

Revisions to the document are noted by a stripe in the left-hand margin.

#2001A
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SUBJECT: Filter Cover Bolt Hole Repair Kit

MODELS AFFECTED: All 3000 and 4000 Product Families Transmission Models

Introduction:

To facilitate the repair of the filter cover bolt threads in the main case a Filter Cover Bolt Hole Repair Kit, J-42385-ALT has been released. The kit can be used for thread repair with any 3000 and 4000 Product Families model. The kit allows the threads to be repaired in or out of chassis. The kit utilizes a solid, thin-walled, self-locking steel bushing insert to repair the filter cover bolt threads in the main housing of the transmission. The thread inserts repair the filter cover bolt threads to their original thread specification of an M10 x 1.5.

The Filter Cover Bolt Hole Repair Kit contains:

- Template J-42385-230 (Main Filter)
- Template J-42385-234 (Lube Filter)
- Two (2) Alignment Pins J-42385-308
- M10 Step Drill J-42385-231
- Tap J-42385-232
- 60 inserts J-42385-514, the kit contains six (6) packets of ten (10) M10 x 1.5 x 24.5
- Insert Driver J-42385-233
- Tap Wrench Part Number 510260
- Six (6) M10 Retaining Bolts Part Number 206158
- Driver Oil J-42385-110

The kit contains 60 inserts and 1 bottle of oil. Additional inserts and oil can be purchased through SPX Kent-Moore.

SPX Corporation (Kent-Moore Service Solutions)
28635 Mound Road
Warren, MI 48092
Phone: 1.800.328.6657
Fax: 1.800.578.7375
www.toolsfortrucks.com

Thread Repair Criteria:

Prior to beginning the field modification procedure, the filter cover bolt holes must be inspected to assure the M10 Step Drill (J-42385-231) can properly prepare the hole for thread cutting with the Tap J-42385-232. If any of the filter cover bolt holes are found oversized the transmission main housing must be replaced. NOTE: The Allison factory installed steel inserts use the same hole and thread size as the Thread Repair Kit inserts; however, the M10 Step Drill J-42385-231 must be used to counter-sink the hole before the Thread Repair Kit inserts are installed.

Field Modification Procedures:

The attached SPX Kent-Moore instruction sheet must be used to facilitate the repair of the filter cover bolt threads in the main case.

DC / SL5350EN
attachment

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