECT CLUTCH ADAPTER, OPTION 6756685, FIGURE 7-1

REF NO	NOMENCLATURE	PART NO	REQ
18	BOLT, HX HD, SELF-LOCKING, 1/2-20 X 1 1/2, CLS 2	9409060	6
19	NOT USED IN THIS GROUP.		

SUPPLEMENTAL PARTS INFORMATION
(SPI)

SPI 127

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May 17, 1954

SUBJECT: TORQMATIC CONVERTERS - ALL 200 SERIES
MODELS. SERVICE REPLACEMENT STATOR
THRUST WASHERS OF CERTAIN EARLY
PRODUCTION UNITS.

REFERENCE: Transmission Engineering Memorandum,
Serial No. 434 A-B, dated April 12, 1954.

In order to improve the wear characteristics of the stator
thrust washers where high torque multiplication for long periods
is involved, improved thrust washers have been incorporated
on the 200 Series Torqmatic Converters.

All 200 Series Torqmatic Converters, S/N 4803 and below,
except 4768, should have both thrust washers replaced in the
event disassembly should be required for any reason.

Parts Involved:

<u>Name</u>	<u>Old Part No.</u>	<u>New Part No.</u>
Washer, Rear Thrust	CEX-7990	6756233
Washer, Pump Thrust	3709044	6756629

The following unit serial numbers are affected by this change:

4600	4691	4779	4790
4601	4714	4780	4791
4602	4721	4781	4792
4625	4725	4782	4799
4668	4776	4783	4800
4669	4777	4788	4801
4672	4778	4789	4802
			4803

Service Manager - Transmissions

SPI 136
Page 1 of 6
August 9, 1954

SUBJECT: TORQMATIC CONVERTER - TC-200 & 300 SERIES -
HYDRAULIC CIRCUITS AND OPERATING PRESSURES.

There are three (3) types of approved hydraulic circuits that are recommended for the subject converters.

1. Integral Heat Exchanger with or without the Integral By-Pass Valve (See S.P.I. No. 175 for Information on Integral By-Pass Valve).

The integral heat exchanger is approved for all applications and will maintain pressures within required limitations. Use of an integral heat exchanger requires use of an orifice in the converter "in" (see sketch) line. Orifice P/N 6756658 with a 7/32" diameter hole, is used with all TC-200 Series Converters. Orifice P/N 6756659 with a 5/16" diameter hole, is used with all TC-300 Series Converters. See sketch for correct flow of water through heat exchanger.

2. Remote Heat Exchanger and External By-Pass Valve (Units below Serial No. 8073).

The remote heat exchanger circuit must have a minimum oil line size of 5/8" I.D., and must have an approved * pressure by-pass valve set for initial opening at 55 plus-minus 5 psi, mounted at the converter oil "out" connection (see below for exceptions) and piped to discharge into the converter oil "in" line. This is for the purpose of controlling converter charging pressure during cold weather starts. This is necessary in order to prevent excessive converter pressure when starting at low ambient temperatures, which could damage the converter.

Exception to location of pressure relief valve

On Detroit Diesel Engine applications, due to peculiarities in the installation, it has been necessary to locate the by-pass valve at the cooler instead of at the converter. The relocation of the by-pass valve in this case has been approved by Allison.

On other installations, if remote mounting of the by-pass valve is necessary, the installation must first be approved by Allison.

3. Remote Heat Exchange and Integral By-pass Valve (Units above Serial No. 8073 see S.I.L. No. 175).

The remote heat exchanger circuit must have a minimum oil line size of 5/8" I.D. in addition to satisfying the cooling requirements for the particular installation. The heat exchanger must have a pressure drop that is compatible with the pressure requirements at stall. In these units the integral by-pass valve will properly control the pressure throughout the remainder of the operating range.

Pressure Limitation on TC-200 & 300 Series Converters.

1. The following oil "out" pressures must be provided at 225 degrees F. oil temperatures:

TC-200

Minimum at full throttle stall	15 psi
Maximum at full throttle stall	30 psi
Maximum at full throttle no load	60 psi

TC-300

Minimum at full throttle stall	25 psi
Maximum at full throttle stall	35 psi
Maximum at full throttle no load	60 psi

2. The following methods should be used to attain the required pressure limitations:

- 2.1 Pressure at Stall too High

If the converter pressure at stall is too high, the pressure drop in the cooler circuit must be reduced. If an increase in oil line size does not reduce the pressure to the required limits, then a heat exchanger with less restriction must be used.

- 2.2 Pressure at Stall too Low

If the converter pressure at stall is too low, the pressure drop in the cooler circuit must be increased. The simplest way to do this is to install an orifice of the proper size to provide the minimum pressure shown above.

4. Oil recommendations for units incorporating the integral by-pass valve (units Serial No. 8073 and above).

-10° F and higher:

Hydraulic transmission fluid type C where available, otherwise SAE 10 heavy duty (MIL-L-2104).

-10° F and lower:

Hydraulic transmission fluid type C where available, otherwise SAE 10 heavy-duty (MIL-L-2104).

5. Oil recommendations for units using the external by-pass valve (units below Serial No. 8073).

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 Page 3 of 6
 August 9, 1954

+10° F and higher:

Hydraulic transmission fluid type C where available, otherwise
 SAE 10 heavy duty (MIL-L-2104).

+ 10° F and lower:

A mineral base oil meeting the following specifications:

Viscosity at 100° F	55-65 SSU
Viscosity at 210° F	35-38 SSU
Pour Point	-30° F
Flash Point	300° F Min.
Copper Strip Test	Negative
ASTM#D 130	
Cabinet Humidity Test	Corrosion around edge
(Anti-rust and anti-corrosion)	of panel only
L-4 Test	Pass
Foam Test	Pass

At temperatures below the pour point of the special light weight oils, auxiliary heat must be applied to raise the oil temperature to its pour point.

The following oils are represented by the respective suppliers as meeting the above specification. Responsibility for the quality of a lubricating oil and its performance in service must remain with the oil company marketing the lubricant. This list should, therefore, not be construed as a recommendation of the products by the Allison Division of General Motors.

<u>Brand</u>	<u>Type</u>
Esso	Torque Fluid 35
Texas Co.	Texaco Torque Fluid
Cities Service	Torque Fluid #4
Socony-Vacuum	Mobile Fluid #62
Standard Oil of Calif.	RPM Torque Fluid #3
Standard Oil	Stanotorque Conv. Fluid

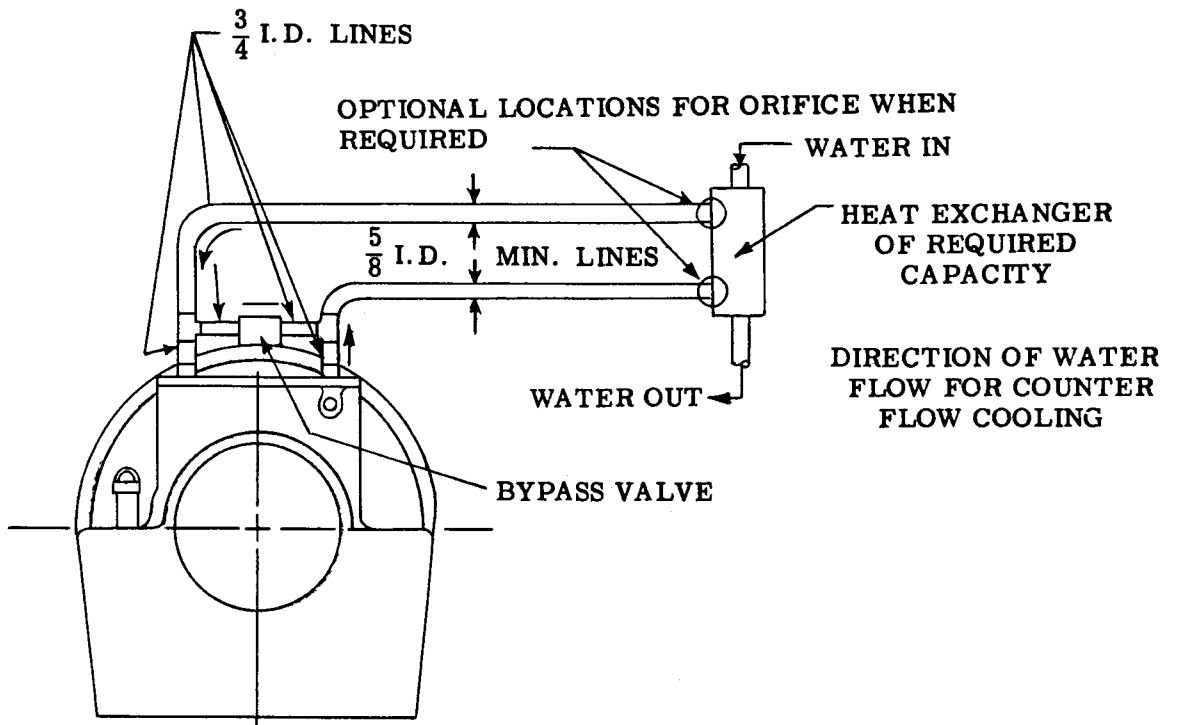
Since new products are continuously being tested by the oil industry, the listing may not contain all products marketed at the time of issue. Revised lists will be made available from time to time, as additional information is developed.

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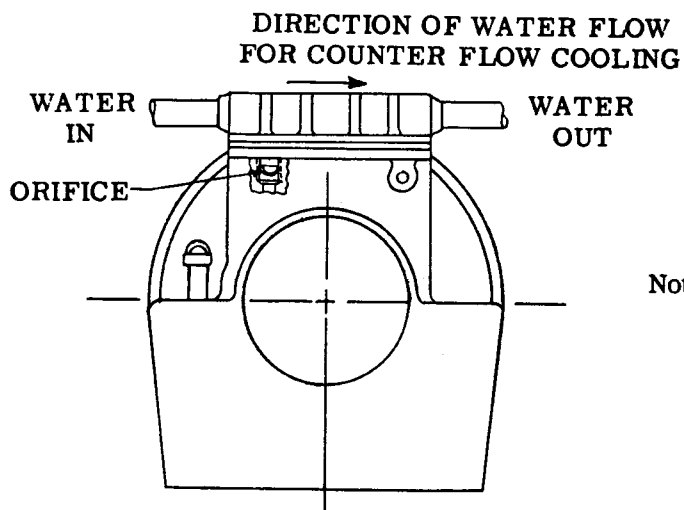
TC 200-300 SERIES CONVERTER
HYDRAULIC CIRCUIT RECOMMENDATIONS

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August 9, 1954
Rev. "A" 1-24-55
Rev. "B" 3-16-55
Rev. "C" 6-17-55

REMOTE HEAT EXCHANGER



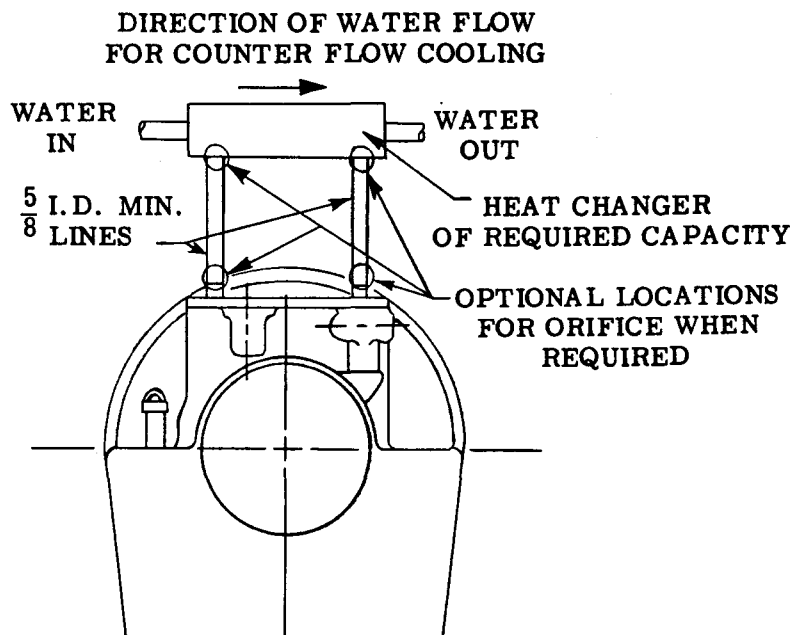
INTEGRAL HEAT EXCHANGER



Note:
Cooler Oil Circuit
Contained in Unit

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REMOTE HEAT EXCHANGER
WITH INTEGRAL
BYPASS VALVE



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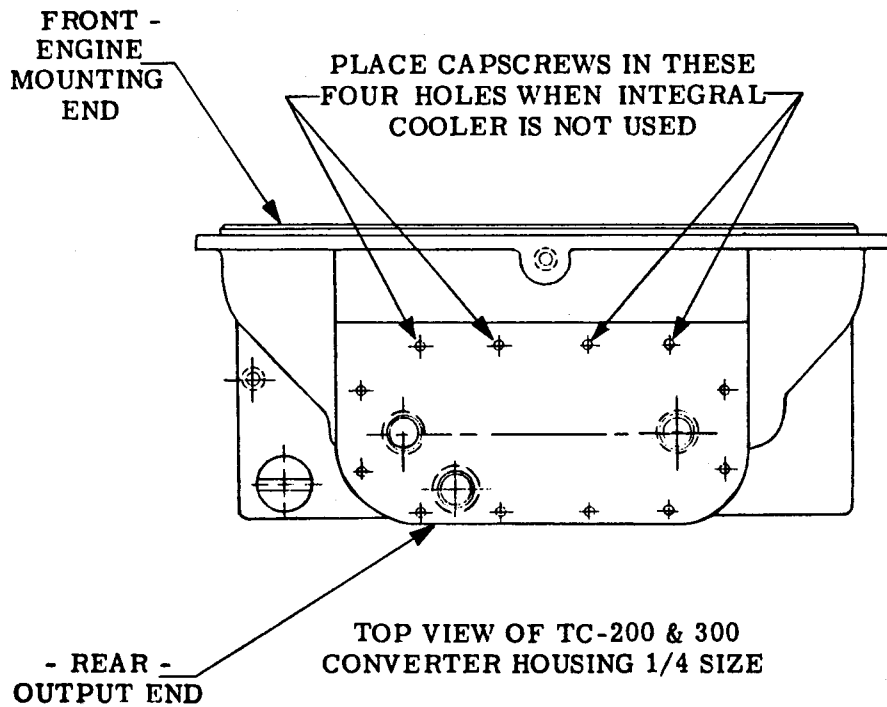
SUBJECT: TORQMATIC CONVERTER - TC-200 & 300 SERIES -
ALL MODELS NOT USING THE INTEGRAL OIL
COOLER - INSTALLING CAP SCREWS IN CONVERTER
HOUSING COOLER MOUNTING HOLES WHEN COOLER
IS NOT USED.

There are twelve (12) drilled and tapped cooler mounting holes located in the cooler mounting pad at the top of the converter housing. The four (4) holes located at the front (engine mounting end) of the cooler mounting pad are through holes into the bell housing of the converter housing. When the integral oil cooler is not used, these four (4) holes (see sketch) are open to the elements and it is possible for rain, dust and debris to work down through the holes and into the converter bell housing.

It is recommended that on all units not using the integral cooler, four (4) 5/16"-18 x 1" UNC bolts be installed in the holes in order to prevent the passage of foreign material into the converter bell housing.

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June 5, 1956

SUBJECT: TORQMATIC CONVERTER - TC-300 SERIES - CONVERTER COVER
CHANGED TO INCORPORATE BALL BEARING P/N 903208 INSTEAD
OF BUSHING P/N 6754922.

In order to provide a better pilot for the turbine assembly, and thereby increase the life of the converter parts, a ball bearing has been added to the converter cover, replacing the bushing. The turbine hub was changed in order to adapt the hub to the new roller bearing. The new roller bearing eliminates the necessity of the turbine thrust washer.

Effective with TC-300 Series Torqmatic Converter Serial No. 13596, the following parts were released or cancelled as noted:

<u>Parts Released</u>	<u>Part Name</u>	<u>Parts Cancelled</u>	<u>Model Used On</u>	<u>Quantity Per Unit</u>
903208	Bearing - Ball		TC-300	1
	Bushing - Conv. Pump Cover	6754922	TC-300	1
	Washer - Turbine Thrust	6755004	TC-300	1
	Cover Assem. - Conv. Pump	6755325*	TC-300	1
6757712*	Cover - Conv. Pump	6755317*	TC-300	1
6758274**	Cover - Conv. Pump	6757255**	TC-300	1
6757713	Turbine Assembly	6755467	TC-300	1

NOTE: Cover assemblies 6755325 and 6757289 which included the bushing 6754922 have been replaced by covers 6757712 and 6758274. The new covers do not include a bushing or bearing, therefore, they are not considered assemblies.

Interchangeability is affected by this change in that new and old part must not be intermixed in a unit. Therefore, a supply of service parts will be maintained on the following parts:

* For engine mounted units only.

** For remote mounted units only.

ALLISON TORQMATIC CONVERTER SERIES 200-300 PARTS CATALOG

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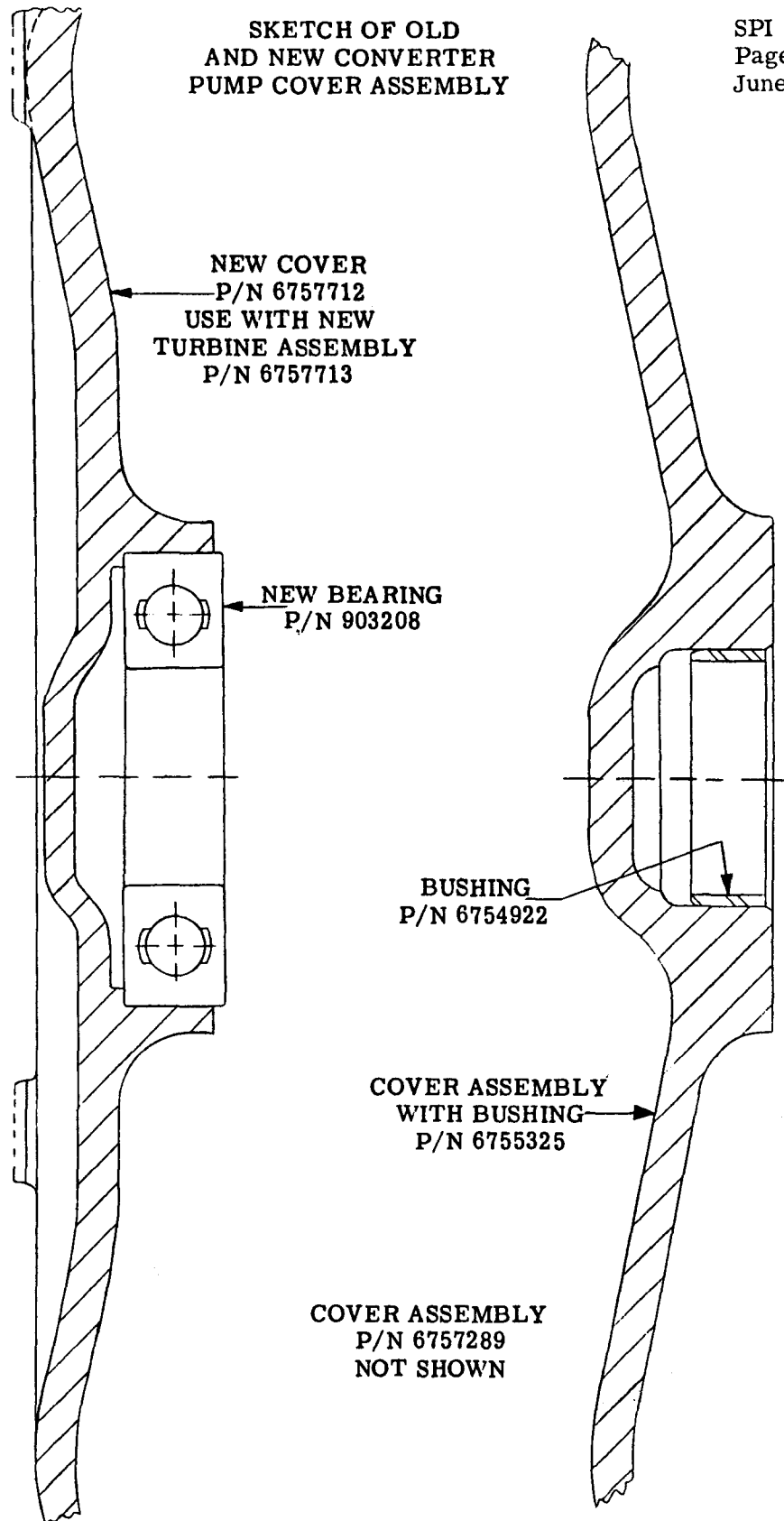
<u>Part No.</u>	<u>Part Name</u>	<u>Model</u>
6754922	Bushing - Conv. Pump Cover	TC-300
6755004	Washer - Turbine Thrust	TC-300
6755325	Cover Assem. - Conv. Pump	TC-300
6755467	Turbine Assembly	TC-300

All spare parts presently in stock should be used.

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SKETCH OF OLD
AND NEW CONVERTER
PUMP COVER ASSEMBLY



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July 5, 1957

SUBJECT: TORQMATIC CONVERTER - TC-200 - ALL MODELS - RELEASE OF
IMPROVED STATOR ASSEMBLY.

As a product improvement, a new stator assembly has been released for the subject models. The primary change in the assembly consists of the addition of convoluted roller springs and the deletion of coiled roller springs.

This change became effective in production with converter S/N 19439.

Parts changes are as follows:

<u>New Part Number</u>	<u>Deleted Part No.</u>	<u>Nomenclature</u>	<u>Quantity Per Unit</u>
6769234	6755271	Stator Assembly	1
3719260	3702099	Cam, Stator	1
3719261	3689751	Spring, Roller	8
None	3691806	Guide	8
3702103	3702100	Washer, Thrust (P/N 3702100 deleted. P/N 3702103 increased from 1 to 2).	2

The new springs should be installed as shown in the attached sketch.

Spare Parts Information:

All superseded parts, in spare parts stock, may be used but should not be used in conjunction with any of the new parts. The complete assemblies P/N 6769234 and P/N 6755271 are interchangeable.

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