

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

2023FA04, Rev. A
November 02, 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

SERIAL NUMBERS AFFECTED: S/N 6511606790 through S/N 6511984367
Build date range 2019-2023

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.



NOTE: The purpose of this Field Action is to provide proactive action to ensure this bolt is torqued to the proper specification for transit bus applications. Details of how to file claims, applicable labor operations and rates, required replacement parts and affected transmission serial numbers are outlined below. If there are questions concerning this correspondence, please contact your Allison Customer Support Manager.

Claim Submittal Information:

Allison Authorized Service Network must submit work performed under this Field Action using the 4WARD parameters outlined in [Table 1](#) and [Table 2](#).

Table 1. Claim Information

CLAIM TYPE	04
SPECIAL ACTIVITY INDICATOR	2023FA04
FIELD ACTION AUTHORIZATION NUMBER	(Include in claim narrative)

4WARD Claim Narrative must include the Field Action Authorization Number obtained from the Allison HUB™ prior to performing the campaign.

Table 2. Labor Codes/Hours

LABOR OPERATION CODE	LABOR HOURS	LABOR OPERATIONS
00094017	0.8	R & R Driveline
00096905	0.2	2023FA04 Yoke Bolt Torque

Any additional parts, labor or travel costs deemed necessary to complete this Field Action must be described in detail in claim narrative. If not listed, they will be deducted from the claim. Allison Authorized Service Network must follow the published Allison current labor time guide for work performed when adding any additional charges.

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.
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](#)).



Figure 1.

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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.

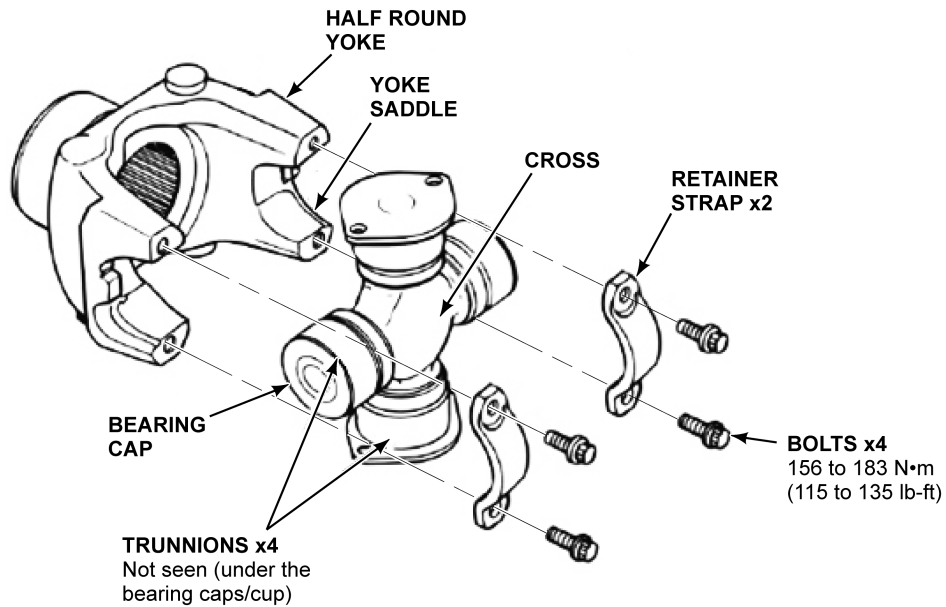


Figure 2.

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