

SIL 20-WT-23
October 16, 2023
Product Code(s): 65
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IMPLEMENTATION DATE: October 3, 2023

SUBJECT: Output Shaft Yoke/Flange Retaining Bolt Torque Specification Increase

MODELS AFFECTED: B3400 R xFE™, B400 R

VOCATIONS AFFECTED: Transit Bus Application

Introduction:

Allison Transmission has observed a potential concern that affects the output shaft yoke/flange retaining bolt P/N 29535219 on B3400 R xFE and B400 R transmissions operating in the Transit Bus Application. This may result in loss of torque on the bolt and a loss of clamp force. As a Customer Satisfaction Initiative, Allison will support increasing the output shaft yoke/flange retaining bolt torque specification to 130 N·m (95 lb ft) for B3400 R xFE and B400 R Series transmissions.

Procedure:

1. Lift bus to access driveline and transmission output bolt, following appropriate safety procedures and guidelines.
2. Disconnect driveline from transmission output yoke.



NOTE: Do not disconnect from the drive axle (differential) end of drive shaft.

3. After disconnecting driveline from transmission output yoke, secure transmission end of drive shaft away from output yoke. U-joint straps and bolts CANNOT be reused and must be discarded, and replaced with new hardware kit.

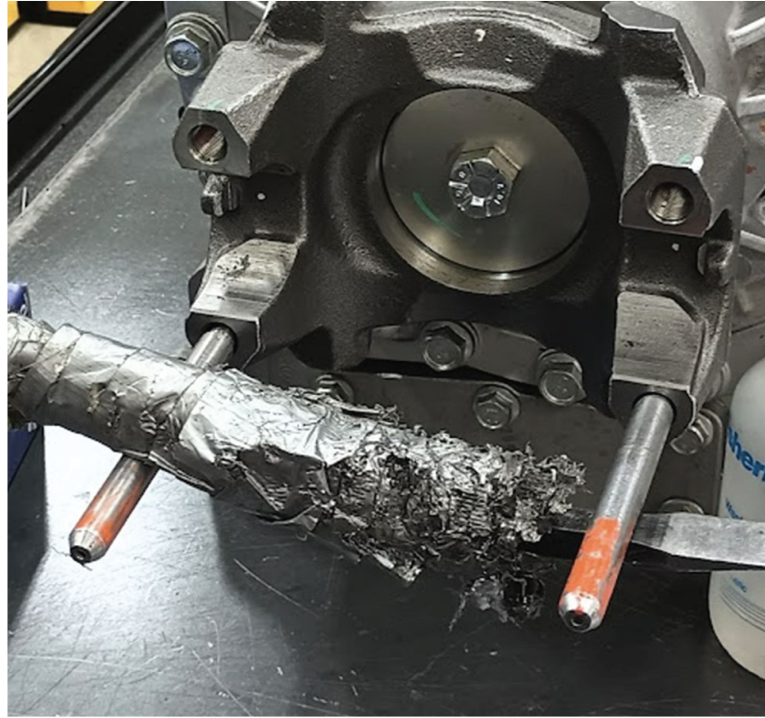
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4. Using a pry bar or yoke holding fixture, secure the yoke so it will not rotate.
 - Make sure not to damage yoke u-joint cavity or other machined surfaces (refer to [Figure 1](#)).



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Figure 1.

5. **Torque output shaft yoke/flange retaining bolt P/N 29535219 to new specification; 130 N·m (95 lb ft).**
6. Clean original paint mark and reapply paint mark to the output retaining plate and output yoke bolt with one continuous mark.

7. Reinstall driveline and secure u-joint to transmission output yoke with new straps and bolts from hardware kit.
- Follow manufacturer's torque procedure and specifications. Refer to [Figure 2](#).
 - Prior to lowering bus from lift, mark transmission nameplate with paint pen to indicate output shaft yoke/flange retaining bolt torque has been verified.

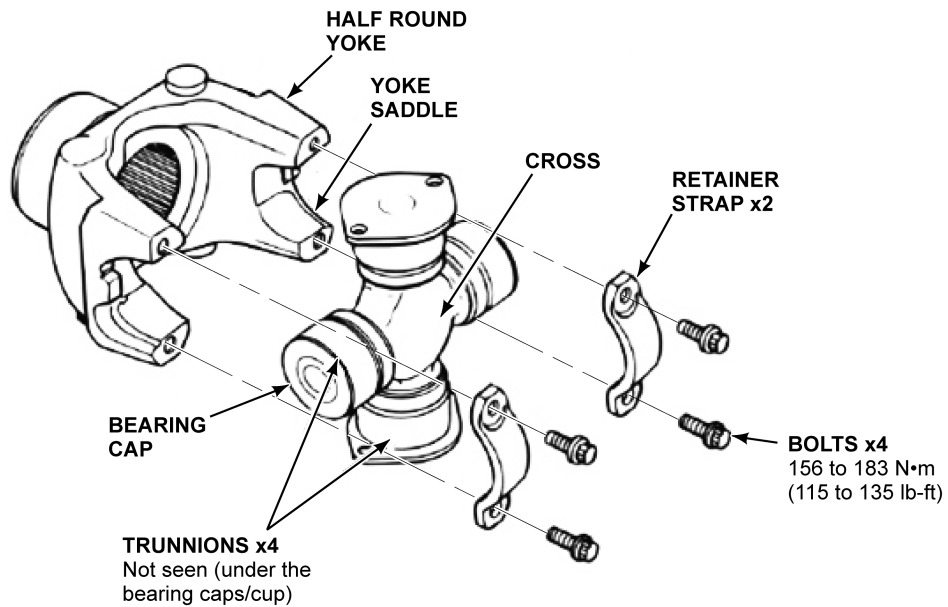


Figure 2.

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